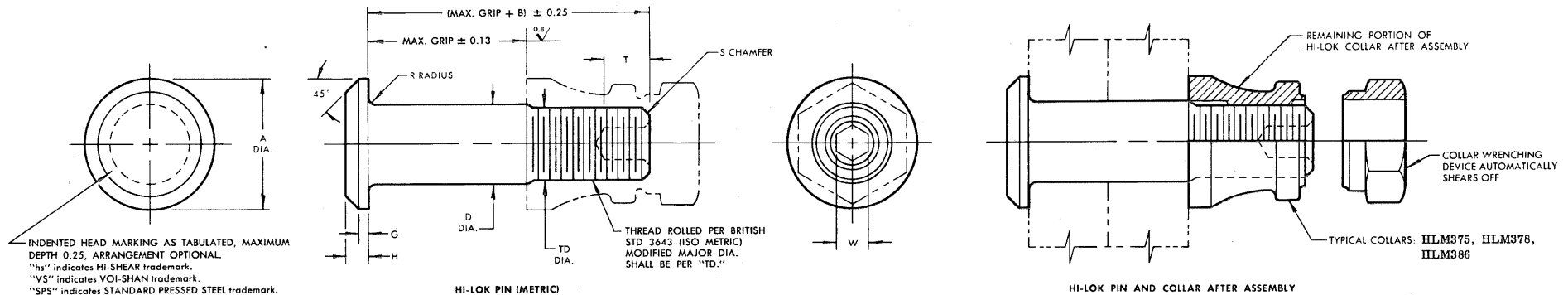


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION (Patent Holder) — Federal Code Ident. No. 73197
VOI-SHAN DIV., VSI CORP. (Licensee) — Federal Code Ident. No. 92215
STANDARD PRESSED STEEL CO. (Licensee) — Federal Code Ident. No. 56878



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
					HLM348	HLM348TF							W * HEX.	T DEPTH		
-04	HLM348M4	4.5	8.65 8.25	9.0	4.490 4.478	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	2.05 1.65	20800	9800
-05	HLM348M5	5.5	10.25 9.75	9.4	5.490 5.478	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	2.55 2.00	31100	15600
-06	HLM348M6	6.5	11.40 10.90	11.7	6.490 6.478	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	2.80 2.25	43500	22200
-08	HLM348M8 x 1	8.5	13.35 12.75	14.0	8.487 8.472	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	3.35 2.80	74300	42000
-10	HLM348M10 x 1	10.5	16.70 15.90	16.2	10.487 10.472	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	4.35 3.80	113400	68000
-12	HLM348M12 x 1.25	12.5	19.30 18.50	19.4	12.484 12.466	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	5.10 4.55	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.
① 3. Surface texture per ISO/R468.

CODE: First dash number indicates nominal diameter in 1 mm
which HLM348 oversize pin replaces.
Second dash number indicates maximum grip in 1 mm.
See "Finish" note for explanation of code letters.

MATERIAL: A-286 high temperature alloy per Spec. AMS5737 or AMS5731.

HOW TO ORDER
EXAMPLES:

HEAT TREAT: 655 N/mm² shear minimum at room temperature.

FINISH: HLM348-()-() = Passivate per Hi-Shear Spec. 258 and cetyl
alcohol lube per Hi-Shear Spec. 305.
HLM348TF-()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.

SPECIFICATION: Hi-Lok Product Specification No. M342.

Pin Part Number Only

HLM348-04-8

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

Pin and Collar Assembly Part Number Combination

HLM348375-04-8

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 2,882,773; 2,927,491; 2,940,495; 3,027,789; 3,138,987; design patent 191,883; other U.S. and Foreign patents granted and pending; property of Hi-Shear Corporation. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.		hi-Lok® PIN (METRIC SERIES) PROTRUDING TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1 mm GRIP VARIATION 0.5 mm OVERSIZE	
DRAWN D. P. S.	DATE 8-8-77	APPROVED <i>[Signature]</i>	DATE 8-9-77
REVISION ①	DATE D. P. S. 12-13-78	DRAWING NUMBER HLM348	