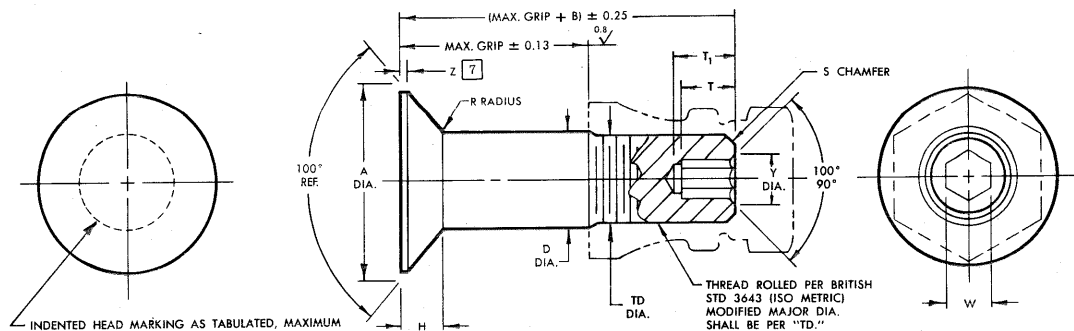
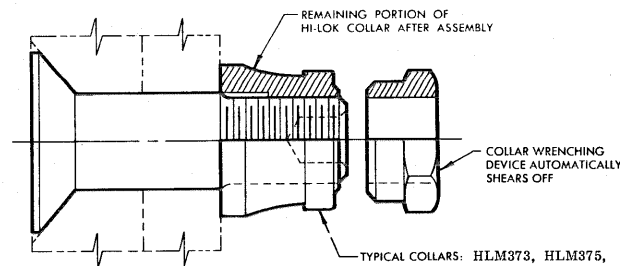




HI-LOK PIN (METRIC)



HI-LOK PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	HEAD MARKING	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	H	R RAD.	Z MAX.	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	HLM321M4	4.5	8.63 8.49	9.0	4.490 4.465	3.91 3.86	0.11	1.74 1.68	0.65 0.40	0.25	0.8 x 45°	M4 x 0.7-4h	1.64 1.61	1.80	2.95	2.30 1.90	20800	9800
-05	HLM321M5	5.5	10.63 10.49	9.4	5.490 5.465	4.90 4.84	0.13	2.16 2.10	0.75 0.50	0.38	0.8 x 45°	M5 x 0.8-4h	2.05 2.01	2.00	3.05	3.05 2.60	31100	15600
-06	HLM321M6	6.5	12.63 12.49	11.7	6.490 6.465	5.88 5.81	0.16	2.58 2.52	0.75 0.50	0.38	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.25	3.40	3.60 3.10	43500	22200
-08	HLM321M8 x 1	8.5	16.63 16.49	14.0	8.487 8.462	7.88 7.80	0.18	3.42 3.36	1.00 0.75	0.38	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	2.80	4.15	4.60 4.05	74300	42000
-10	HLM321M10 x 1	10.5	20.63 20.49	16.2	10.487 10.462	9.88 9.80	0.21	4.26 4.20	1.00 0.75	0.38	1.2 x 45°	M10 x 1.0-4h	4.11 4.02	3.80	5.35	5.55 5.00	113400	68000
-12	HLM321M12 x 1.25	12.5	24.63 24.49	19.4	12.484 12.459	11.87 11.76	0.23	5.10 5.04	1.25 1.00	0.56	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. Head edge out of roundness shall not exceed "F."
2. Concentricity: Conical surface of head to "D" diameter within 0.13 FIR.
3. "H" is dimensioned from maximum "D" diameter.
4. Dimensions to be met after finish.
5. Surface texture per ISO/R468.
6. Use HLM621 for oversize replacement.
7. Curved or flat edge manufacturer's option.

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: HLM321-()-() = Cadmium plate per Spec. QQ-P-416, Type I, Class 2,
and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM321PB-()-() = 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 HLM321 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
HLM321-04-8

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

Pin and Collar Assembly Part Number Combination
HLM321373-04-8

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.	DATE 6-10-83	hi-lok® PIN (METRIC SERIES) 100° FLUSH TENSION HEAD ALLOY STEEL 1 mm GRIP VARIATION 0.5 mm OVERSIZE E
APPROVED R.P.P.	DATE 6-14-83	
REVISION	DATE	DRAWING NUMBER HLM321

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