



HI-LOK PIN (METRIC)

HI-LOK PIN AND COLLAR AFTER ASSEMBLY

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
					WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE	W HEX.								T DEPTH			
-04	HLM41M4	4	6.49 6.35	8.35	3.990 3.978	3.990 3.965	3.91 3.86	0.11	1.05 0.99	0.65 0.40	0.25	0.8 x 45°	M4 x 0.7-4h	1.64 1.61	2.05 1.65	16400	6200	
-05	HLM41M5	5	7.85 7.71	8.65	4.990 4.978	4.990 4.965	4.90 4.84	0.13	1.20 1.14	0.75 0.50	0.38	0.8 x 45°	M5 x 0.8-4h	2.05 2.01	2.55 2.00	25700	9300	
-06	HLM41M6	6	9.68 9.54	10.70	5.990 5.978	5.990 5.965	5.88 5.81	0.16	1.55 1.49	0.75 0.50	0.38	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	37000	14700	
-08	HLM41M8 x 1	8	12.73 12.59	12.95	7.987 7.972	7.987 7.962	7.88 7.80	0.18	1.99 1.93	1.00 0.75	0.38	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	65800	24400	
-10	HLM41M10 x 1	10	15.68 15.54	15.20	9.987 9.972	9.987 9.962	9.88 9.80	0.21	2.39 2.33	1.00 0.75	0.38	1.2 x 45°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	102900	37800	
-12	HLM41M12 x 1.25	12	18.42 18.28	18.15	11.984 11.966	11.984 11.969	11.87 11.76	0.23	2.70 2.64	1.25 1.00	0.56	1.2 x 45°	M12 x 1.25-4h	4.90 4.81	5.10 4.55	148100	52000	

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

- 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 HLM341 for oversize replacement.

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:

Pin Part Number Only
HLM41-04-8
8 mm Maximum Grip Length
4 mm Nominal Diameter Pin
Pin Part Number

* INCH STANDARD HEX.

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

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

FINISH: HLM41-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM41TF-()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.

SPECIFICATION: Hi-Lok Product Specification No. M342.

Pin and Collar Assembly Part Number Combination
HLM4170-04-8
Size and Grip Length,
See Above Example
Collar Part Number
Pin Part Number

U.S. patents 2,882,773; 2,927,491; 2,940,495; 3,027,789; 3,138,987, design patent 191,883; other U.S. and Foreign patents granted and pending; property of Hi-Shear Corporation. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.	
DRAWN DATE D. P. S. 1-25-77	hi-lok® PIN (METRIC SERIES) 100° FLUSH SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1 mm GRIP VARIATION
APPROVED DATE R. Lopez 1-25-77	
REVISION DATE	DRAWING NUMBER HLM41

HLM41