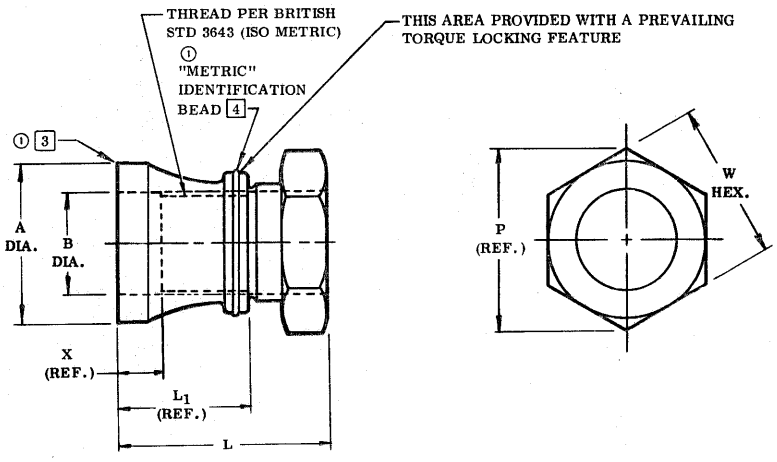
**STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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 | L1 (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<br>7.65 | | 4.75<br>4.65 | 12.25<br>11.75 | 7.7 | | | 8.87 | 8.00<br>7.78 | 3.3 | | 1.7-2.9 | 5800 |
| -05 | 5.5 | M5 x 0.8-4H5H | 8.75<br>8.65 | | 5.75<br>5.65 | 12.40<br>11.90 | 7.9 | | | 11.10 | 10.00<br>9.78 | 3.4 | | 2.8-4.6 | 7300 |
| -06 | 7 | M6 x 1.0-4H5H | 11.30<br>11.20 | | 7.25<br>7.15 | 15.70<br>15.20 | 10.4 | | | 12.12 | 11.00<br>10.73 | 4.5 | | 5.6-9.1 | 12000 |
| -08 | 9 | M8 x 1.0-4H5H | 14.20<br>14.05 | | 9.30<br>9.15 | 18.20<br>17.70 | 12.2 | | | 14.40 | 13.00<br>12.73 | 4.5 | | 14.6-18.1 | 22200 |
| -10 | 11 | M10 x 1.0-4H5H | 17.70<br>17.50 | | 11.30<br>11.15 | 20.95<br>20.45 | 14.1 | | | 15.56 | 14.00<br>13.73 | 4.5 | | 23.7-28.3 | 33300 |
| -12 | 13 | M12 x 1.25-4H5H | 21.20<br>21.00 | | 13.30<br>13.15 | 24.55<br>24.05 | 16.7 | | | 18.90 | 17.00<br>16.73 | 5.3 | | 36.1-43.0 | 48900 |
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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: 2024 aluminum alloy per QQ-A-430 or QQ-A-225/6.

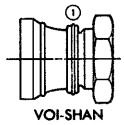
HEAT TREAT: Age to T6 condition per MIL-H-6088.

FINISH: HLM370-( ) = Anodize, dye color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.

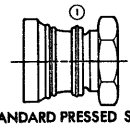
SPECIFICATION: Hi-Lok Product Specification M345.

CODE: Dash number indicates nominal thread size in 1 mm.

EXAMPLE: HLM370-08 = 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 | 10-15-75 | D. P. S. |
| APPROVED | 12/15/75 | R. Tapp |
| ① REVISION | 12-16-83 | D. P. S. |

TITLE

# hi-lok® COLLAR (METRIC SERIES)

2024-T6 ALUMINUM ALLOY
1 mm GRIP VARIATION — SHEAR APPLICATION
FOR USE ON 0.5 AND 1 mm OVERSIZE HI-LOK PINS

DRAWING NUMBER

**HLM370**

2-1501

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