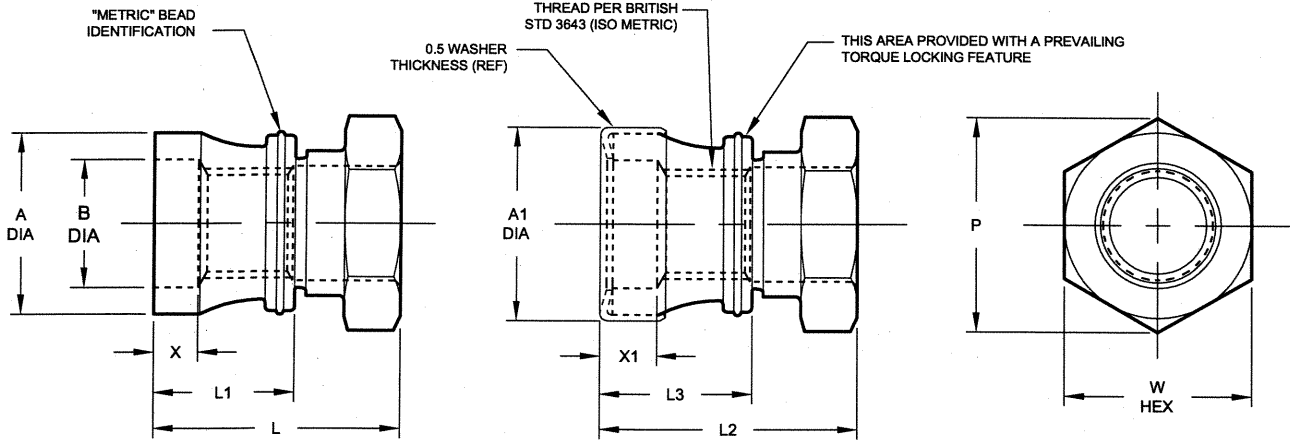


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 a LISI AEROSPACE Company
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A & Canada) CAGE No. 06725
 HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97929
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
 (Pins & Steel Collars)

BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB68
 a LISI AEROSPACE Company
 HUCK S.A. France (Licensee - ECC Countries)
 BLANC AERO S.A. France (Licensee - ECC Countries)
 a LISI AEROSPACE Company
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



(10)

DASH NO. (METRIC)	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	TORQUE-OFF NEWTON-METER	ULT TNSN STR NEWTONS MINIMUM
04	4	M4 x 0.7-4H5H	7.42 7.15	8.6	4.25 4.15	11.75 11.25	7.2	12.3	8.0	8.65	8.00 7.78	2.8	3.6	1.7-2.9	5800
05	5	M5 x 0.8-4H5H	8.25 7.69	9.1	5.25 5.15	11.90 11.40	7.4	12.4	8.1	11.10	10.00 9.78	2.9	3.7	2.8-4.6	7300
06	6	M6 x 1.0-4H5H	10.47 10.30	11.7	6.25 6.15	14.50 14.00	9.2	15.0	9.9	12.12	11.00 10.73	3.3	4.1	5.6-9.1	12000
08	8	M8 x 1.0-4H5H	13.15 13.00	14.6	8.30 8.15	17.00 16.50	11.0	17.7	11.9	14.40	13.00 12.73	3.3	4.2	14.6-18.1	22200
10	10	M10 x 1.0-4H5H	16.50 15.78	17.5	10.30 10.15	19.75 19.25	12.9	20.5	13.9	15.56	14.00 13.73	3.3	4.3	23.7-28.3	33300
12	12	M12 x 1.25-4H5H	20.70 19.60	22.1	12.30 12.15	23.10 22.60	15.3	23.9	16.3	18.90	17.00 16.73	3.9	4.9	36.1-43.0	48900

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 2. Dimensions apply after finish.
 3. Use HLM370 for oversize replacement.

MATERIAL: Collar - 2024 aluminum alloy per QQ-A-430 or QQ-A-225/6.
 Washer - 2024 aluminum alloy per QQ-A-250/4 or 250/5.

HEAT TREAT: Collar - Age to T6 condition per AMS2770.
 Washer - Age to T6 condition per AMS2770.

FINISH: Collar - HLM70(-) = Anodize color red, and cetyl alcohol lube per Hi-Shear Spec. 305.
 Collar & Washer - HLM70TW() = Collar finish same as HLM70(-), and washer with anodize, color red.

SPECIFICATION: Hi-Lok Product Specification M345.

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

EXAMPLES: HLM70-08 = M8 x 1.0 Hi-Lok collar.
 HLM70TW08 = M8 x 1.0 Hi-Lok collar and washer.

"Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation

DATE	BY	TITLE	DRAWING NO.
4-17-70	Van	HI-LOK® COLLAR (METRIC SERIES) 2024-T6 ALUMINUM ALLOY 1 mm GRIP VARIATION, SHEAR APPLICATION	HLM70
4-17-70	R.Ting		
6-7-2004	J.F.Obispo		
(10) REVISION			