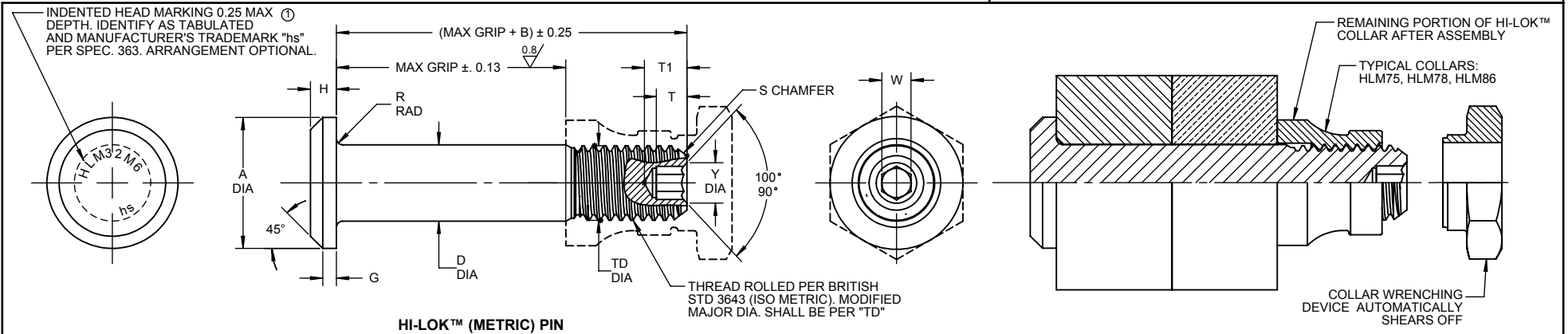




HI-LOK™ (METRIC) PIN

HI-LOK™ (METRIC) PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	HEAD 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
												* W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA		
04	HLM32M4	4	8.15 7.75	8.35	3.990 3.978	3.91 3.86	0.9	1.60 1.40	0.65 0.40	0.8 x 45°	M4 x 0.7-4h	1.64 1.61	1.65	2.95	2.30 1.90	18600	11100
05	HLM32M5	5	9.75 9.25	8.65	4.990 4.978	4.90 4.84	1.0	1.90 1.65	0.65 0.40	0.8 x 45°	M5 x 0.8-4h	2.05 2.01	2.00	3.05	3.05 2.60	29100	17700
06	HLM32M6	6	10.90 10.40	10.70	5.990 5.978	5.88 5.81	1.3	2.30 2.05	0.65 0.40	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.25	3.40	3.60 3.10	41800	25300
08	HLM32M8 X 1	8	12.85 12.25	12.95	7.987 7.972	7.88 7.80	1.6	3.05 2.80	0.75 0.50	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	2.80	4.15	4.60 4.05	74400	47700
10	HLM32M10 X 1	10	16.20 15.40	15.20	9.987 9.972	9.88 9.80	1.9	3.75 3.50	0.75 0.50	1.2 x 45°	M10 x 1.0-4h	4.11 4.02	3.80	5.35	5.55 5.00	116200	77200
12	HLM32M12 X 1.25	12	18.80 18.00	18.15	11.984 11.966	11.87 11.76	2.3	4.45 4.20	0.75 0.50	1.2 x 45°	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

* INCH STANDARD HEX

GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within 0.25 FIR.
① 2. Dimensions are in millimeters and to be met after finish.
3. Surface texture per ISO/R468.

CODE: First dash number indicates nominal diameter in 1 mm.
Second dash number indicates maximum grip in 1 mm.

HOW TO ORDER

① **EXAMPLE:** Pin Part Number
HLM32-04-8

8 mm Maximum Grip Length
4 mm Nominal Diameter Pin
Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HLM3278-04-8

Size and Grip Length - See Above Example
Collar Part Number
Pin Part Number

MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 740 MPa shear minimum.

FINISH: HLM32-()-() = Passivate per Hi-Shear Spec. 258.

SPECIFICATION: HI-LOK™ Product Specification M342.

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			TITLE HI-LOK™ PIN (METRIC SERIES) PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1mm GRIP VARIATION	
DRAWN BY D.P.S.	DATE 1979-10-31		DRAWING NUMBER HLM32	
APPROVED R. TING	DATE 1979-11-01			
REVISION ①	DATE K. TRAN 2017-12-05		1 OF 1	