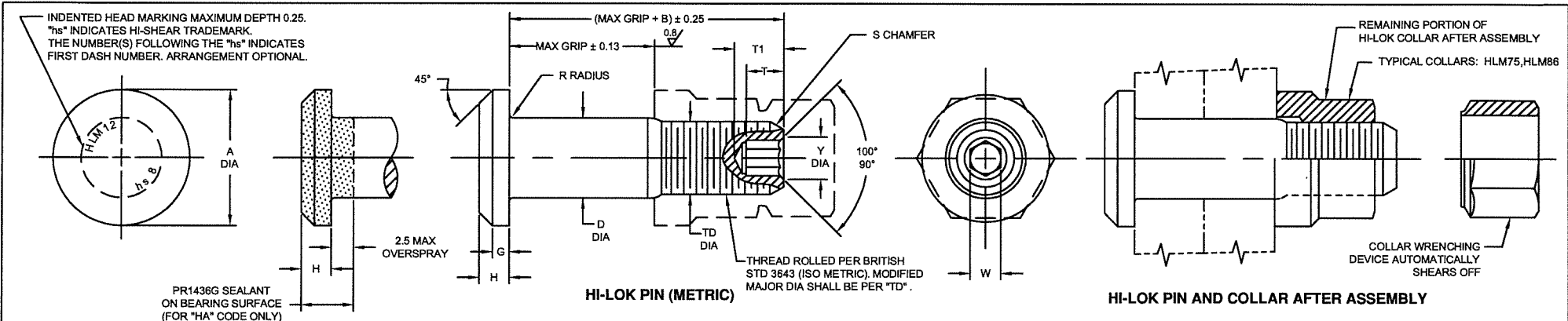


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|---|---|
| HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197 a LISI AEROSPACE Company | BLANC AERO INDUSTRIES RUGBY (Licensee) CAGE No. U6300 a LISI AEROSPACE Company |
| AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A & Canada) CAGE No. 06725 | BLANC AERO S.A. France (Licensee) CAGE NO. F0188 |
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| WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516 | a LISI AEROSPACE Company |
| MINIHEA CO., LTD. Japan (Pins & Steel Collars) (Licensee-Japan) | FT BESTAS, Izmir (Licensee) CAGE No. T0602 a LISI AEROSPACE Company |



| FIRST DASH NO. | MARKING | PIN NOM DIA | A DIA | B REF | D DIA | | TD DIA | G REF | H | R RAD | S CHAMFER REF | THREAD | SOCKET | | | | DOUBLE SHEAR NEWTONS MINIMUM | TENSION NEWTONS MINIMUM |
|----------------|-----------------|-------------|----------------|-------|--------------------------|------------------------|----------------|-------|--------------|--------------|---------------|------------------------|--------------|-------------|--------------|--------------|------------------------------|-------------------------|
| | | | | | WITHOUT ALUMINUM COATING | AFTER ALUMINUM COATING | | | | | | | W HEX | T DEPTH MIN | T1 DEPTH MAX | Y DIA | | |
| 04 | HLM12M4 | 4 | 8.15 7.75 | 8.35 | 3.990 3.978 | 3.990 3.965 | 3.91 3.86 | 0.9 | 1.60 1.40 | 0.65 0.40 | 0.8 x 37° | M4 x 0.7-4h Modified | 1.64 1.61 | 1.80 | 2.95 1.90 | 2.30 1.90 | 16400 | 9800 |
| 05 | HLM12M5 | 5 | 9.75 9.25 | 8.65 | 4.990 4.978 | 4.990 4.965 | 4.90 4.84 | 1.0 | 1.90 1.65 | 0.65 0.40 | 0.8 x 37° | M5 x 0.8-4h Modified | 2.05 2.01 | 2.00 | 3.05 2.60 | 2.60 | 25700 | 15600 |
| 06 | HLM12M6 | 6 | 10.90 10.40 | 10.70 | 5.990 5.978 | 5.990 5.965 | 5.88 5.81 | 1.3 | 2.30 2.05 | 0.65 0.40 | 0.8 x 37° | M6 x 1.0-4h Modified | 2.46 2.40 | 2.25 | 3.40 3.10 | 3.60 3.10 | 37000 | 22200 |
| 08 | HLM12M8 X 1 | 8 | 12.85 12.25 | 12.95 | 7.987 7.972 | 7.987 7.962 | 7.88 7.80 | 1.6 | 3.05 2.80 | 0.75 0.50 | 1.2 x 37° | M8 x 1.0-4h Modified | 3.29 3.22 | 2.80 | 4.15 4.05 | 4.60 4.05 | 65800 | 42000 |
| 10 | HLM12M10 X 1 | 10 | 16.20 15.40 | 15.20 | 9.987 9.972 | 9.987 9.962 | 9.88 9.80 | 1.9 | 3.75 3.50 | 0.75 0.50 | 1.2 x 37° | M10 x 1.0-4h Modified | 4.11 4.02 | 3.80 | 5.35 5.00 | 5.55 5.00 | 102900 | 68000 |
| 12 | HLM12M12 X 1.25 | 12 | 18.80 18.00 | 18.15 | 11.984 11.966 | 11.984 11.959 | 11.87 11.76 | 2.3 | 4.45 4.20 | 0.75 0.50 | 1.2 x 37° | M12 x 1.25-4h Modified | 4.90 4.81 | 4.55 | 6.30 5.90 | 6.45 5.90 | 148100 | 100200 |

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

- 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 HLM312 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.

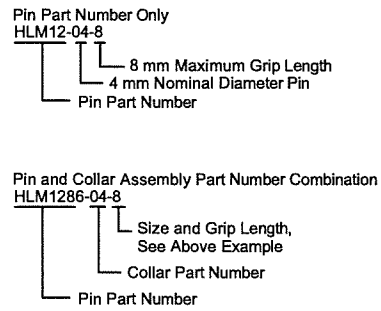
HEAT TREAT: 655 MPa shear minimum.

- FINISH:**
- HLM12(-)(-) = 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.
 - HLM12AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLM12AZ(-)(-) = 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.
 - 15 HLM12AT(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294.
 - HLM12HA(-)(-) = 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:



| | | |
|--|------------------|---|
| U.S. Patents 3,390,906 and foreign patents. "Hi-Lok" and "HL" are registered trademarks of Hi-Shear Corporation. | | |
| DRAWN Van | DATE 4-17-70 | TITLE HI-LOK® PIN (METRIC SERIES) PROTRUDING TENSION HEAD TITANIUM 1 mm GRIP VARIATION |
| APPROVED R.Ting | DATE 4-20-70 | DRAWING NUMBER HLM12 |
| REVISION 15 | DATE 02-04-10 | |

HLM12