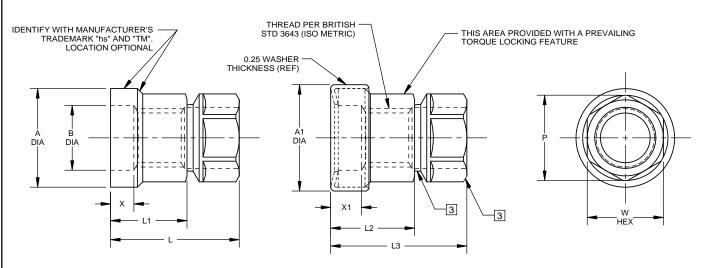
For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:

## HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



DASH NO. METRIC	PIN NOM DIA	THREAD	<b>A</b> DIA	A1 DIA (REF)	<b>B</b> DIA	L	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	<b>W</b> 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: 1. Go thread gage penetration shall be 3/4 of one revolution after thread lock.

® 2. Dimensions are in millimeters and apply after finish.

3 Burrs from cutoff process and cutting torque-off groove allowed.

4. 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:

 - 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:

- HSTM1094-() HSTM1094PB() = Solid film lube per AS5272, Type I.

= 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 &

Collar

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.

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

"HI-LITE" AND "HSTM" ARE INTERNATIONAL REGISTERED TRADEMARKS OF HI-SHEAR CORPORATION

	DATE	ВҮ
DRAWN	1982-10-11	D.P.S.
APPROVED	1982-10-12	R.TING
8 REVISION	2017-08-24	M.BEARD

## 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.

HSTM1094