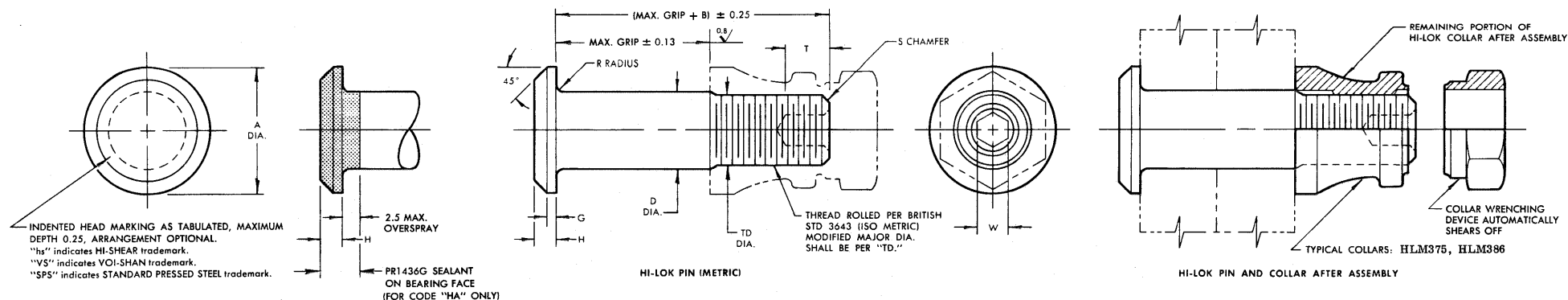


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION (Patent Holder) — Federal Code Ident. No. 73197
VOI-SHAN DIV., VSI CORP. (Licensee) — Federal Code Ident. No. 92215
STANDARD PRESSED STEEL CO. (Licensee) — Federal Code Ident. No. 56878



FIRST DASH NO.	HEAD MARKING	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	G REF.	H	R RAD.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET		** DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					2	4							W HEX.	T DEPTH		
-04	HLM912M5	5														
-05	HLM912M6	6														
-06	HLM908M6	7	11.90 11.40	11.7	6.990 6.978	6.990 6.965	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	56900	25300
-08	HLM908M8 x 1	9	13.85 13.25	14.0	8.987 8.972	8.987 8.962	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	94100	47700
-10	HLM908M10 x 1	11	17.20 16.40	16.2	10.987 10.972	10.987 10.962	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	140600	77200
-12	HLM908M12 x 1.25	13	19.80 19.00	19.4	12.984 12.966	12.984 12.959	11.87 11.76	2.3	4.45 4.20	0.75 0.50	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	5.10 4.55	196400	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.

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

HEAT TREAT: 740 MPa shear minimum.

FINISH: HLM908-()-() = 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.
HLM908AP-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM908FM-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet, and M88 solid film lubricant (0.003 mm minimum thickness).
HLM908V-()-() = Solid film lube per "Lubeco" 2123, Type II.
HLM908HA-()-() = 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 HLM908 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

HLM908-04-8

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

Pin and Collar Assembly Part Number Combination

HLM908386-04-8

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 191,863; 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 5-20-77
APPROVED <i>R. L. S.</i>	DATE 5-20-77
REVISION ②	DATE D. P. S. 12-13-78
hi-lok® PIN (METRIC SERIES) PROTRUDING TENSION HEAD 6Al-6V-2Sn TITANIUM 1 mm GRIP VARIATION — 1 mm OVERSIZE DRAWING NUMBER HLM908	