



FIRST DASH NO.	HEAD MARKING	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET		** DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					4	6								* W HEX.	* T DEPTH		
-04	HLM905M4	4.5	8.63 8.49	9.0	4.490 4.478	4.490 4.465	3.91 3.86	0.11	1.74 1.68	0.65 0.40	0.25	0.8 x 37°	M4 x 0.7-4h	1.64 1.61	2.05 1.65	23500	11100
-05	HLM905M5	5.5	10.63 10.49	9.4	5.490 5.478	5.490 5.465	4.90 4.84	0.13	2.16 2.10	0.75 0.50	0.38	0.8 x 37°	M5 x 0.8-4h	2.05 2.01	2.55 2.00	35200	17700
-06	HLM905M6	6.5	12.63 12.49	11.7	6.490 6.478	6.490 6.465	5.88 5.81	0.16	2.58 2.52	0.75 0.50	0.38	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	49100	25300
-08	HLM905M8 x 1	8.5	16.63 16.49	14.0	8.487 8.472	8.487 8.462	7.88 7.80	0.18	3.42 3.36	1.00 0.75	0.38	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	84000	47700
-10	HLM905M10 x 1	10.5	20.63 20.49	16.2	10.487 10.472	10.487 10.462	9.88 9.80	0.21	4.26 4.20	1.00 0.75	0.38	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	128100	77200
-12	HLM905M12 x 1.25	12.5	24.63 24.49	19.4	12.484 12.466	12.484 12.459	11.87 11.76	0.23	5.10 5.04	1.25 1.00	0.56	1.2 x 37°	M12 x 1.25-4h	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:
- Head edge out of roundness shall not exceed "F."
 - Concentricity: Conical surface of head to "D" diameter within 0.13 FIR.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after surface coating and before lubrication.
 - Surface texture per ISO/R468.
 - Dimensions to be met after finish, for "V", "AP" and "HA" codes only.
 - Curved or flat edge manufacturer's option.
 - Use HLM909 for oversize replacement.

MATERIAL: 6Al-6V-2Sn titanium alloy per Spec. AMS4971.
HEAT TREAT: 740 MPa shear minimum.

FINISH: HLM905-()-() = 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.
HLM905AP-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM905FM-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet, and M88 solid film lubricant (0.003 mm minimum thickness).
HLM905HA-()-() = 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.
HLM905V-()-() = Solid film lube per "Lubeco" 2123, Type II.
SPECIFICATION: Hi-Lok Product Specification No. M342.

CODE: First dash number indicates nominal diameter in 1 mm which HLM905 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
HLM905-04-8

8 mm Maximum Grip Length
Replaces 4 mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HLM905386-04-8

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 D. P. S.	DATE 5-19-77
APPROVED R. P. S.	DATE 5-19-77
REVISION 2	DATE D. P. S. 12-13-78
hi-Lok® PIN (METRIC SERIES) 100° FLUSH TENSION HEAD 6Al-6V-2Sn TITANIUM 1 mm GRIP VARIATION 0.5 mm OVERSIZE DRAWING NUMBER HLM905	