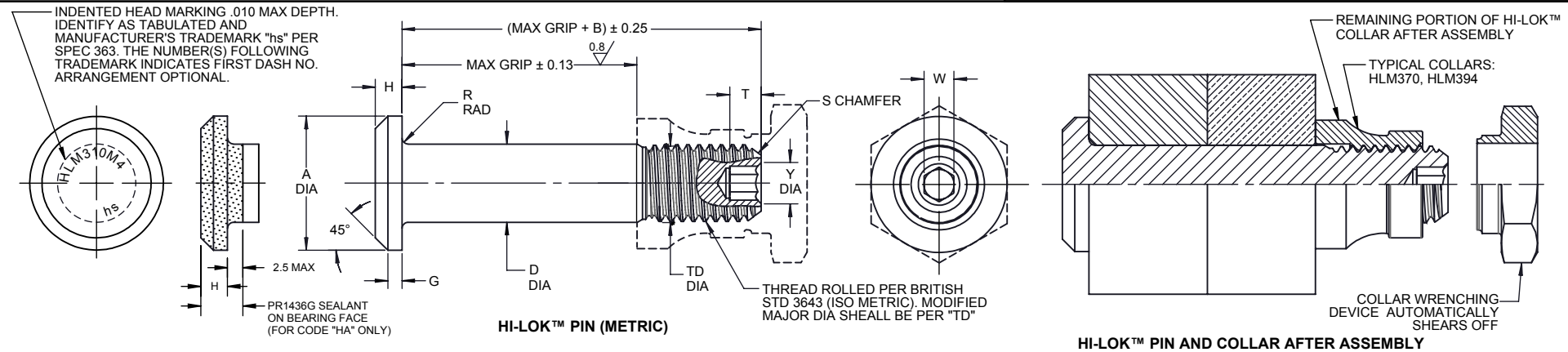




FIRST DASH NO.	MARKING	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					HLM310	HLM310AP AND HLM310HA							W HEX	T DEPTH	Y DIA		
04	HLM310M4	4.5	6.65 6.25	9.0	4.490 4.478	4.490 4.465	3.91 3.86	0.6	1.20 0.95	0.65 0.40	0.8 x 37°	M4 x 0.7-4h	1.64 1.61	2.20 1.80	2.30 1.90	20800	7800
05	HLM310M5	5.5	8.15 7.65	9.4	5.490 5.478	5.490 5.465	4.90 4.84	0.8	1.40 1.15	0.65 0.40	0.8 x 37°	M5 x 0.8-4h	2.05 2.01	2.55 2.00	3.05 2.60	31100	11800
06	HLM310M6	6.5	10.20 9.70	11.7	6.490 6.478	6.490 6.465	5.88 5.81	0.9	1.75 1.50	0.65 0.40	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	3.60 3.10	43500	18200
08	HLM310M8 X 1	8.5	12.85 12.25	14.0	8.487 8.472	8.487 8.462	7.88 7.80	1.0	2.20 1.95	0.75 0.50	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	4.60 4.05	74300	31600
10	HLM310M10 X 1	10.5	16.20 15.40	16.2	10.487 10.472	10.487 10.462	9.88 9.80	1.3	2.65 2.40	0.75 0.50	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	5.55 5.00	113400	48900
12	HLM310M12 X 1.25	12.5	18.80 18.00	19.4	12.484 12.466	12.484 12.459	11.87 11.76	1.5	2.95 2.70	0.75 0.50	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	5.10 4.55	6.45 5.90	160800	66700

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

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within 0.25 FIM.
 - Dimensions are in millimeters and to be met after finish.
 - Surface texture per ISO/R468.
 - Use HLM610 for oversize replacement.
- 5 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 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-4V titanium alloy per AMS4928 or AMS4967.
 6AL-6V-2Sn titanium alloy per AMS4971 is acceptable for -10 and larger sizes.
- HEAT TREAT:** 655 MPa shear minimum.

- FINISH:** ©HLM310-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet (equivalent to LN9368 Blatt 4), plus cetyl alcohol lube per Hi-Shear Spec. 305
- 5 HLM310AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
- © 5 HLM310HA()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, apply precoat No. PR1436G sealant (.051-.127mm thick), plus cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ Product Specification M342.

CODE: First dash number indicates nominal diameter in 1 mm. which HLM310 oversize pin replaces.
 Second dash number indicates maximum grip in 1 mm. See Finish note for explanation of code letters.

**HOW TO ORDER
 EXAMPLE:**

Pin Part Number
HLM310AP04-8

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 D.P.S.	DATE 1975-10-15	TITLE HI-LOK™ PIN (METRIC SERIES) PROTRUDING SHEAR HEAD TITANIUM 1 mm GRIP VARIATION, 0.5 mm OVERSIZE
APPROVED R. TING	DATE 1975-12-15	
REVISION 6	DATE S. KARNO 2018-08-28	DRAWING NUMBER HLM310