lisi AEROSPACE
hi-shear corporation
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HI-SHEAR Corporation, USA
a LISI AEROSPACE Company
Design Holder
CAGE No. 73197

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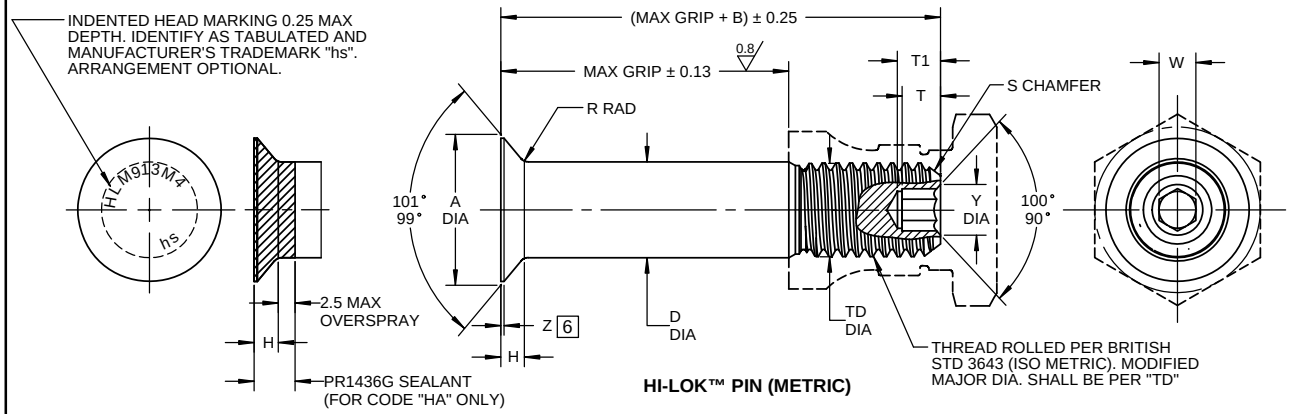
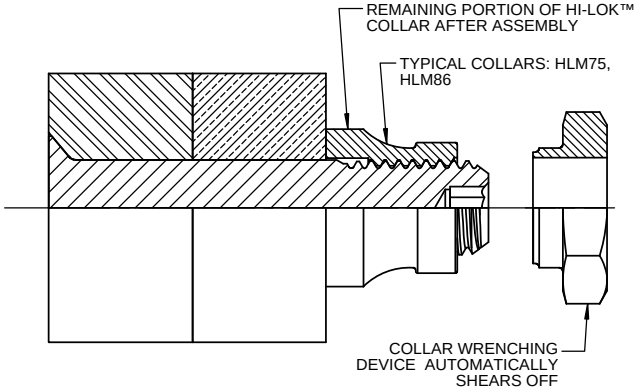


HI-LOK™ PIN (METRIC)



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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FIRST DASH NO.	PIN NOM DIA	HEAD MARKING	A DIA	B REF	D DIA WITHOUT COATING OR SOLID FILM LUBE	D DIA AFTER COATING OR SOLID FILM LUBE	TD DIA	F REF	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH MIN	SOCKET T1 DEPTH MAX	SOCKET Y DIA	DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
04	4	HLM913M4	8.13 7.99	8.35	3.990 3.978	3.990 3.965	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	1.80	2.95	2.30 1.90	18600	11100
05	5	HLM913M5	10.13 9.99	8.65	4.990 4.978	4.990 4.965	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	2.00	3.05	3.05 2.60	29100	17700
06	6	HLM913M6	12.13 11.99	10.70	5.990 5.978	5.990 5.965	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	2.25	3.40	3.60 3.10	41800	25300
08	8	HLM913M8 x 1	16.13 15.99	12.95	7.987 7.972	7.987 7.962	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	2.80	4.15	4.60 4.05	74400	47700
10	10	HLM913M10 x 1	20.13 19.99	15.20	9.987 9.972	9.987 9.962	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	3.80	5.35	5.55 5.00	116200	77200
12	12	HLM913M12 x 1.25	24.13 23.99	18.15	11.984 11.966	11.984 11.959	11.87 11.76	0.23	2.10 5.04	1.25 1.00	0.56	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	4.55	6.30	6.45 5.90	167400	113800

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

GENERAL NOTES:
1 Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within 0.08 FIM.
3. "H" is dimensioned from maximum "D" diameter.
⑨ 4. Dimensions are in millimeters and to be met after finish.
5. Surface texture per ISO/R468.
6 Curved or flat edge manufacturer's option.
7. Use HLM905 for oversize replacement.
8 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: 6AL-6V-2Sn titanium alloy per AMS4971.
HEAT TREAT: 740 N/mm2 shear minimum.
FINISH:
HLM913( )-( ) = 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.
8 HLM913AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM913FM( )-( ) = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet, and M88 solid film lubricant (0.003 mm minimum thickness).
8 HLM913HA( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and apply recoat No. PR1436G sealant (.051-.127 mm thick) plus cetyl alcohol lube per Hi-Shear Spec. 305.
HLM913V( )-( ) = Solid film lube per "Lubeco" 2123, Type II.

SPECIFICATION: HI-LOK™ Product Specification M342.

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.

HOW TO ORDER
⑨ **EXAMPLE:** Pin Part Number
HLM913AP04-8
- 8 mm Maximum Grip Length
- 4 mm Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY	DATE	TITLE
VAN	1971-09-15	HI-LOK™ PIN (METRIC SERIES) 100° FLUSH TENSION HEAD 6AL-6V-2Sn TITANIUM 1 mm GRIP VARIATION
APPROVED	DATE	
R.TING	1971-09-15	
REVISION	DATE	DRAWING NUMBER
⑨	M.BEARD 2017-08-29	**HLM913** 1 OF 1

HLM913