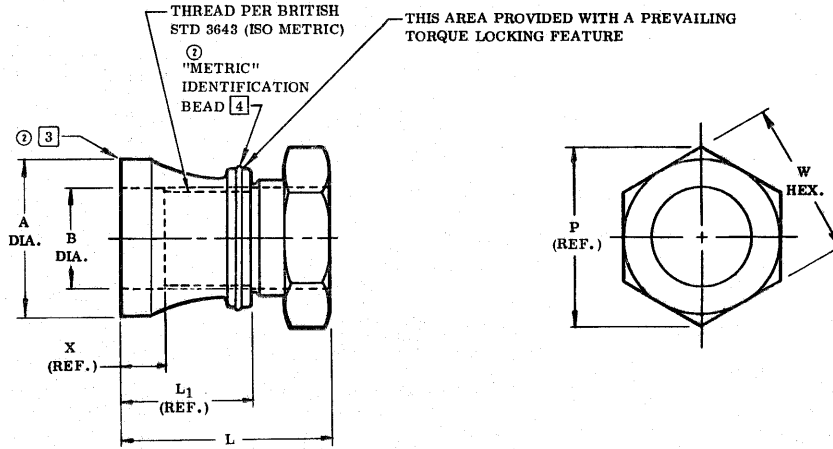


**STANDARDS COMMITTEE  
FOR HI-LOK® PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

② HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 75187  
 Division of HI-Shear Industries Inc., U.S.A. (Licensee)  
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.S.A. (Licensee)  
 Division of HI-Shear Industries Inc., U.S.A. (Licensee)  
 YOJ-SHAK, Division of YOJ Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 82215  
 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. 47822  
 Division of Litton Systems Inc., U.S.A. (Licensee)

ST. CHAMOND-GRAMAT, S.A. France (Licensee—EEC Countries)  
 KANAX-WERKE, Germany (Licensee—EEC Countries)  
 Rudolph Katherman GmbH & Co. (Licensee—EEC Countries—Coltore)  
 SIMONDS, S.A. France (Licensee—Japan)  
 TOKYO SCREW COMPANY, Japan (Licensee—Japan)  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Overseas Plus & Steel Collars)  
 U.S. Federal Code I.D. No. 50518



DASH NO. (METRIC)	PIN NOM. DIA.	THREAD	A DIA.	B DIA.	L	L1 (REF.)	P (REF.)	W (HEX.)	X (REF.)	TORQUE OFF	ULT TNSN STR
										NEWTON-METER	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.  
 ③ Break sharp edge.  
 ④ Parts made prior to this revision are OK to use.

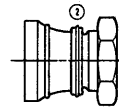
① MATERIAL: Type 303 Se stainless steel per ASTM A 582 and AMS5640.

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.

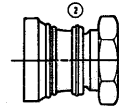
SPECIFICATION: Hi-Lok Product Specification M345.

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 3,390,904; and foreign patents. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.

DRAWN	DATE	BY	TITLE	DRAWING NUMBER
	10-15-75	D. P. S.		
APPROVED	12/15/75	<i>R. Lopez</i>	<b>hi-Lok® COLLAR (METRIC SERIES)</b>  TYPE 303 Se STAINLESS STEEL 1 mm GRIP VARIATION — SHEAR APPLICATION FOR USE ON 0.5 AND 1 mm OVERSIZE HI-LOK PINS	<b>HLM394</b>
② REVISION	12-16-83	D. P. S.		