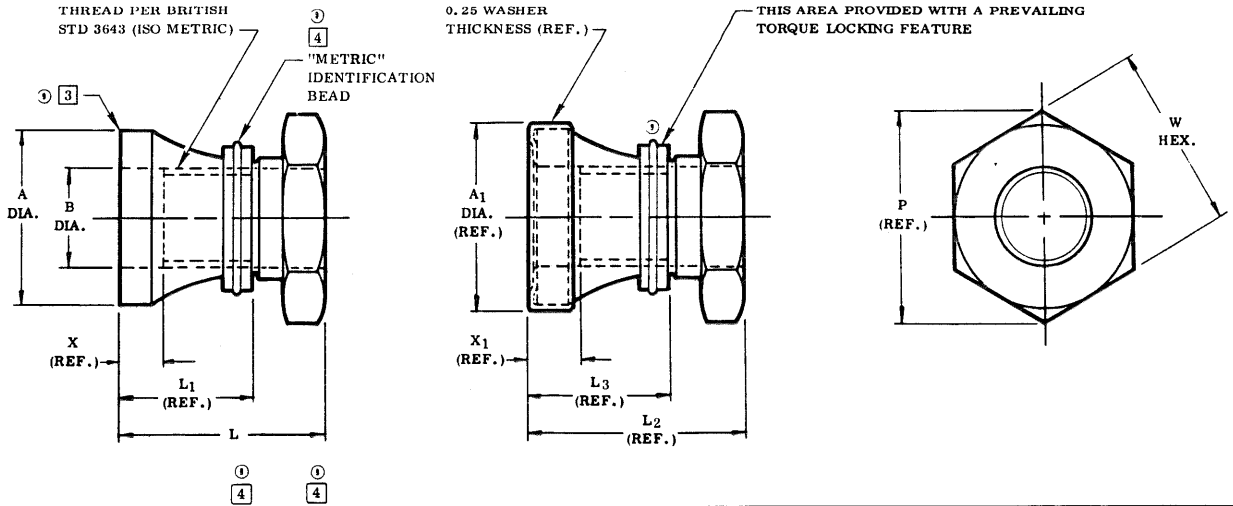


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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.
 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.

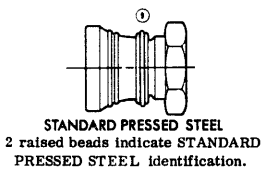
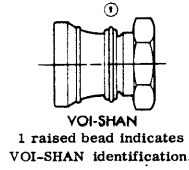
(Licensee)
 KAMAX-WERKE, Germany
 Rudolph Kellerman GmbH & Co.
 ST. CHAMOND-GRANAT, S.A. France (Licensee)
 TOKYO SCREW COMPANY, Japan (Licensee)



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	ULT TNSN STR
														NEWTON-METER	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	8.30 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	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: 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.
 5. Use HLM386 for oversize replacement.

① MATERIAL: Collar - Type 303 Se stainless steel per ASTM A-582 and AMS5640.
 Washer - 300 series stainless steel.
 FINISH: Collar - HLM86-() = Solid film lube per Spec. MIL-L-8937.
 HLM86PB-() = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per HI-Shear Spec. 305.
 HLM86TB-() = HI-Kote 2 solid film lube per HI-Shear Spec. 292 and cetyl alcohol lube per HI-Shear Spec. 305.
 Collar and Washer - HLM86W-() = Collar finish same as HLM86-() and washer is passivate.
 HLM86PBW-() = Collar finish same as HLM86PB-() and washer with cadmium plate per QQ-P-416, Type II, Class 2, and no lube.



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: HLM86-08 = M8 x 1.0 HI-Lok collar with solid film lube.
 HLM86PBW-08 = M8 x 1.0 HI-Lok collar and washer.

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.

DRAWN	DATE	BY
	4-17-70	Van
APPROVED	4-17-70	R. [Signature]
⑨ REVISION	5-7-80	D. P. S.

hi-lok® COLLAR (METRIC SERIES)
 TYPE 303 Se STAINLESS STEEL
 1 mm GRIP VARIATION - TENSION APPLICATION

DRAWING NUMBER
HLM86