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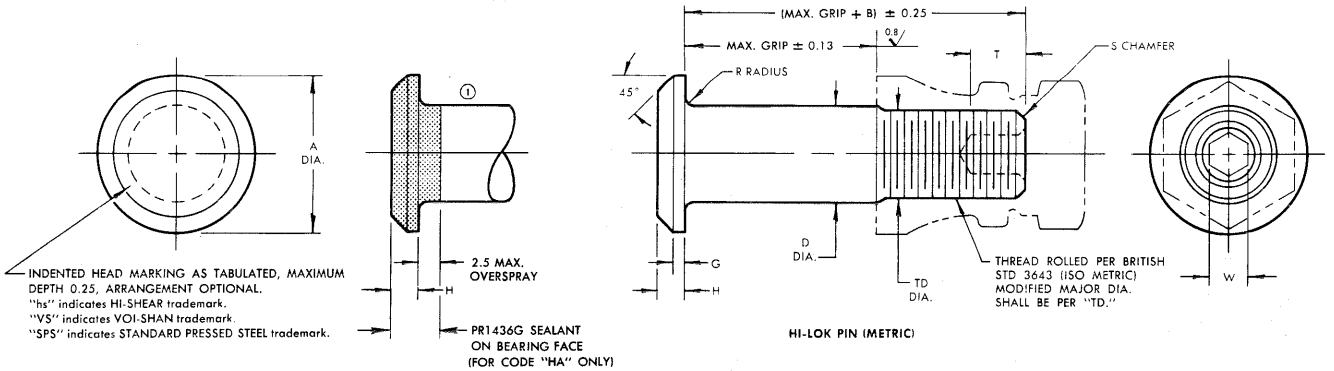
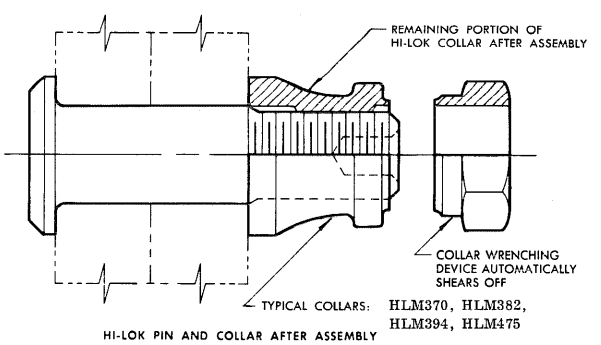
STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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



HI-LOK PIN (METRIC)



HI-LOK PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	HEAD MARKING	NOM. DIA.	A DIA.	B REF.	D DIA. [2] [4] HLM902 OR HLM902FM	D DIA. [2] [4] HLM902AP OR (1) HLM902HA	TD DIA.	G REF.	H	R RAD.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET W* HEX.	SOCKET T DEPTH	** DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
-04	HLM902M4	4.5	6.65 6.25	9.0	4.490 4.478	4.490 4.465	3.91 3.86	0.6	1.20 0.95	0.65 0.40	0.8 x 37°	M4 x 0.7-4h	1.64 1.61	2.05 1.65	23500	8700
-05	HLM902M5	5.5	8.15 7.65	9.4	5.490 5.478	5.490 5.465	4.90 4.84	0.8	1.40 1.15	0.65 0.40	0.8 x 37°	M5 x 0.8-4h	2.05 2.01	2.55 2.00	35200	13100
-06	HLM902M6	6.5	10.20 9.70	11.7	6.490 6.478	6.490 6.465	5.88 5.81	0.9	1.75 1.50	0.65 0.40	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	49100	20500
-08	HLM902M8 x 1	8.5	12.85 12.25	14.0	8.487 8.472	8.487 8.462	7.88 7.80	1.0	2.20 1.95	0.75 0.50	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	84000	35800
-10	HLM902M10 x 1	10.5	16.20 15.40	16.2	10.487 10.472	10.487 10.462	9.88 9.80	1.3	2.65 2.40	0.75 0.50	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	128100	55400
-12	HLM902M12 x 1.25	12.5	18.80 18.00	19.4	12.484 12.466	12.484 12.459	11.87 11.76	1.5	2.95 2.70	0.75 0.50	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	5.10 4.55	181600	73400

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 surface coating and before lubrication.
3. Surface texture per ISO/DR221.
(1) 4. Dimensions to be met after finish for "AP" and "HA" codes only.
5. Use HLM906 for oversize replacement.

MATERIAL: 6Al-6V-2Sn titanium alloy per Spec. AMS4971.

HEAT TREAT: 740 MPa shear minimum.

FINISH:
HLM902-( )-( ) = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet (equivalent to LN9368 Blatt 4), and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM902AP-( )-( ) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM902FM-( )-( ) = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet, and M88 solid film lubricant (0.003 mm minimum thickness).
(1) HLM902HA-( )-( ) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and apply precoat No. PR1436G sealant (.051-.127 mm thick) plus 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 HLM902 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
HLM902-04-8
- 8 mm Maximum Grip Length
- Replaces 4 mm Nominal Diameter Pin
- Pin Part Number

Pin and Collar Assembly Part Number Combination
HLM902370-04-8
- 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.

DRAWN	DATE	hi-lok® PIN (METRIC SERIES)
D.P.S.	5-19-77	PROTRUDING SHEAR HEAD 6Al-6V-2Sn TITANIUM 1 mm GRIP VARIATION 0.5 mm OVERSIZE
APPROVED	DATE	
R. Lange	5-19-77	
REVISION	DATE	DRAWING NUMBER
1	D.P.S. 11-4-77	HLM902

HLM902

2-1501

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