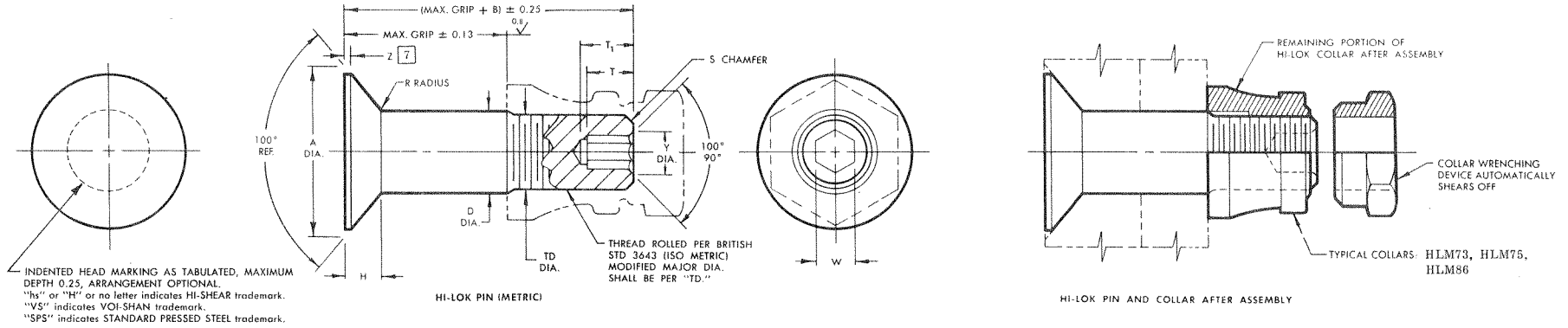


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

Division of Hi-Shear Industries Inc., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee) U.S. Federal Code I.D. No. 92215
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215
 VSI-SHEAR, 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. 92215
 LITTON FASTENING SYSTEMS, U.S.A. (Licensee) U.S. Federal Code I.D. No. 97928
 Division of Litton Systems Inc., U.S.A. (Licensee) U.S. Federal Code I.D. No. 97928
 KANAK-WESKE, Germany (Licensee—EEC Countries—Collars)
 Rudolf Kellerman GmbH & Co. (Licensee—EEC Countries—Collars)
 SIMMONDS, S.A. France (Licensee—Japan)
 TOKYO SCREW COMPANY, Japan (Licensee—Japan)
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins & Steel Collars)
 U.S. Federal Code I.D. No. 60516



INDENTED HEAD MARKING AS TABULATED, MAXIMUM DEPTH 0.25, ARRANGEMENT OPTIONAL.
 "hs" or "H" or no letter indicates HI-SHEAR trademark.
 "VS" indicates VQI-SHEAR trademark.
 "SPS" indicates STANDARD PRESSED STEEL trademark.

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)	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
													* W HEX.	T HEX DEPTH MIN.	T1 DEPTH MAX.	Y DIA.		
-04	HLM21M4	4	8.13 7.99	8.35	3.990 3.965	3.91 3.86	0.11	1.74 1.68	0.65 0.40	0.25	0.8 x 45°	M4 x 0.7-4h	1.64 1.61	1.80	2.95	2.30 1.90	16400	9800
-05	HLM21M5	5	10.13 9.99	8.65	4.990 4.965	4.90 4.84	0.13	2.16 2.10	0.75 0.50	0.38	0.8 x 45°	M5 x 0.8-4h	2.05 2.01	2.00	3.05	3.05 2.60	25700	15600
-06	HLM21M6	6	12.13 11.99	10.70	5.990 5.965	5.88 5.81	0.16	2.58 2.52	0.75 0.50	0.38	1.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.25	3.40	3.60 3.10	37000	22200
-08	HLM21M8 x 1	8	16.13 15.99	12.95	7.987 7.962	7.88 7.80	0.18	3.42 3.36	1.00 0.75	0.38	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	2.80	4.15	4.60 4.05	65800	42000
-10	HLM21M10 x 1	10	20.13 19.99	15.20	9.987 9.962	9.88 9.80	0.21	4.26 4.20	1.00 0.75	0.38	1.2 x 45°	M10 x 1.0-4h	4.11 4.02	3.80	5.35	5.55 5.00	102900	68000
-12	HLM21M12 x 1.25	12	24.13 23.99	18.15	11.984 11.959	11.87 11.76	0.23	5.10 5.04	1.25 1.00	0.56	1.2 x 45°	M12 x 1.25-4h	4.90 4.81	4.55	6.30	6.45 5.90	148100	100200

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

* Inch standard hex.

- GENERAL NOTES:
- Head edge out of roundness shall not exceed "F."
 - Concentricity: Conical surface of head to "D" diameter within 0.08 FIR.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ISO/R468.
 - Use HLM321 for oversize replacement.
 - Curved or flat edge manufacturer's option.

MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626 or MIL-S-6049.

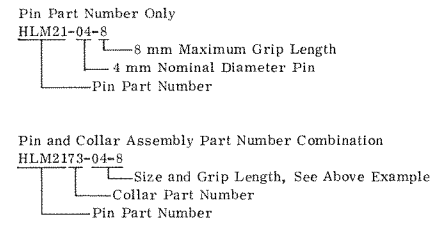
HEAT TREAT: 655 N/mm² shear minimum per Spec. MIL-H-6875.

FINISH: HLM21-()-() = Cadmium plate per Spec. QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLM21PB-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Product Specification No. 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
EXAMPLES:



U.S. patents 3,390,906, and foreign patents. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.

DRAWN	DATE	hi-lok ® PIN (METRIC SERIES) 100° FLUSH TENSION HEAD ALLOY STEEL 1 mm GRIP VARIATION
D. P. S.	6-10-83	
APPROVED	DATE	DRAWING NUMBER
<i>R. Long</i>	6-14-83	
REVISION	DATE	HLM21

HLM21