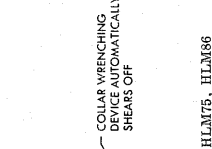
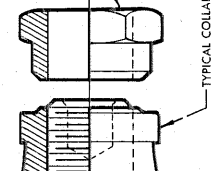
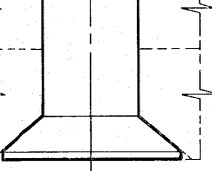
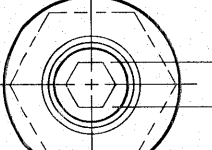
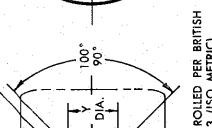
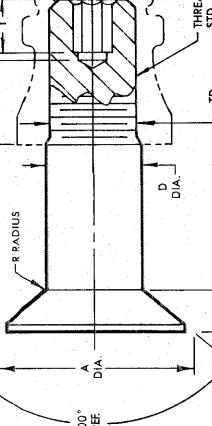
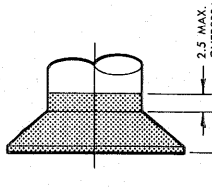
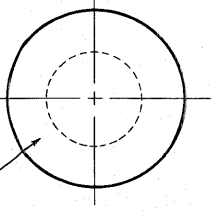


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

INDENTED HEAD MARKING AS TABULATED, MAXIMUM DEPTH 0.25, ARRANGEMENT OPTIONAL.
"H" indicates HI-SHEAR trademark.
"S" indicates STANDARD PRESSED STEEL trademark.



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.	HEAD MARKING	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD (MODIFIED)	* HEX.	SOCKET		DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM	
														T ₁ DEPTH MAX.	Y DIA.			
-04	HLM13M4	4	8-13	8-35	3-990	3-91	0.11	1-74	0.65	0.25	0.8 x 37°	M4 x 0.7-4h	1.64	1.80	2.95	2.30	16400	9800
-05	HLM13M5	5	10-13	8-65	4-990	4-90	0.13	2-16	0.75	0.38	0.8 x 37°	M5 x 0.8-4h	2.05	2.00	3.05	2.60	25700	15600
-06	HLM13M6	6	12-13	10-70	5-990	5-88	0.16	2-58	0.75	0.38	0.8 x 37°	M6 x 1.0-4h	2.46	2.25	3.40	3.60	37000	22200
-08	HLM13M8 x 1	8	16-13	12-95	7-987	7-88	0.18	3-42	1.00	0.38	1.2 x 37°	M8 x 1.0-4h	3.28	2.80	4.15	4.60	65800	42000
-10	HLM13M10 x 1	10	20-13	15-20	9-987	9-88	0.21	4-26	1.00	0.38	1.2 x 37°	M10 x 1.0-4h	4.11	3.80	5.35	5.55	102000	68000
-12	HLM13M12 x 1.25	12	24-13	18-15	11-982	11-87	0.23	5-10	1.25	0.56	1.2 x 37°	M12 x 1.25-4h	4.92	4.55	6.30	6.45	148100	100200

GENERAL NOTES: 1. Head edge out of roundness shall not exceed ".1".
2. Concentricity: Conical surface of head to "D" diameter within 0.08 FIR.
3. "H" is dimensioned from maximum "D" diameter.
4. Surface texture per ISO/R468.
5. Dimensions to be met after finish.
6. Curved or flat edge manufacturer's option.
7. Use HLM13 for oversize replacement.
8. Parts made prior to this revision are OK to use.

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

HEAT TREAT: 655 MPa shear minimum.
FINISH: HLM13-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-robot (equivalent to LN3668 Blat 4), and cetyl alcohol lube per Hi-Shear Spec. 306.
HLM13AP-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 306.
HLM13AU-()-() = Solid film lube per "Electrofilm" XSF-104.
HLM13HA-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and apply precoat No. PRI4366 sealant (.051-.127 mm thick) plus cetyl alcohol lube per Hi-Shear Spec. 306.
SPECIFICATION: Hi-Lok Product Specification No. M342.

HOW TO ORDER: Pin Part Number Only
EXAMPLES: HLM13-01-3
 4 mm Nominal Diameter Pin
 8 mm Maximum Grip Length
 Pin Part Number

Pin and Collar Assembly Part Number Combination
HLM1386-04-8
 Size and Grip Length. See Above Example
 Collar Part Number
 Pin Part Number

* INCH STANDARD HEX

U.S. patents 3,990,906 and foreign patents.
"Hi-Lok" and "H" are Registered Trademarks of Hi-Shear Corporation.

DATE: 4-17-78
DRAWN: AMS
APPROVED: [Signature]
REVISION: 14
DATE: 9-21-82
D.P.S.
TITANIUM
100° FLUSH TENSION HEAD
1 mm GRIP VARIATION
DRAWING NUMBER: HLM13