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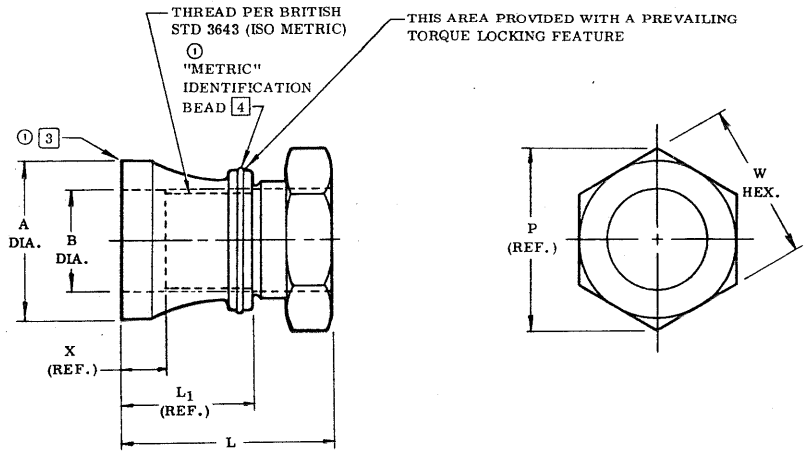
STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

① HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197
Division of Hi-Shear Industries Inc., U.S.A.
AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)
Division of Hi-Shear Industries Inc., U.S.A.
VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215
SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 56878
LITTON FASTENING SYSTEMS, U.S.A. (Licensee) U.S. Federal Code I.D. No. 97928
Division of Litton Systems Inc., U.S.A.
ST. CHAMOND-GRANAT, S.A. France (Licensee—EEC Countries)
KAMAX-WERKE, Germany (Licensee—EEC Countries)
Rudolph Kellerman GmbH & Co.
SIMMONDS, S.A. France (Licensee—EEC Countries—Collars)
TOKYO SCREW COMPANY, Japan (Licensee—Japan)
WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins & Steel Collars)
U.S. Federal Code I.D. No. 60516



DASH NO. (METRIC)	PIN NOM. DIA.	THREAD	A DIA.		B DIA.		L	L_1 (REF.)		P (REF.)		W (HEX.)	X (REF.)	TORQUE-OFF NEWTON-METER	ULT TNSN STR NEWTONS MINIMUM
-04	4.5	M4 x 0.7-4H5H	7.75 7.65		4.75 4.65		12.25 11.75	7.7		8.87		8.00 7.78	3.3	2.8 - 4.0	13300
-05	5.5	M5 x 0.8-4H5H	8.75 8.65		5.75 5.65		12.40 11.90	7.9		11.10		10.00 9.78	3.4	3.9 - 5.7	17800
-06	7	M6 x 1.0-4H5H	11.30 11.20		7.25 7.15		15.70 15.20	10.4		12.12		11.00 10.73	4.5	9.0 - 12.5	30200
-08	9	M8 x 1.0-4H5H	14.20 14.05		9.30 9.15		18.20 17.70	12.2		14.40		13.00 12.73	4.5	20.3 - 26.0	53400
-10	11	M10 x 1.0-4H5H	17.70 17.50		11.30 11.15		20.95 20.45	14.1		15.56		14.00 13.73	4.5	40.6 - 47.5	86700
-12	13	M12 x 1.25-4H5H	21.20 21.00		13.30 13.15		24.55 24.05	16.7		18.90		17.00 16.73	5.3	67.7 - 76.3	117900

NOTES:
1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
2. Dimensions apply after finish.
① 3. Break sharp edge.
① 4. Parts made prior to this revision are OK to use.

MATERIAL: 17-4PH stainless steel per AMS5643.

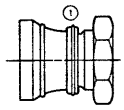
HEAT TREAT: To condition H1025 per MIL-H-6875.

FINISH: HLM373-( ) = Silver plate per Spec. AMS2410 (.0050-.0125 thick), dye color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM373V-( ) = Solid film lubricant per "Lubeco" 2123, Type II.
HLM373TB-( ) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.

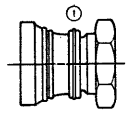
SPECIFICATION: Hi-Lok Product Specification M345.

CODE: Dash number indicates nominal thread size in 1/32nds. See "Finish" note for explanation of code letters.

EXAMPLE: HLM373-08 = M8 x 1.0 Hi-Lok collar.



VOI-SHAN
1 raised bead indicates VOI-SHAN identification.



STANDARD PRESSED STEEL
2 raised beads indicate STANDARD PRESSED STEEL identification.

U.S. patents 3,390,906; and foreign patents. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.

	DATE	BY
DRAWN	5-13-77	D.P.S.
APPROVED	5-19-77	R. [illegible]
① REVISION	12-16-83	D.P.S.

TITLE

hi-Lok® COLLAR (METRIC SERIES)

17-4PH STAINLESS STEEL
1 mm GRIP VARIATION — TENSION APPLICATION
FOR USE ON 0.5 AND 1 mm OVERSIZE HI-LOK PINS

DRAWING NUMBER

HLM373

2-1501

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