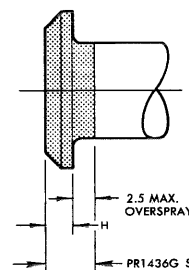
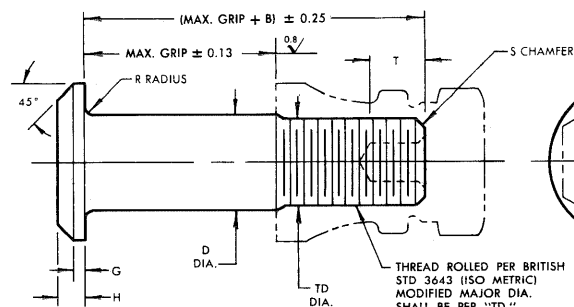


INDENTED HEAD MARKING AS TABULATED, MAXIMUM
DEPTH 0.25, ARRANGEMENT OPTIONAL.
"hs" indicates HI-SHEAR trademark.
"VS" indicates VOI-SHAN trademark.
"SPS" indicates STANDARD PRESSED STEEL trademark.

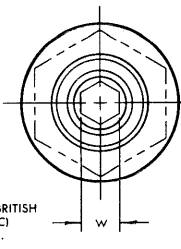


- 2.5 MAX.
OVERSPRAY

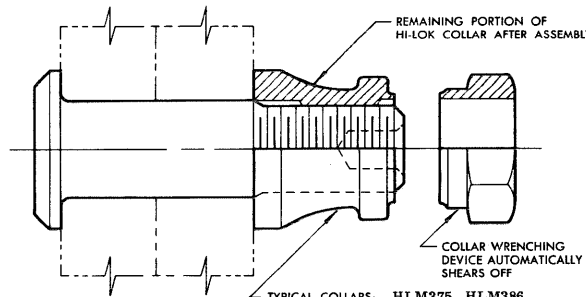
— PR1436G SEALANT
ON BEARING FACE
(FOR CODE "HA" ONLY)



HI-LOK PIN (METRIC)



— THREAD ROLLED PER BRITISH
STD 3643 (ISO METRIC)
MODIFIED MAJOR DIA.
SHALL BE PER "STD"



HI-LOK PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	HEAD MARKING	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	G REF.	H	R RAD.	S CHAMFER REF.	T H RAD. (MODIFIED)	SOCKET		DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTON MINIMUM
					HLM904 OR HLM904FM	HLM904V, HLM904AP OR HLM904HA							W HEX.	T DEPTH		
-04	HLM904M4	4.5	8.65 8.25	9.0	4.490 4.478	4.490 4.465	3.91 3.86	0.9	1.60 1.40	0.65 0.40	0.8 x 37°	M4 x 0.7-4h	1.64 1.61	2.05 1.65	23500	11100
-05	HLM904M5	5.5	10.25 9.75	9.4	5.490 5.478	5.490 5.465	4.90 4.84	1.0	1.90 1.65	0.65 0.40	0.8 x 37°	M5 x 0.8-4h	2.05 2.01	2.55 2.00	35200	17700
-06	HLM904M6	6.5	11.40 10.90	11.7	6.490 6.478	6.490 6.465	5.88 5.81	1.3	2.30 2.05	0.65 0.40	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	49100	25300
-08	HLM904M8 x 1	8.5	13.35 12.75	14.0	8.487 8.472	8.487 8.462	7.88 7.80	1.6	3.05 2.80	0.75 0.50	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	84000	47700
-10	HLM904M10 x 1	10.5	16.70 15.90	16.2	10.487 10.472	10.487 10.462	9.88 9.80	1.9	3.75 3.50	0.75 0.50	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	128100	77200
-12	HLM904M12 x 1.25	12.5	19.30 18.50	19.4	12.484 12.466	12.484 12.459	11.87 11.76	2.3	4.45 4.20	0.75 0.50	1.2 x 37°	M12 x 1.26-4h	4.90 4.81	5.10 4.55	181600	113800

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

- GENERAL NOTES:
1. Concentricity: Head to "D" diameter within 0.25 FIR.
 2. Dimensions to be met after surface coating and before lubrication.
 3. Surface texture per ISO/R468.
 4. Dimensions to be met after finish, for "V", "AP" and "HA" codes only.
 5. Use HLM908 for oversize replacement.

MATERIAL: 6Al-6V-2Sn titanium alloy per Spec. AMS4971.

HEAT TREAT: 740 MPa shear minimum.

FINISH: HLM904-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet (equivalent to LN9368 Blatt 4), and cetyl alcohol lube per Hi-Shear Spec. 305.

HLM904AP-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.

HLM904FM-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet, and M88 solid film lubricant (0.003 mm minimum thickness).

HLM904V-()-() = Solid film lube per "Lubeco" 2123, Type II.

HLM904HA-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and apply precoat No. PR1436G sealant (.051-.127 mm thick) plus cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Product Specification No. M342.

CODE: First dash number indicates nominal diameter in 1 mm which HLM904 oversize pin replaces.
Second dash number indicates maximum grip in 1 mm.
See "Finish" note for explanation of code letters.

HOW TO ORDER

EXAMPLES:

Pin Part Number Only

HLM904-04-8

8 mm Maximum Grip Length

— Replaces 4 mm Nominal Diameter Pin

- Pin Part Number

Pin and Collar Assembly Part Number Combination

HLM904386-04-8

 Size and Grip Length, See Above Example

— Collar Part Number

- Pin Part Number

* Inch standard hex.

* * The Double Shear values shown are based on cross sectional area for nominal diameter pin.

U.S. patents 2,882,773; 2,927,491; 2,940,495; 3,027,789; 3,138,987; design patent 191,883; other U.S. and Foreign patents granted and pending; property of Hi-Shear Corporation. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.

DRAWN	DATE
D. P. S.	5-19-77

hi-Lok® PIN (METRIC SERIES)
PROTRUDING TENSION HEAD
6Al-6V-2Sn TITANIUM
1 mm GRIP VARIATION
0.5 mm OVERSIZE

APPROVED DATE
R. Ling, 5-19-7

DRAWING NUMBER
HLM904

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