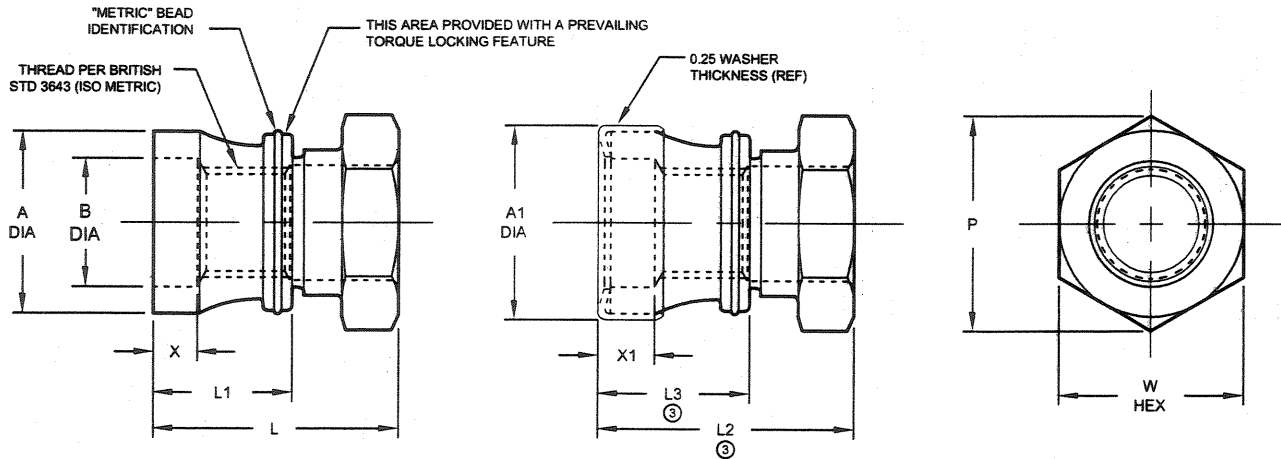


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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. 97828
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 36878
 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. 0LB66
 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)



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	8.1	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	9600
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	12700
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	20700
08	8	M8 x 1.0-4H5H	13.15 13.00	14.0	8.33 8.18	17.00 16.50	11.0	17.5	11.6	14.40	13.00 12.73	3.3	3.9	20.3-26.0	36900
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	62300
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	97800

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 - Dimensions apply after finish.
 - Use HLM378 for oversize replacement.

MATERIAL: Collar - A-286 high temperature alloy per AMS5731.
 Steel Washer - 300 series stainless steel.

FINISH: Collar - HLM78(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
 HLM78G() = Silver plate per AMS2410 (.0002 - .0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305.

Collar & Washer -
 HLM78W() = Collar finish same as HLM78(-), and washer is passivate.
 HLM78GW() = Collar finish same as HLM78G(), 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.

EXAMPLES: HLM78-08 = M8 x 1.0 Hi-Lok collar with solid film lube.
 HLM78GW08 = M8 x 1.0 Hi-Lok collar and washer with silver plate and washer is passivate.

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

			TITLE	DRAWING NO.
DRAWN	1-25-77	D.P.S.	HI-LOK® COLLAR (METRIC SERIES) A-286 HIGH TEMPERATURE ALLOY 1 mm GRIP VARIATION, TENSION APPLICATION	HLM78
APPROVED	1-25-77	R.Ting		
3 REVISION	07-30-07	J.F.Obispo		