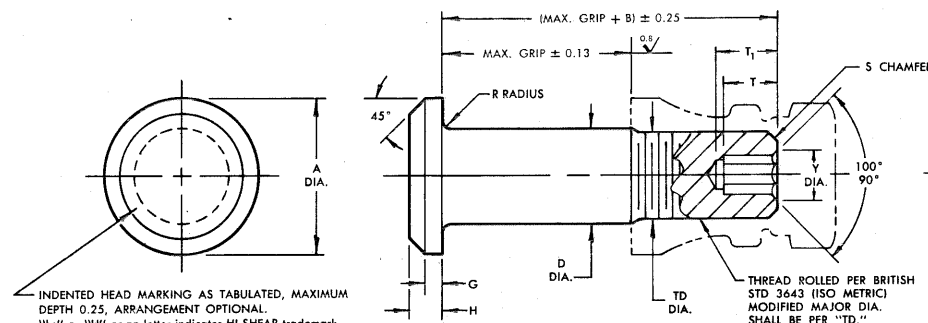


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

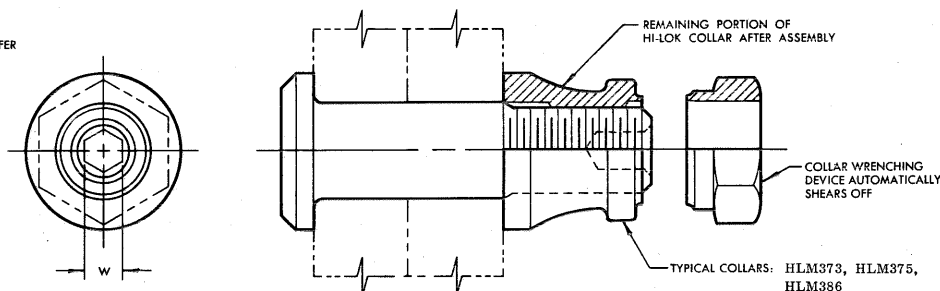
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197
Division of Hi-Shear Industries Inc., U.S.A. (Licensee)
AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)
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TOKYO SCREW COMPANY, Japan (Licensee—Oversize Pins & Steel Collars)
WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins & Steel Collars)
U.S. Federal Code I.D. No. 60516



HI-LOK PIN (METRIC)



HI-LOK PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	HEAD MARKING	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 HEX DEPTH MIN.	T1 DEPTH MAX.	Y DIA.		
-04	HLM320M4	4.5	8.65 8.25	9.0	4.490 4.465	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	1.80	2.95	2.30 1.90	20800	9800
-05	HLM320M5	5.5	10.25 9.75	9.4	5.490 5.465	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	31100	15600
-06	HLM320M6	6.5	11.40 10.90	11.7	6.490 6.465	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	43500	22200
-08	HLM320M8 x 1	8.5	13.35 12.75	14.0	8.487 8.462	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	74300	42000
-10	HLM320M10 x 1	10.5	16.70 15.90	16.2	10.487 10.462	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	113400	68000
-12	HLM320M12 x 1.25	12.5	19.30 18.50	19.4	12.484 12.459	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	160800	100200

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

- GENERAL NOTES:
1. Concentricity: Head to "D" diameter within 0.25 FIR.
 2. Dimensions to be met after finish.
 3. Surface texture per ISO/R468.
 4. Use HLM620 for oversize replacement.

MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626 or MIL-S-6049.

HEAT TREAT: 655 N/mm² shear minimum per Spec. MIL-H-6875.

FINISH: HLM320-()-() = Cadmium plate per Spec. QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM320PB-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Product Specification No. M342.

CODE: First dash number indicates nominal diameter in 1 mm which HLM320 oversize pin replaces.
Second dash number indicates maximum grip in 1 mm. See "Finish" note for explanation of code letters.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HLM320-04-8
— 8 mm Maximum Grip Length
— Replaces 4 mm Nominal Diameter Pin
— Pin Part Number

Pin and Collar Assembly Part Number Combination
HLM320373-04-8
— Size and Grip Length, See Above Example
— Collar Part Number
— Pin Part Number

* Inch standard hex.

** The Double Shear values shown are based on cross sectional area for nominal diameter pin.

U.S. patents 3,390,906; and foreign patents. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.	
DRAWN D. P. S. 6-10-83	DATE 6-10-83
APPROVED R. J. S. 6-14-83	DATE 6-14-83
REVISION	DATE
hi-Lok® PIN (METRIC SERIES) PROTRUDING TENSION HEAD ALLOY STEEL 1 mm GRIP VARIATION 0.5 mm OVERSIZE	
DRAWING NUMBER HLM320	