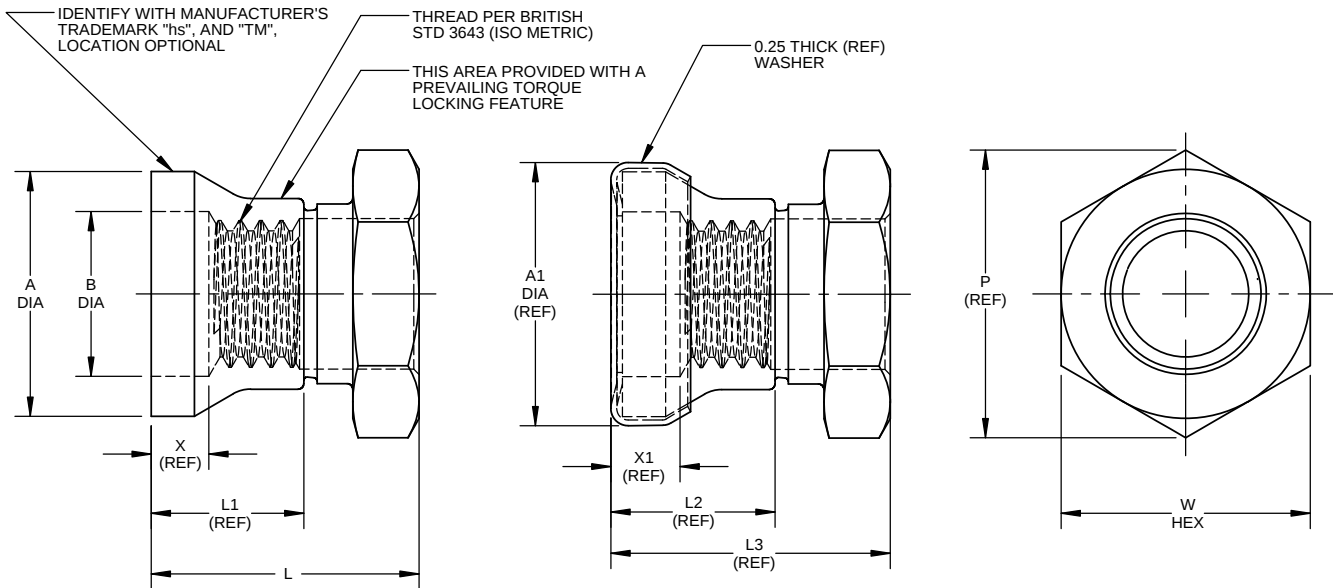


④

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DASH NO. (METRIC)	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	TORQUE-OFF NEWTON-METER	ULT TNSN STR NEWTONS MINIMUM
04	4	M4 x 0.7-4H6H	7.49 7.24	8.2	4.78 4.62	10.16 9.65	5.58	6.1	10.4	8.87	8.00 7.78	1.7	2.2	4.0 2.8	13300
05	5	M5 x 0.8-4H6H	8.24 7.99	9.1	5.78 5.62	10.42 9.90	5.84	6.3	10.7	11.10	10.00 9.78	1.7	2.2	5.7 3.9	17800
06	6	M6 x 1.0-4H5H	10.77 10.52	11.6	6.78 6.62	11.94 11.43	6.60	7.1	12.2	12.12	11.00 10.73	2.3	2.8	12.5 9.0	30200
08	8	M8 x 1.0-4H5H	13.45 13.20	14.6	8.82 8.62	14.23 13.71	8.12	8.7	14.5	14.40	13.00 12.73	2.4	3.0	26.0 20.3	53400
10	10	M10 x 1.0-4H5H	16.63 16.33	17.4	10.88 10.63	16.39 15.87	9.52	10.2	16.8	15.56	14.00 13.73	2.4	3.0	47.5 40.6	86700
12	12	M12 x 1.25-4H5H	21.85 21.55	22.8	12.88 12.63	18.80 18.28	10.92	11.6	19.2	18.90	17.00 16.73	2.5	3.2	76.3 67.7	117900

GENERAL NOTES:

1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
2. Dimensions are in millimeters and apply after finish.
3. Use HSTM373 for oversize replacement

MATERIAL: Collar - 17-4PH stainless steel per AMS5643.
Washer - 300 series stainless steel.

HEAT TREAT: ④ To condition H1025 per AMS-H-6875 (collar only).

FINISH: Collar - HSTM73-() = Silver plate per Spec. AMS2410 (.0050-.0125 thick), dye color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
④ HSTM73DU() = Solid film lube per AS5272.
HSTM73TB() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
HSTM73V() = Solid film lubricant per "Lubeco" 2123, Type II.
④ HSTM73HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

Collar &
Washer - HSTM73W-() = Collar finish same as HSTMJ73-() and washer is passivate.

SPECIFICATION: HI-LITE™ Product Specification M381.

CODE: Dash number indicates nominal thread size in 1 mm.
See "Finish" note for explanation of code letters.

EXAMPLE: HSTM73-08 = M8 x 1.0 HI-LITE™ collar.
HSTM73-W08 = M8 x 1.0 HI-LITE™ collar with washer.

"HI-LITE" AND "HST" ARE INTERNATIONAL
REGISTERED TRADEMARKS OF HI-SHEAR CORPORATION

	DATE	BY	TITLE	DRAWING NO.
DRAWN	1983-12-23	DEPT. 104	HI-LITE™ COLLAR (METRIC SERIES)	HSTM73
APPROVED	1984-01-03	E.E.B.	17-4PH STAINLESS STEEL 1mm GRIP VARIATION, TENSION APPLICATION	1 of 1
④ REVISION	2017-09-18	M.BEARD	FOR USE ON STANDARD AND 0.5 mm OVERSIZE HI-LITE™ PINS	