lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

Design Holder

CAGE No. 73197

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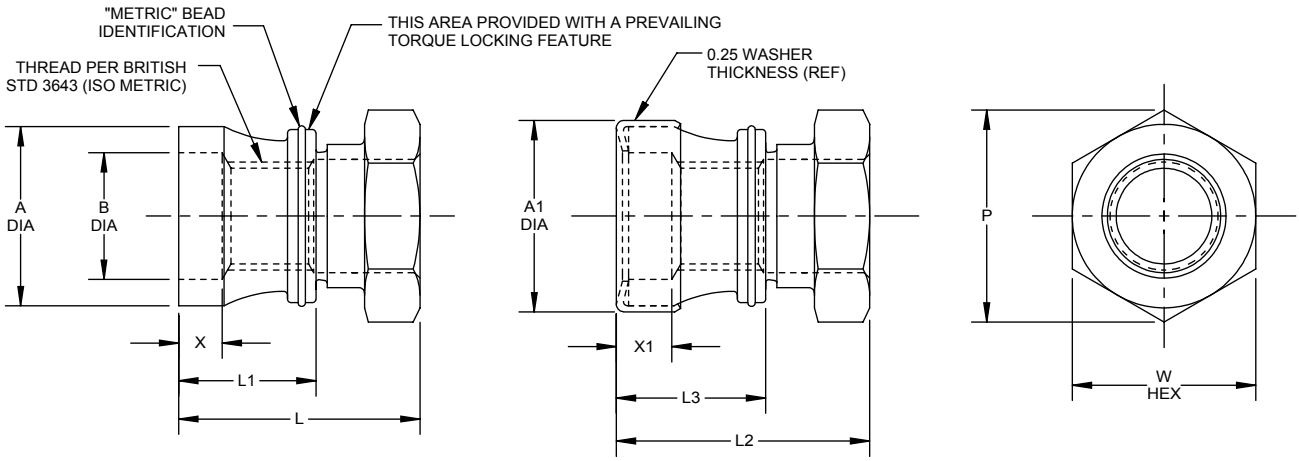

DASH NO. (METRIC)	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	TORQUE-OFF NEWTON - METER	ULT TNSN STR NEWTONS MINIMUM
04	4	M4 x 0.7-4H5H	7.42 7.15	8.1	4.25 4.15	11.75 11.25	7.2	12.0	7.7	8.87	8.00 7.78	2.8	3.3	2.8-4.0	9600
05	5	M5 x 0.8-4H5H	8.25 7.69	8.6	5.25 5.15	11.90 11.40	7.4	12.2	7.9	11.10	10.00 9.78	2.9	3.4	3.9-5.7	12700
06	6	M6 x 1.0-4H5H	10.47 10.30	11.2	6.25 6.15	14.50 14.00	9.2	14.8	9.7	12.12	11.00 10.73	3.3	3.8	9.0-12.5	20700
08	8	M8 x 1.0-4H5H	13.15 13.00	14.0	8.33 8.18	17.00 16.50	11.0	17.5	11.6	14.40	13.00 12.73	3.3	3.9	20.3-26.0	36900
10	10	M10 x 1.0-4H5H	16.50 15.78	16.9	10.30 10.15	19.75 19.25	12.9	20.2	13.6	15.56	14.00 13.73	3.3	4.0	40.6-47.5	62300
12	12	M12 x 1.25-4H5H	21.54 19.60	22.4	12.30 12.15	23.10 22.60	15.3	23.6	16.0	18.90	17.00 16.73	3.9	4.5	67.7-76.3	97800

NOTES:
1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
④ 2. Dimensions are in millimeters and apply after finish.
3. Use HLM378 for oversize replacement.

MATERIAL:
Collar - A-286 high temperature alloy per AMS5731.
Steel Washer - 300 series stainless steel.

FINISH:
Collar - HLM78-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
HLM78G( ) = Silver plate per AMS2410 (.0002 - .0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305.
④ HLM78HK( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

Collar & Washer -
HLM78W( ) = Collar finish same as HLM78-( ), and washer is passivate.
HLM78GW( ) = Collar finish same as HLM78G( ), and washer is passivate.

SPECIFICATION: HI-LOK™ Product Specification M345.

CODE: Dash number indicates nominal thread size in 1 mm.
See Finish note for explanation of code letters.

EXAMPLES:
HLM78-08 = M8 x 1.0 HI-LOK™ collar with solid film lube.
HLM78GW08 = M8 x 1.0 HI-LOK™ collar and washer with silver plate and washer is passivate.

	DATE	BY
DRAWN	1977-01-25	D.P.S.
APPROVED	1977-01-25	R. TING
④ REVISION	2007-07-30	KEVIN TRAN

TITLE
HI-LOK™ COLLAR
(METRIC SERIES)
A-286 HIGH TEMPERATURE ALLOY
1 mm GRIP VARIATION, TENSION APPLICATION

DRAWING NO.
HLM78