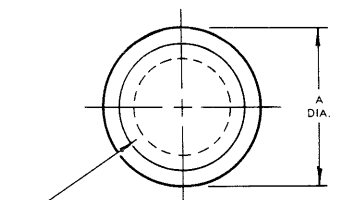


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

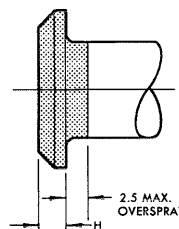
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

① HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197
Division of Hi-Shear Industries Inc.
VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215
SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 56878
LITTON FASTENING SYSTEMS, U.S.A. (Licensee) U.S. Federal Code I.D. No. 97928
Division of Litton Systems, Inc.

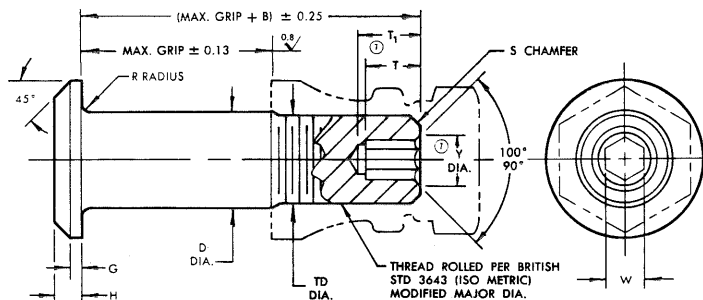
KAMAX-WERKE, Germany (Licensee)
Rudolph Kellerman GmbH & Co.
ST. CHAMOND-GRANAT, S.A. France (Licensee)
TOKYO SCREW COMPANY, Japan (Licensee)



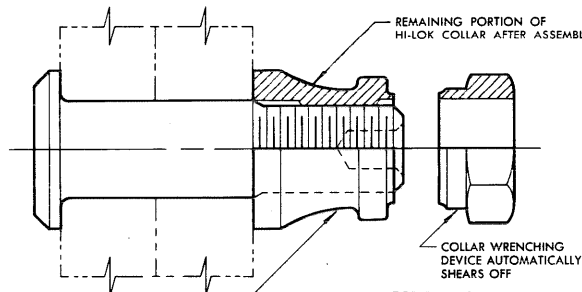
INDENTED HEAD MARKING AS TABULATED, MAXIMUM DEPTH 0.25, ARRANGEMENT OPTIONAL.
"hs" indicates HI-SHEAR trademark.
"VS" indicates VOI-SHAN trademark.
"SPS" indicates STANDARD PRESSED STEEL trademark.



2.5 MAX. OVERSPRAY
PR1436G SEALANT ON BEARING FACE (FOR CODE "HA" ONLY)



HI-LOK PIN (METRIC)



HI-LOK PIN AND COLLAR AFTER ASSEMBLY

①
6

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
					HLM912 OR HLM912FM	HLM912V OR HLM912HA							* W HEX.	T HEX DEPTH MIN.	T ₁ DEPTH MAX.	Y DIA.		
-04	HLM912M4	4	8.15 7.75	8.35	3.990 3.978	3.990 3.965	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	1.80	2.95	2.30 1.90	18600	11100
-05	HLM912M5	5	9.75 9.25	8.65	4.990 4.978	4.990 4.965	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	2.00	3.05	3.05 2.60	29100	17700
-06	HLM912M6	6	10.90 10.40	10.70	5.990 5.978	5.990 5.965	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	2.25	3.40	3.60 3.10	41800	25300
-08	HLM912M8 x 1	8	12.85 12.25	12.95	7.987 7.972	7.987 7.962	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	2.80	4.15	4.60 4.05	74400	47700
-10	HLM912M10 x 1	10	16.20 15.40	15.20	9.987 9.972	9.987 9.962	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	3.80	5.35	5.55 5.00	116200	77200
-12	HLM912M12 x 1.25	12	18.80 18.00	18.15	11.984 11.966	11.984 11.959	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	4.55	6.30	6.45 5.90	167400	113800

* Inch Standard Hex

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 HLM904 for oversize replacement.
① 6. Parts made prior to this revision are OK to use.

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

HEAT TREAT: 740 N/mm² shear minimum.

FINISH: HLM912-()-() = 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.
HLM912AP-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM912FM-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet, and M88 solid film lubricant (0.003 mm minimum thickness).
HLM912HA-()-() = 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.
HLM912V-()-() = Solid film lube per "Lubeco" 2123, Type II.

SPECIFICATION: Hi-Lok Product Specification No. M342.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HLM912-04-8
8 mm Maximum Grip Length
4 mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HLM91286-04-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

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

U.S. patents 2,927,491; 2,940,495; 3,027,789; 3,138,987. Other U.S. and Foreign patents granted and pending. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.	
DRAWN Van	DATE 9-15-71
APPROVED R. E. 9-15-71	DATE 9-15-71
REVISION ①	DATE D.P.S. 5-16-80
hi-Lok® PIN (METRIC SERIES) PROTRUDING TENSION HEAD 6Al-6V-2Sn TITANIUM 1 mm GRIP VARIATION HLM912	

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