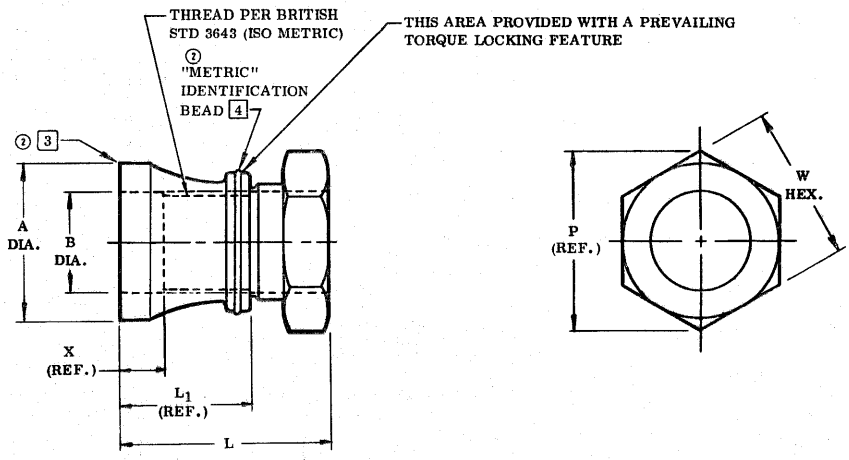
LISI AEROSPACE – Please refer to Central Documentation Website to check validity

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

(2) 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. 58878
LITTON FASTENING SYSTEMS, U.S.A. (Licensee) U.S. Federal Code I.D. No. 97823
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. 50516



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		1.7-2.9	9600
-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		2.8-4.6	12700
-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		5.6-9.1	20700
-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		14.6-18.1	36900
-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		23.7-28.3	62300
-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		36.1-43.0	97800

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

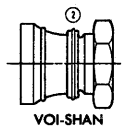
(2) MATERIAL: Type 303 Se stainless steel per ASTM A 582 and AMS5640.

FINISH:
HLM394-( ) = Solid film lube per MIL-L-8937.
HLM394G-( ) = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM394LP-( ) = Solid film lube per MIL-L-46010.
HLM394PB-( ) = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

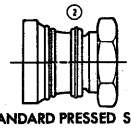
SPECIFICATION: Hi-Lok Product Specification M345.

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

EXAMPLE:
HLM394-08 = M8 x 1.0 Hi-Lok collar with solid film lube.
HLM394G-08 = M8 x 1.0 Hi-Lok collar with silver plate and cetyl alcohol lube.



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	10-15-75	D. P. S.
APPROVED	12/15/75	R. Tripp
(2) REVISION	12-16-83	D. P. S.

TITLE

hi-Lok® COLLAR (METRIC SERIES)

TYPE 303 Se STAINLESS STEEL
1 mm GRIP VARIATION — SHEAR APPLICATION
FOR USE ON 0.5 AND 1 mm OVERSIZE HI-LOK PINS

DRAWING NUMBER

HLM394

2-1501

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