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.
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.
Division of Litton Systems, Inc. (Licensee) **U.S. Federal Code I.D. No. 97928**

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ST. CHAMOND-GRANAT, S.A. France (Licensee)
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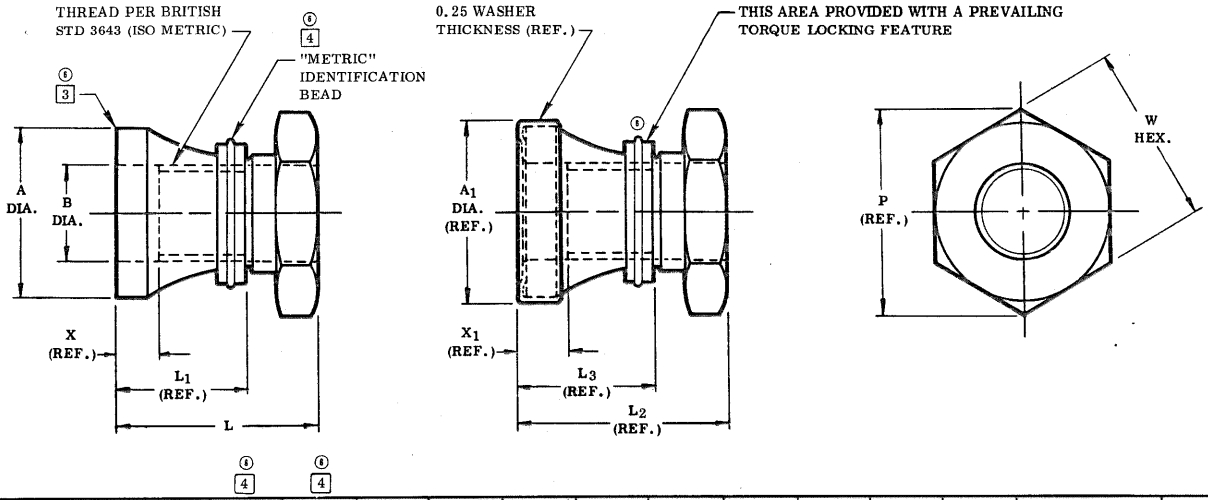


6 4 6 4

DASH NO. (METRIC)	PIN NOM. DIA.	THREAD	A DIA.	A_1 DIA. (REF.)	B DIA.	L	L_1 (REF.)	L_2 (REF.)	L_3 (REF.)	P (REF.)	W (HEX.)	X (REF.)	X_1 (REF.)	TORQUE OFF NEWTON-METER	ULT TNSN STR NEWTONS MINIMUM
-04	4	M4 x 0.7-4H5H	7.42 7.15	8.1	4.25 4.15	11.75 11.25	7.2	12.0	7.7	8.87	8.00 7.78	2.8	3.3	2.8-4.0	13300
-05	5	M5 x 0.8-4H5H	8.25 7.69	8.6	5.25 5.15	11.90 11.40	7.4	12.2	7.9	11.10	10.00 9.78	2.9	3.4	3.9-5.7	17800
-06	6	M6 x 1.0-4H5H	10.47 10.30	11.2	6.25 6.15	14.50 14.00	9.2	14.8	9.7	12.12	11.00 10.73	3.3	3.8	9.0-12.5	30200
-08	8	M8 x 1.0-4H5H	13.15 13.00	14.0	6 4 8.30 8.15	17.00 16.50	11.0	17.5	11.6	14.40	13.00 12.73	3.3	3.9	20.3-26.0	53400
-10	10	M10 x 1.0-4H5H	16.50 15.78	16.9	10.30 10.15	19.75 19.25	12.9	20.2	13.6	15.56	14.00 13.73	3.3	4.0	40.6-47.5	86700
-12	12	M12 x 1.25-4H5H	21.54 19.60	22.4	12.30 12.15	23.10 22.60	15.3	23.6	16.0	18.90	17.00 16.73	3.9	4.5	67.7-76.3	117900

NOTES:
1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
2. Dimensions apply after finish.
6 3. Break sharp edge.
6 4. Parts made prior to this revision are OK to use.
5. Use HLM373 for oversize replacement.

MATERIAL: Collar — 17-4PH stainless steel per AMS5643.
Washer — 300 series stainless steel.

HEAT TREAT: To condition H1025 per MIL-H-6875 (collar only).

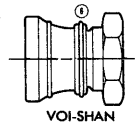
FINISH: Collar — HLM73-( ) = Silver plate per Spec. AMS2410 (.0050-.0125 thick), dye color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM73DU-( ) = Solid film lube per MIL-L-8937.
HLM73TB-( ) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM73V-( ) = Solid film lubricant per "Lubeco" 2123, Type II.

Collar and Washer — HLM73W-( ) = Collar finish same as HLM73-( ) and washer is passivate.

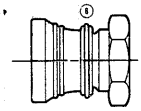
SPECIFICATION: Hi-Lok Product Specification M345.

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

EXAMPLE: HLM73-08 = M8 x 1.0 Hi-Lok collar.
HLM73W-08 = M8 x 1.0 Hi-Lok collar with washer.



VOI-SHAN
1 raised bead indicates VOI-SHAN identification.



STANDARD PRESSED STEEL
2 raised beads indicate STANDARD PRESSED STEEL identification.

U.S. patents 2,927,491; 2,940,495; 3,027,789; 3,138,987.
Other U.S. and Foreign patents granted and pending.
"Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.

	DATE	BY
DRAWN	12-2-71	VAN
APPROVED	12-2-71	R.Y.
6 REVISION	4-22-80	D.P.S.

TITLE
hi-lok® COLLAR (METRIC SERIES)
17-4PH STAINLESS STEEL
1 mm GRIP VARIATION — TENSION APPLICATION

DRAWING NUMBER
HLM73

2-1501

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