



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
					1 HLM903 OR HLM903FM	6 HLM903AP OR HLM903HA								W * HEX.	T DEPTH		
-04	HLM903M4	4.5	6.99 6.85	9.0	1.490 4.478	1.490 4.465	3.91 3.86	0.11	1.05 0.99	0.65 0.40	0.25	0.8 x 37°	M4 x 0.7-4h	1.64 1.61	2.05 1.65	23500	7100
-05	HLM903M5	5.5	8.35 8.21	9.4	5.490 5.478	5.490 5.465	1.90 4.84	0.13	1.20 1.14	0.75 0.50	0.38	0.8 x 37°	M5 x 0.8-4h	2.05 2.01	2.55 2.00	35200	10700
-06	HLM903M6	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 37°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	49100	16700
-08	HLM903M8 x 1	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 37°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	84000	28900
-10	HLM903M10 x 1	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 37°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	128100	44500
-12	HLM903M12 x 1.25	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 37°	M12 x 1.25-4h	4.90 4.81	5.10 4.55	181600	66700

- GENERAL NOTES:
- Head edge out of roundness shall not exceed "F."
 - Concentricity: Conical surface of head to "D" diameter within 0.13 FIR.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after surface coating and before lubrication.
 - Surface texture per ISO/DR221.
 - Dimensions to be met after finish, for "AP" and "HA" codes only.
 - Curved or flat edge manufacturer's option.
 - Use HLM907 for oversize replacement.

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

HEAT TREAT: 740 MPa shear minimum.

FINISH: HLM903-()-() = 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.

HLM903AP-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.

HLM903FM-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet, and M88 solid film lubricant (0.003 mm minimum thickness).

HLM903HA-()-() = 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 HLM903 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

HLM903-04-8

8 mm Maximum Grip Length

Replaces 4 mm Nominal Diameter Pin

Pin Part Number

Pin and Collar Assembly Part Number Combination

HLM903370-04-8

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 D.P.S.	DATE 5-19-77	hi-Lok[®] PIN (METRIC SERIES) 100° FLUSH SHEAR HEAD 6Al-6V-2Sn TITANIUM 1 mm GRIP VARIATION 0.5 mm OVERSIZE
APPROVED R. J. J. 5-19-77	DATE 5-19-77	
REVISION 1	DATE D.P.S. 11-4-77	DRAWING NUMBER HLM903