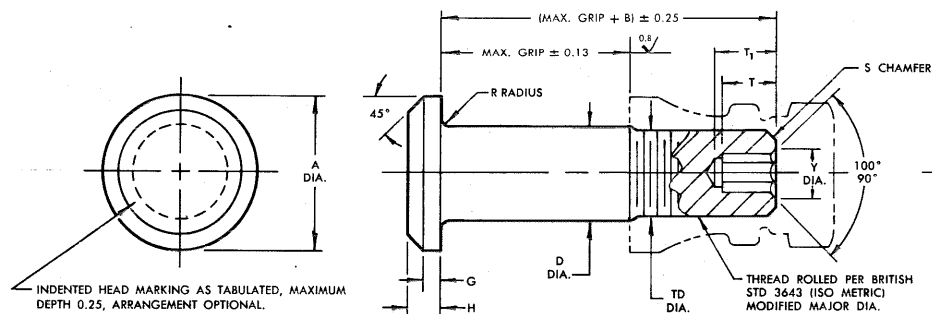


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

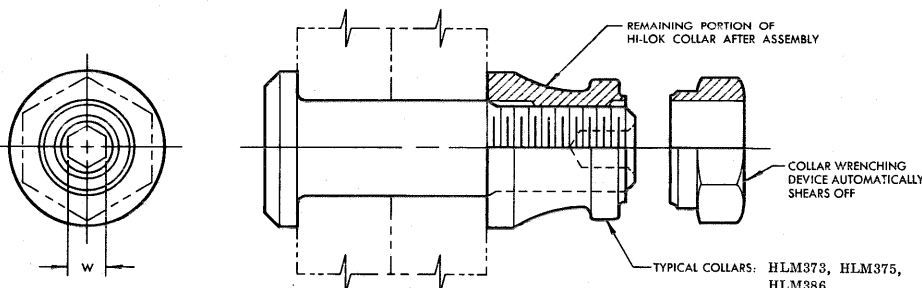
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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. (Licensee)
AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)
Division of Hi-Shear Industries Inc., U.S.A. (Licensee)
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
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WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins & Steel Collars)
U.S. Federal Code I.D. No. 60516



HI-LOK PIN (METRIC)



HI-LOK PIN AND COLLAR AFTER ASSEMBLY

INDENTED HEAD MARKING AS TABULATED, MAXIMUM DEPTH 0.25, ARRANGEMENT OPTIONAL.
"hs" or "H" or no letter indicates HI-SHEAR trademark.
"VS" indicates VOI-SHAN trademark.
"SPS" indicates STANDARD PRESSED STEEL trademark.

FIRST DASH NO.	HEAD MARKING	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	G REF.	H	R RAD.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
												* W HEX.	T HEX DEPTH MIN.	T ₁ DEPTH MAX.	Y DIA.		
-04		5			NOTE:	Use HLM20-05 (See HLM20 Sales Drawing for Collar Selection)											
-05		6			NOTE:	Use HLM20-06 (See HLM20 Sales Drawing for Collar Selection)											
-06	HLM620M6	7	11.90 11.40	11.7	6.990 6.965	5.88 5.81	1.3	2.20 2.05	0.65 0.40	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.25	3.40	3.60 3.10	50400	22200
-08	HLM620M8 x 1	9	13.85 13.25	14.0	8.987 8.962	7.88 7.80	1.6	3.05 2.80	0.75 0.50	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	2.80	4.15	4.60 4.05	83300	42000
-10	HLM620M10 x 1	11	17.20 16.40	16.2	10.987 10.962	9.88 9.80	1.9	3.75 3.50	0.75 0.50	1.2 x 45°	M10 x 1.0-4h	4.11 4.02	3.80	5.35	5.55 5.00	124500	68000
-12	HLM620M12 x 1.25	13	19.80 19.00	19.4	12.984 12.959	11.87 11.76	2.3	4.45 4.20	0.75 0.50	1.2 x 45°	M12 x 1.25-4h	4.90 4.81	4.55	6.30	6.45 5.90	173900	100200

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 finish.
3. Surface texture per ISO/DR221.

MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626 or MIL-S-6049.

HEAT TREAT: 655 N/mm² shear minimum per Spec. MIL-H-6875.

FINISH: HLM620-()-() = Cadmium plate per Spec. QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM620PB-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Product Specification No. M342.

CODE: First dash number indicates nominal diameter in 1 mm which HLM620 oversize pin replaces.
Second dash number indicates maximum grip in 1 mm.
See "Finish" note for explanation of code letters.

HOW TO ORDER EXAMPLES:

Pin Part Number Only

HLM620-06-8

— 8 mm Maximum Grip Length
— Replaces 6 mm Nominal Diameter Pin
— Pin Part Number

Pin and Collar Assembly Part Number Combination

HLM620386-06-8

— Size and Grip Length, See Above Example
— Collar Part Number
— Pin Part Number

* Inch standard hex.

* * The Double Shear values shown are based on cross sectional area for nominal diameter pin.

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

DRAWN	DATE	hi-lok® PIN (METRIC SERIES) PROTRUDING TENSION HEAD ALLOY STEEL 1 mm GRIP VARIATION — 1 mm OVERSIZE	
D. P. S.	6-10-83		
APPROVED	DATE	DRAWING NUMBER HLM620	
<i>RYS</i>	6-14-83		
REVISION	DATE		