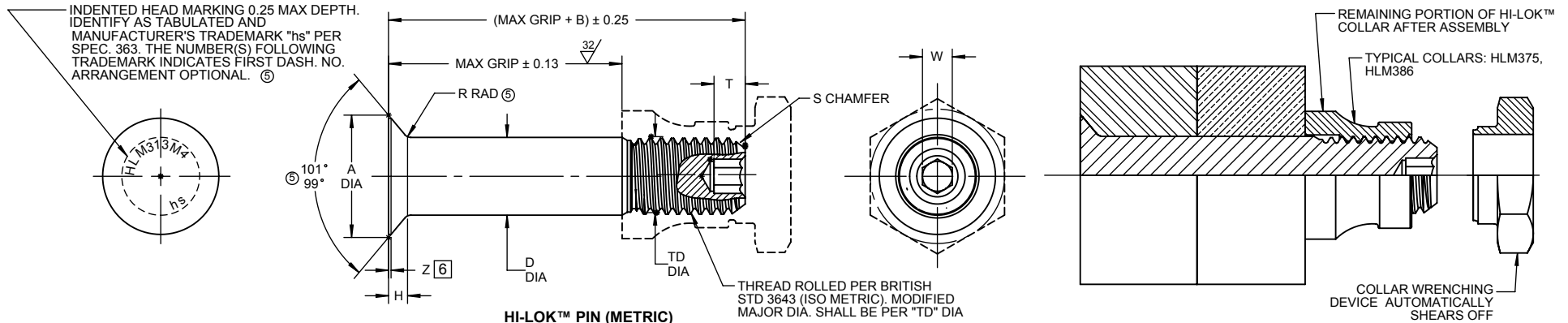




HI-LOK™ PIN (METRIC)

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	HEAD MARKING	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET		DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					WITHOUT COATING OR SOLID FILM LUBE	AFTER COATING OR SOLID FILM LUBE								W HEX	T DEPTH		
04	HLM313M4	4.5	8.63 8.49	9.0	4.490 4.478	4.490 4.465	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	2.20 1.80	20800	9800
05	HLM313M5	5.5	10.63 10.49	9.4	5.490 5.478	5.490 5.465	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	2.55 2.00	31100	15600
06	HLM313M6	6.5	12.63 12.49	11.7	6.490 6.478	6.490 6.465	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	2.80 2.25	43500	22200
08	HLM313M8 x 1	8.5	16.63 16.49	14.0	8.487 8.472	8.487 8.462	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	3.35 2.80	74300	42000
10	HLM313M10 x 1	10.5	20.63 20.49	16.2	10.487 10.472	10.487 10.462	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	4.35 3.80	113400	68000
12	HLM313M12 x 1.25	12.5	24.63 24.49	19.4	12.484 12.466	12.484 12.459	11.87 11.76	0.23	5.10 5.04	1.25 1.00	0.56	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	5.10 4.55	160800	100200

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 .08 FIM.
 3. "H" is dimensioned from maximum "D" diameter.
 4. Surface texture per ISO/R468.
 - ⑤ 5. Dimensions are in millimeters and to be met after finish.
 - ⑥ 6. Curved or flat edge manufacturer's option.
 7. Use HLM613 for oversize replacement.
 - ⑧ 8. 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 for all sizes. 6AL-6V-2Sn titanium alloy per AMS4971 is acceptable for -10 and larger sizes.

HEAT TREAT: 655 MPa shear minimum.

FINISH: HLM313-()-() = 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 HLM313AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.

HLM313AU()-() = Solid film lube per "Electrofilm" XSF-104.

SPECIFICATION: HI-LOK™ Product Specification M342.

CODE: First dash number indicates nominal diameter in 1 mm. Which HLM313 oversize pin replaces. Second dash number indicates maximum grip in 1 mm. See Finish note for explanation of code letters.

HOW TO ORDER

⑤ EXAMPLE:

Pin Part Number

HLM313AP04-8

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 1977-05-17	TITLE HI-LOK™ PIN (METRIC SERIES) 100° FLUSH TENSION HEAD TITANIUM 1 mm GRIP VARIATION 0.5 mm OVERSIZE
APPROVED R.TING	DATE 1977-05-19	
REVISION ⑤	DATE F.CARINGELLA 2017-10-16	DRAWING NUMBER HLM313