



HI-LOK PIN AND COLLAR AFTER ASSEMBLY

HI-LOK PIN (METRIC)

FIRST DASH NO.	HEAD MARKING	NOAL. DIA.	A DIA.	B REF.	D DIA. WITHOUT SOLID FILM DIA. WITH SOLID FILM DIA.	TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD (MODIFIED)	W HEX	T DEPTH	SOCKET	DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
-04	HLM341M4	4.5	6.99	9.0	4.478	4.465	3.86	0.11	0.99	0.40	0.25	0.8 x 45°	1.64	2.05	20800	6200	
-05	HLM341M5	5.5	8.35	9.4	5.490	5.490	4.90	0.13	1.20	0.75	0.38	0.8 x 45°	2.05	2.55	31100	9300	
-06	HLM341M6	6.5	10.18	11.7	6.490	6.490	5.88	0.16	1.55	0.75	0.38	0.8 x 45°	2.46	2.80	43500	14700	
-08	HLM341M8 x 1	8.5	13.23	14.0	8.487	8.487	7.88	0.18	1.99	1.00	0.38	1.2 x 45°	3.29	3.35	74300	24400	
-10	HLM341M10 x 1	10.5	16.18	16.2	10.487	10.487	9.88	0.21	2.39	1.00	0.38	1.2 x 45°	4.11	4.35	113400	37800	
-12	HLM341M12 x 1.25	12.5	18.78	19.4	12.484	12.484	11.87	0.23	2.70	1.25	0.56	1.2 x 45°	4.90	5.10	160800	52000	

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH SYSTEM STRENGTHS DETERMINES.

GENERAL NOTES:

- Head edge out of roundness shall not exceed "F".
- Concentricity: Conical surface of head to "D" diameter within 0.13 FIR.
- "H" is dimensioned from maximum "D" diameter.
- Dimensions to be met after finish.
- Surface texture per ISO/DR221.
- Curved or flat edge manufacturer's option.
- Use HLM641 for oversize replacement.

CODE: First dash number indicates nominal diameter in 1 mm which HLM341 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
HLM341-04-5
8 mm Maximum Grip Length
Replaces 4 mm Nominal Diameter Pin
Pin Part Number

MATERIAL: A-286 high temperature alloy per Spec. AMS5737 or AMS5731.

HEAT TREAT: 655 N/mm² shear minimum at room temperature.

FINISH: HLM341-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM341TF-()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.

SPECIFICATION: Hi-Lok Product Specification No. M342.

U.S. Patent: 2,882,773; 2,927,491; 2,949,495; 3,027,789; 3,138,987; design patent 1,911,883, after U.S. and Foreign patents granted and pending. Hi-Shear Corporation, "Hi-Lok" and "Hi" are Registered Trademarks of Hi-Shear Corporation.

DATE: 1-25-77
APPROVED: [Signature]
REVISION: [Signature]

Hi-Lok® PIN (METRIC SERIES)
100° FLUSH SHEAR HEAD
A-286 HIGH TEMPERATURE ALLOY
1 mm GRIP VARIATION
0.5 mm OVERSIZE

DRAWING NUMBER: **HLM341**