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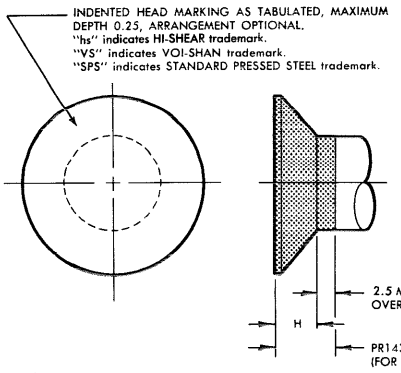
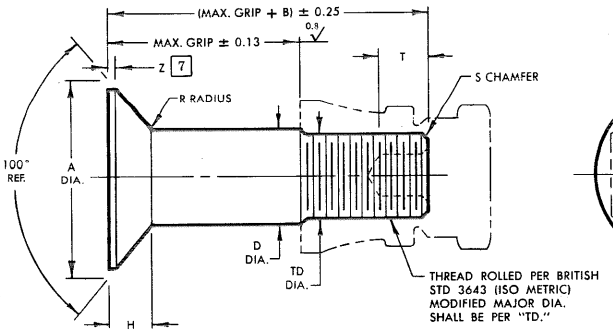
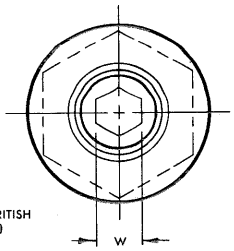
STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

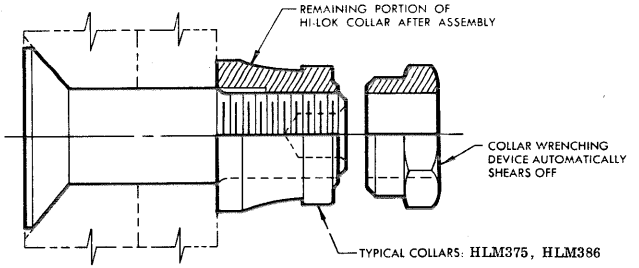
HI-SHEAR CORPORATION (Patent Holder) — Federal Code Ident. No. 73197
VOI-SHAN DIV., VSI CORP. (Licensee) — Federal Code Ident. No. 92215
STANDARD PRESSED STEEL CO. (Licensee) — Federal Code Ident. No. 56878





HI-LOK PIN (METRIC)





HI-LOK PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	HEAD MARKING	NOM. DIA.	A DIA.	B REF.	D DIA. [4] HLM909 OR HLM909FM	D DIA. [4] [6] HLM909V, HLM909AP OR HLM909HA	TD DIA. [1]	F [1]	H	R RAD.	Z MAX. [7]	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET W* HEX.	SOCKET T DEPTH	** DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
-04	HLM913M5	5				NOTE: Use HLM913-05 (See HLM913 Sales Drawing for Collar Selection)											
-05	HLM913M6	6				NOTE: Use HLM913-06 (See HLM913 Sales Drawing for Collar Selection)											
-06	HLM909M6	7	13.13 12.99	11.7	6.990 6.978	6.990 6.965	5.88 5.81	0.16	2.58 2.52	0.75 0.50	0.38	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	56900	25300
-08	HLM909M8 x 1	9	17.13 16.99	14.0	8.987 8.972	8.987 8.962	7.88 7.80	0.18	3.42 3.36	1.00 0.75	0.38	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	94100	47700
-10	HLM909M10 x 1	11	21.13 20.99	16.2	10.987 10.972	10.987 10.962	9.88 9.80	0.21	4.26 4.20	1.00 0.75	0.38	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	140600	77200
-12	HLM909M12 x 1.25	13	25.13 24.99	19.4	12.984 12.966	12.984 12.959	②11.87 11.76	0.23	5.10 5.04	1.25 1.00	0.56	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	5.10 4.55	196400	113800

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 surface coating and before lubrication.
② 5. Surface texture per ISO/R468.
6. Dimensions to be met after finish, for "V", "AP" and "HA" codes only.
7. Curved or flat edge manufacturer's option.

MATERIAL: 6Al-6V-2Sn titanium alloy per Spec. AMS4971.
HEAT TREAT: 740 MPa shear minimum.
FINISH:
HLM909-( )-( ) = 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.
HLM909AP-( )-( ) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM909FM-( )-( ) = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet, and M88 solid film lubricant (0.003 mm minimum thickness).
HLM909HA-( )-( ) = 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.
HLM909V-( )-( ) = Solid film lube per "Lubeco" 2123, Type II.
SPECIFICATION: Hi-Lok Product Specification No. M342.

CODE: First dash number indicates nominal diameter in 1 mm which HLM909 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
HLM909-04-8
- 8 mm Maximum Grip Length
- Replaces 4 mm Nominal Diameter Pin
- Pin Part Number

Pin and Collar Assembly Part Number Combination
HLM909386-04-8
- 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.	5-20-77	100° FLUSH TENSION HEAD
APPROVED	DATE	6Al-6V-2Sn TITANIUM
E. Ring	5-20-77	1 mm GRIP VARIATION — 1 mm OVERSIZE
REVISION ②	DATE D. P. S. 12-13-78	DRAWING NUMBER HLM909

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HLM909

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