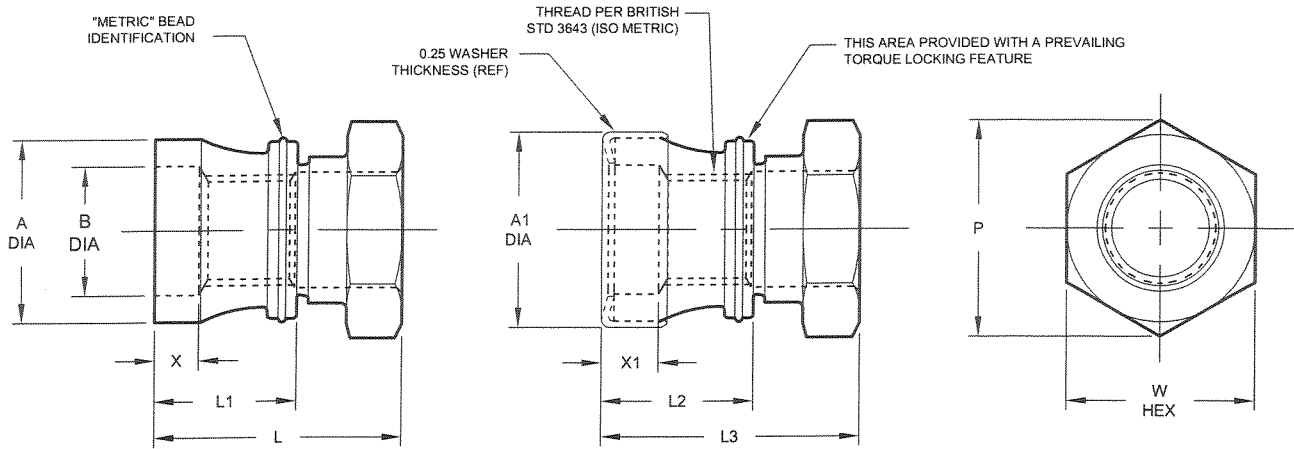


# STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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. 97928  
 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. 0LB88  
 a LISI AEROSPACE Company  
 HUCK S.A. France (Licensee - ECC Countries) -----CAGE No. 06725  
 BLANC AERO S.A. France (Licensee - ECC Countries) -----CAGE No. 97928  
 a LISI AEROSPACE Company  
 TOKYO SCREW COMPANY, Japan (Licensee - Japan) -----CAGE No. 56878



(12)

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	1.7-2.9	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	2.8-4.6	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	5.6-9.1	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	14.6-18.1	36900
10	10	M10 x 1.0-4H5H	16.50 15.78	16.9	8.30 8.15	19.75 19.25	12.9	20.2	13.6	15.56	14.00 13.73	3.3	4.0	23.7-28.3	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	36.1-43.0	97800

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
  2. Dimensions apply after finish.
  3. Use HLM394 for oversize replacement.

**MATERIAL:** Collar - Type 303 Se Stainless steel per ASTM A582.  
 Steel Washer - 300 series stainless steel.

**FINISH:** Collar - HLM94( ) = Solid film lube per AS5272, Type I.  
 HLM94G( ) = Silver plate per AMS2410 (.0002 - .0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLM94K( ) = Solid film lube per Lubeco 905.  
 HLM94LP( ) = Solid film lube per AS5272, Type II.  
 HLM94PB( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

Collar & Washer -  
 HLM94W( ) = Collar finish same as HLM94( ), and washer is passivate.  
 HLM94GW( ) = Collar and washer both with silver plate per AMS2410 (.0002 - .0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLM94PBW( ) = Collar finish same as HLM94PB( ) and washer with cadmium plate per AMS-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.

**EXAMPLES:** HLM94-08 = M8 x 1.0 Hi-Lok collar with solid film lube.  
 HLM94GW08 = M8 x 1.0 Hi-Lok collar and washer, both with silver plate and cetyl alcohol lube.

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

			TITLE	DRAWING NO.
DATE	BY		<b>HI-LOK® COLLAR (METRIC SERIES)</b> TYPE 303 Se STAINLESS STEEL 1 mm GRIP VARIATION, SHEAR APPLICATION	<b>HLM94</b>
DRAWN	4/17/70	AHS		
APPROVED	4-17-70	R.Ting		
(12) REVISION	11-04-2003	J.F.Obispo		