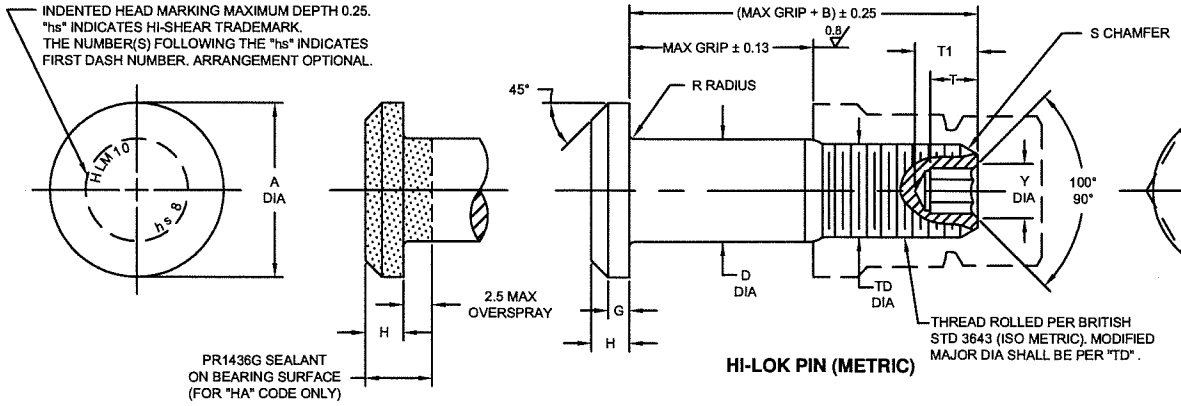
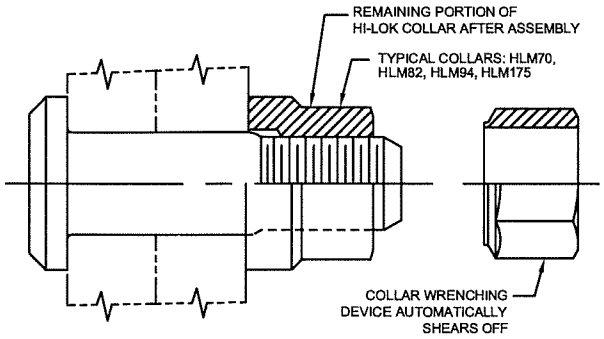
lisi AEROSPACE (17)
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

(17)

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 SPS TECHNOLOGIES, U.S.A.——(Licensee)——CAGE No. 56878 FAIRCHILD - SIMMONDS S.A. France——(Licensee)——CAGE No. 92215	BLANC AERO., U.K.——(Licensee)——CAGE No. OLB68 a LISI AEROSPACE Company BLANC AERO S.A. France——(Licensee - ECC Countries) a LISI AEROSPACE Company TOKYO SCREW COMPANY, Japan——(Licensee - Japan)



HI-LOK PIN (METRIC)



HI-LOK PIN AND COLLAR AFTER ASSEMBLY

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

FIRST DASH NO.	MARKING	PIN NOM DIA	A DIA	B REF	D DIA WITHOUT ALUMINUM COATING	D DIA AFTER ALUMINUM COATING	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD	SOCKET W HEX	SOCKET T DEPTH MIN	SOCKET T1 DEPTH MAX	SOCKET Y DIA	DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
04	HLM10M4	4	6.65 6.25	8.35	3.990 3.978	3.990 3.965	3.91 3.86	0.6	1.20 0.95	0.65 0.40	0.8 x 37°	M4 x 0.7-4h Modified	1.64 1.61	5 1.80	2.95	2.30 1.90	16400	7800
05	HLM10M5	5	8.15 7.65	8.65	4.990 4.978	4.990 4.965	4.90 4.84	0.8	1.40 1.15	0.65 0.40	0.8 x 37°	M5 x 0.8-4h Modified	2.05 2.01	2.00	3.05	3.05 2.60	25700	11800
06	HLM10M6	6	10.20 9.70	10.70	5.990 5.978	5.990 5.965	5.88 5.81	0.9	1.75 1.50	0.65 0.40	0.8 x 37°	M6 x 1.0-4h Modified	2.46 2.40	2.25	3.40	3.60 3.10	37000	18200
08	HLM10M8 X 1	8	12.85 12.25	12.95	7.987 7.972	7.987 7.962	7.88 7.80	1.0	2.20 1.95	0.75 0.50	1.2 x 37°	M8 x 1.0-4h Modified	3.29 3.22	2.80	4.15	4.60 4.05	65800	31600
10	HLM10M10 X 1	10	16.20 15.40	15.20	9.987 9.972	9.987 9.962	9.88 9.80	1.3	2.65 2.40	0.75 0.50	1.2 x 37°	M10 x 1.0-4h Modified	4.11 4.02	3.80	5.35	5.55 5.00	102900	48900
12	HLM10M12 X 1.25	12	18.80 18.00	18.15	11.984 11.966	11.984 11.959	11.87 11.76	1.5	2.95 2.70	0.75 0.50	1.2 x 37°	M12 x 1.25-4h Modified	4.90 4.81	4.55	6.30	6.45 5.90	148100	66700

GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within 0.25 FIM.
2. Dimensions to be met after finish.
3. Surface texture per ISO/R468.
4. Use HLM310 for oversize replacement.
5. Parts made prior to this revision are OK to use.

MATERIAL: 6AL-4V titanium alloy per AMS4928 or AMS4967.
6AL-6V-2Sn titanium alloy per AMS4971 is acceptable for -10 and larger sizes.

HEAT TREAT: 655 MPa shear minimum.

FINISH:
HLM10-( )-( ) = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet (equivalent to LN9368 Blatt 4), with color code black on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.
HLM10AP( )-( ) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
(17) HLM10AZ( )-( ) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 with color code black on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.
(17) HLM10AT( )-( ) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294.
HLM10HA( )-( ) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, apply precoat No. PR1436G sealant (.051-.127mm thick) with color code black on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification M342.

CODE: First dash number indicates nominal diameter in 1 mm.
Second dash number indicates maximum grip in 1 mm.
See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:

Pin Part Number Only
HLM10-04-8
- 8 mm Maximum Grip Length
- 4 mm Nominal Diameter Pin
- Pin Part Number

Pin and Collar Assembly Part Number Combination
HLM1070-04-8
- Size and Grip Length, See Above Example
- Collar Part Number
- Pin Part Number

U.S. Patents 3,390,906 and foreign patents.
"Hi-Lok" and "HL" are registered trademarks of Hi-Shear Corporation.

DRAWN	DATE	TITLE
Van	4-17-70	HI-LOK® PIN (METRIC SERIES)
APPROVED R.Ting	DATE 4-20-70	PROTRUDING SHEAR HEAD TITANIUM 1 mm GRIP VARIATION
REVISION (17)	DATE 9-17-09	DRAWING NUMBER HLM10

HLM10

JFO-STD/HSTPIN

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