

[illegible]

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.
4. Dimensions to be met after finish for "AP" and "HA" codes only.
5. Use HLM902 for oversize replacement.

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

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

HEAT TREAT: 740 N/mm² shear minimum.

FINISH: HLM910(-)(-) = 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.

HLM910AP(-)(-) = Hi-Kote 1 aluminum coating per HI-Shear Spec. 294 and cetyl alcohol lube per HI-Shear Spec. 305.

HLM910FM(-)(-) = Surface coating per HI-Shear Spec. 306, Type I, color blue-violet, and M88 solid film lubricant (0.003 mm minimum thickness).

① HLM910HA(-)(-) = 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.

HOW TO ORDER
EXAMPLES:

Pin Part Number Only
HLM910-04-8
 8 mm Maximum Grip Length
 4 mm Nominal Diameter Pin
 Pin Part Number

Pin and Collar Assembly Part Number Combination
HLM91070-04-8
 _____ Size and Grip Length, See Above Example
 _____ Collar Part Number
 _____ Pin Part Number

* INCH STANDARD HEX

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 VAN 6-25-71	 PIN (METRIC SERIES) PROTRUDING SHEAR HEAD 6AL-6V-2Sn TITANIUM 1 mm GRIP VARIATION
APPROVED DATE R24-7-71	
REVISION DATE 6 D.P.S. 11-4-77	DRAWING NUMBER HLM910

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