



DASH NO. METRIC	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	TORQUE-OFF NEWTON-METERS	ULT TENSION STR NEWTONS MINIMUM
04	4	M4 x 0.7-4H5H	7.49 7.24	8.1	4.78 4.62	11.05 10.54	5.58	6.1	11.3	5.54	5.00 4.78	1.7	2.2	1.7 - 2.9	9600
05	5	M5 x 0.8-4H5H	8.24 7.99	8.6	5.78 5.62	11.30 10.80	5.84	6.3	11.6	6.65	6.00 5.78	1.7	2.2	2.8 - 4.6	12700
06	6	M6 x 1.0-4H5H	10.77 10.52	11.2	6.78 6.62	13.34 12.83	6.60	7.1	13.6	7.82	7.00 6.78	2.3	2.8	5.6 - 9.1	20700
08	8	M8 x 1.0-4H5H	13.45 13.20	14.0	8.82 8.62	16.13 15.62	8.12	8.7	16.4	10.72	9.50 9.28	2.4	3.0	14.6 - 16.8	36900

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution after thread lock.
 - ⑧ Dimensions are in millimeters and apply after finish.
 - ③ Burrs from cutoff process and cutting torque-off groove allowed.
 - Use HSTM1294 for oversize replacement.
 - ⑤ After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

- MATERIAL:**
- Collar - 302 HQ (or 18-9LW) stainless steel per ASTM A493, Type XM-7, or 305 stainless steel per AMS-QQ-S-763 and AMS5686, or 303 Se stainless steel per ASTM A582 (AMS5640).
- Washer - 300 series stainless steel.
- FINISH:**
- Collar - HSTM1094-() = Solid film lube per AS5272, Type I.
 HSTM1094PB() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HSTM1094TB() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
 ⑤ HSTM1094AT() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294.
 ⑧ HSTM1094HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
- Collar & Washer - HSTM1094W() = Collar finish same as HSTM1094-() and washer is passivate.
 HSTM1094PBW() = Collar finish same as HSTM1094PB() and washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and no lube.

SPECIFICATION: HI-LITE™ Product Specification M381.

CODE: Dash number indicates nominal thread size in 1mm.
 See finish note for explanation of code letters.

EXAMPLES: HSTM1094-08 = M8 x 1.0 HI-LITE™ collar with solid film lube.
 HSTM1094PBW() = M8 x 1.0 HI-LITE™ collar and washer, both with cadmium plate.

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DATE	BY	TITLE HI-LITE™ COLLAR (METRIC SERIES) STAINLESS STEEL 1mm GRIP VARIATION, SHEAR APPLICATION FOR USE ON STANDARD AND 0.5mm OVERSIZE HI-LITE™ PINS		DRAWING NO.
DRAWN	1982-10-11			HSTM1094
APPROVED	1982-10-12			1 of 1
⑧ REVISION	2017-08-24			