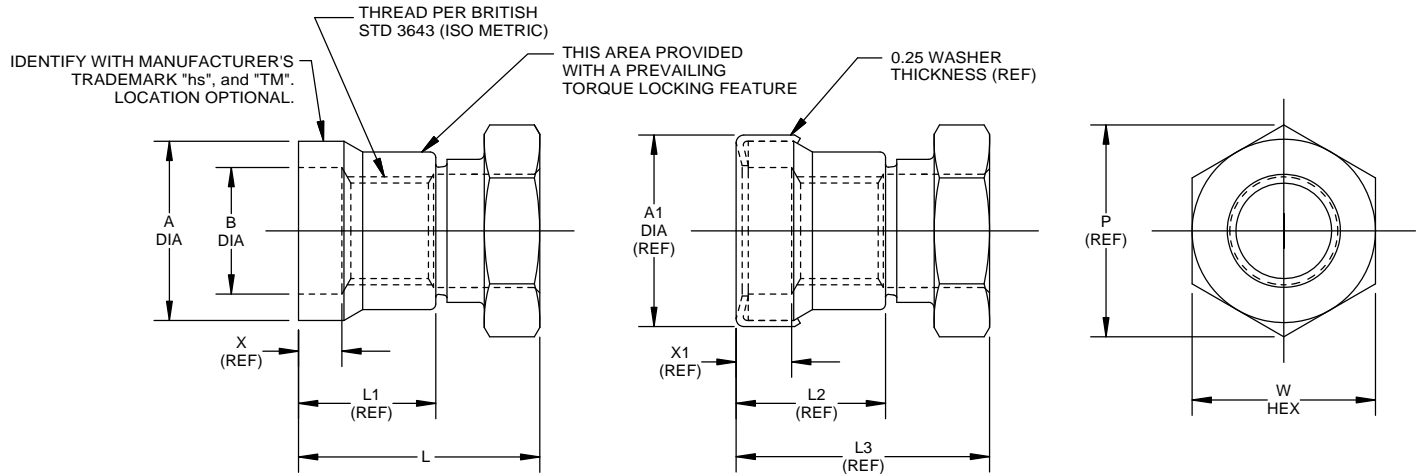


④

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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 - METERS	ULT TNSN STR NEWTONS MINIMUM
04	4	M4 x 0.7-4H5H	7.49 7.24	8.1	4.78 4.62	10.16 9.65	5.58	6.1	10.4	8.87	8.00 7.78	1.7	2.2	1.7 - 2.9	9600
05	5	M5 x 0.8-4H5H	8.24 7.99	8.6	5.78 5.62	10.42 9.90	5.84	6.3	10.7	11.10	10.00 9.78	1.7	2.2	2.8 - 4.6	12700
06	6	M6 x 1.0-4H5H	10.77 10.52	11.2	6.78 6.62	11.94 11.43	6.60	7.1	12.2	12.12	11.00 10.73	2.3	2.8	5.6 - 9.1	20700
08	8	M8 x 1.0-4H5H	13.45 13.20	14.0	8.82 8.62	14.23 13.71	8.12	8.7	14.5	14.40	13.00 12.73	2.4	3.0	14.6 - 18.1	36900

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
  - ④ Dimensions are in millimeters and apply after finish.

**MATERIAL:** Collar - Type 303 Se stainless steel per ASTM A-582 and AMS5640.  
Washer - 300 series stainless steel.

**FINISH:** ④ Collar - HSTM94-( ) = Solid film lube per AS5272.  
HSTM94G-( ) = Silver plate per AMS2410, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HSTM94LP-( ) = Solid film lube per AS5272.  
HSTM94PB-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

④ Collar & Washer - HSTM94W-( ) = Collar finish same as HSTM94-( ) and washer is passivate.  
HSTM94GW-( ) = Collar and washer both with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.  
HSTM94PBW-( ) = Collar finish same as HSTM94PB-( ) and washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and no lube.

**SPECIFICATION:** HI-LITE™ Product Specification M381.

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

**EXAMPLE:** HSTM94-08 = M8 x 1.0 HI-LITE™ collar with solid film lube.  
HSTM94GW-08 = M8 x 1.0 HI-LITE™ collar and washer, both with silver plate and cetyl alcohol lube.

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

			<p>TITLE</p> <p><b>HI-LITE™ COLLAR</b></p> <p>(METRIC SERIES)</p> <p>TYPE 303 Se STAINLESS STEEL</p> <p>1mm GRIP VARIATION, SHEAR APPLICATION</p> <p>FOR USE ON STANDARD AND 0.5 mm OVERSIZE HI-LITE™ PINS</p>	<p>DRAWING NO.</p> <p><b>HSTM94</b></p> <p>1 of 1</p>
	DATE	BY		
DRAWN	1984-02-21	D.P.S.		
APPROVED	1984-02-21	E.E.B.		
④ REVISION	2017-12-19	M.BEARD		