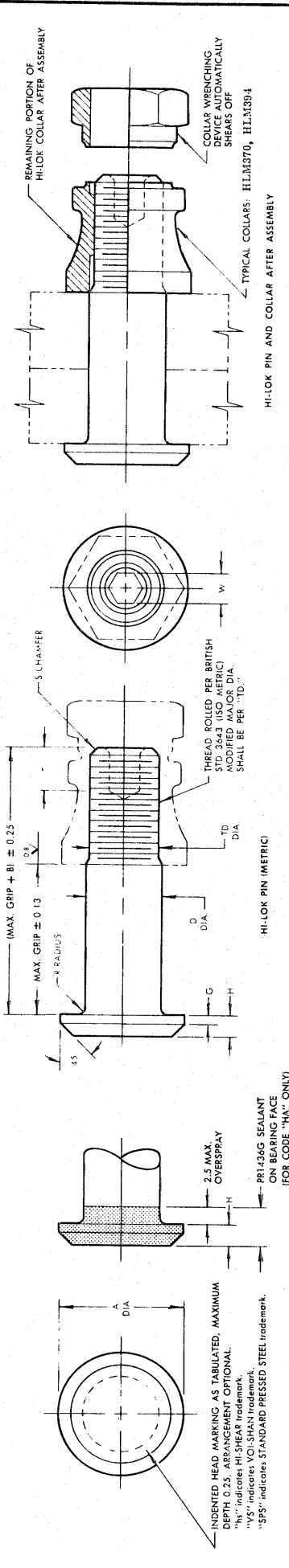


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197
AMCRAFT FASTENERS (Formed Parts), LTD. (Licensee) U.S. Federal Code I.D. No. 80516
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee) U.S. Federal Code I.D. No. 80516
SPS TECHNICAL PRODUCTS, U.S.A. (Licensee) U.S. Federal Code I.D. No. 80516
LITTON FASTENERS SYSTEMS, U.S.A. (Licensee) U.S. Federal Code I.D. No. 80516
Division of Litton Systems Inc., U.S.A. (Licensee) U.S. Federal Code I.D. No. 80516



SEE COLLAR STANDARDS FOR COLLAR STRENGTH, COLLAR STRENGTH PIN OR COLLAR DETERMINES SYSTEM STRENGTH.

FIRST DASH NO.	HEAD MARKING	NOM. DIA.	A DIA.	B	C	D DIA.	G REF.	H REF.	R RAD.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET		DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
												W HEX.	T DEPTH		
-04	HLM310M4	4.5	6.65	9.0	4.490	4.478	0.6	0.95	0.40	0.8 x 37°	M4 x 0.7-4h	1.64	2.20	20800	7800
-05	HLM310M5	5.5	8.15	9.4	5.490	5.478	0.8	1.40	0.40	0.8 x 37°	M5 x 0.8-4h	2.05	2.55	31100	11800
-06	HLM310M6	6.5	10.20	11.7	6.490	6.478	0.9	1.75	0.40	0.8 x 37°	M6 x 1.0-4h	2.46	2.25	43500	18200
-08	HLM310M8 x 1	8.5	12.85	14.0	8.487	8.472	1.0	2.20	0.50	1.2 x 37°	M8 x 1.0-4h	3.25	3.35	74300	31600
-10	HLM310M10 x 1	10.5	16.20	16.2	10.487	10.472	1.3	2.65	0.50	1.2 x 37°	M10 x 1.0-4h	4.11	4.35	118400	48900
-12	HLM310M12 x 1.25	12.5	18.80	19.4	12.484	12.466	1.5	2.95	0.75	1.2 x 37°	M12 x 1.25-4h	4.80	5.10	160800	66700

HI-LOK PIN AND COLLAR AFTER ASSEMBLY

CODE: First dash number indicates nominal diameter in 1 mm which HLM310 oversize pin replaces. Second dash number indicates maximum grip in 1 mm. See "Finish" note for explanation of code letters.

HOW TO ORDER EXAMPLES:
 Pin Part Number Only
 HLM310-04-8
 8 mm Maximum Grip Length
 Replaces 4 mm Nominal Diameter Pin
 Pin Part Number
 Pin and Collar Assembly, Part Number Combination
 HLM310370-04-8
 Size and Grip Length. See Above Example
 Collar Part Number
 Pin Part Number

GENERAL NOTES:
 1. Concentricity: Head to "D" diameter within 0.25 FIR.
 2. Surface texture to be met after finish.
 3. Dimensions to be met after finish.
 4. Use HLM610 for oversize replacement.

MATERIAL:
 6AL-4V titanium alloy per Spec. AMS4928 or AMS1967 for all sizes.
 6AL-6V-2Sn titanium alloy per Spec. AMS4971 is acceptable for -10 size and larger.

HEAT TREAT:
 665 MPa shear minimum.

FINISH:
 HLM310-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet (equivalent to LNS368 Blatt 4), and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLM310AP-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLM310HA-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and apply precoat No. PRL436G sealant (.051-.127 mm thick) plus cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Product Specification No. M342.

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

hi-lok® PIN (METRIC SERIES)
 PROTRUDING SHEAR HEAD
 TITANIUM
 1 mm GRIP VARIATION
 0.3 mm OVERSIZE

DRAWN DATE: D.P.S. 10-15-79
 APPROVED DATE: 12/15/75
 REVISION DATE: D.P.S. 5-21-82
 DRAWING NUMBER: **HLM310**