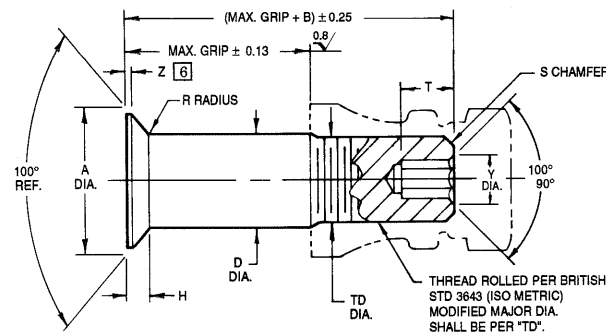
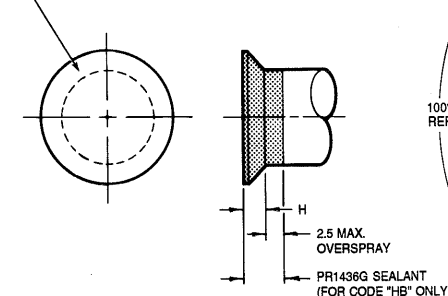


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

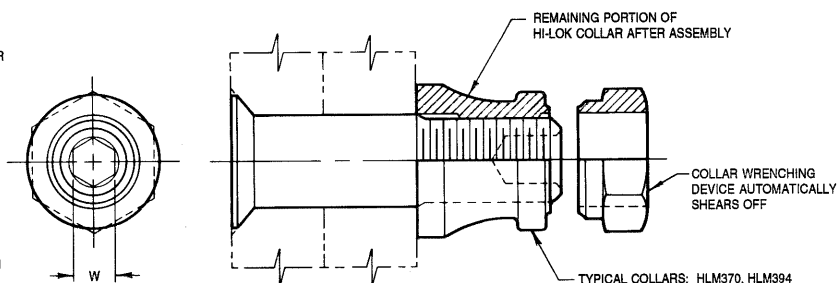
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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WEST COAST AEROSPACE INC., U.S.A. (Licensee)	U.S. Federal Code No. 60516	Collars
	Pins & Steel Collars	TOKYO SCREW COMPANY, Japan (Licensee - Japan)

INDENTED HEAD MARKING AS TABULATED.
MAXIMUM DEPTH 0.25, ARRANGEMENT OPTIONAL.
"hs" indicates HI-SHEAR trademark.



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
					HLM335	HLM335TB AND HLM335HB								# W HEX.	T DEPTH		
-04	HLM335M4	4.5	6.99 6.85	9.0	4.490 4.478	4.490 4.465	3.91 3.86	0.11	1.05 0.99	0.65 0.40	0.25	0.8 x 45°	M4 x 0.7-4h	1.64 1.61	2.20 1.80	27300	8200
-05	HLM335M5	5.5	8.35 8.21	9.4	5.490 5.478	5.490 5.465	4.90 4.84	0.13	1.20 1.14	0.75 0.50	0.38	0.8 x 45°	M5 x 0.8-4h	2.05 2.01	2.55 2.00	40800	12200
-06	HLM335M6	6.5	10.18 10.04	11.7	6.490 6.478	6.490 6.465	5.88 5.81	0.16	1.55 1.49	0.75 0.50	0.38	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	56900	19300
-08	HLM335M8x1	8.5	13.23 13.09	14.0	8.487 8.472	8.487 8.462	7.88 7.80	0.18	1.99 1.93	1.00 0.75	0.38	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	97300	32000
-10	HLM335M10x1	10.5	16.18 16.04	16.2	10.487 10.472	10.487 10.462	9.88 9.80	0.21	2.39 2.33	1.00 0.75	0.38	1.2 x 45°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	148600	49600
-12	HLM335M12x1.25	12.5	18.92 18.78	19.4	12.484 12.466	12.484 12.459	11.87 11.76	0.23	2.70 2.64	1.25 1.00	0.56	1.2 x 45°	M12 x 1.25-4h	4.90 4.81	5.10 4.55	210600	68300

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

* Inch standard hex.

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within 0.08 FIR.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ISO/R468
 - Curved or flat edge manufacturer's option.

MATERIAL: PH13-8Mo stainless steel per Spec. AMS5629.

HEAT TREAT: 860 MPa shear minimum.

FINISH: HLM335-(-)(-) = Passivate per Hi-Shear Spec. 262,
and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM335TB-(-)(-) = Hi-Kote 2nd solid film lube per Hi-Shear Spec. 292,
and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM335HB-(-)(-) = Hi-Kote 2nd solid film lube per Hi-Shear Spec. 292
and apply precoat No. PR1436G sealant (.051-.127 mm
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 of the pin which HLM335 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
HLM335-04-8
8 mm Maximum Grip Length
replaces 4 mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HLM335370-04-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

"Hi-Lok" and "HL" are internationally
registered trademarks of Hi-Shear Corporation

DRAWN	DATE	TITLE
T.Craigne	10-26-92	HI-LOK® PIN (Metric Series)
APPROVED	DATE	100° FLUSH SHEAR HEAD
A.BROWN	10-27-92	PH13-8Mo STAINLESS STEEL
REVISION	DATE	1mm GRIP VARIATION 0.5MM OVERSIZE
		DRAWING NUMBER
		HLM335

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