

HI-LOK PIN (METRIC)

HI-LOK PIN AND COLLAR AFTER ASSEMBLY

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH COLLARS ARE AVAILABLE. DETERMINES SYSTEM STRENGTH.

FIRST DASH NO.	HEAD MARKING	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	H	R RAD.	Z	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET		DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
													* W HEX.	T DEPTH		
-04	HLM411M4	4	7.31	8.35	3.990	3.91	0.11	1.39	0.65	0.25	0.8 x 37°	M4 x 0.7-4h	1.64	2.05	16400	8000
-05	HLM411M5	5	7.17	8.65	4.990	4.90	0.13	1.33	0.40	0.13	0.8 x 37°	M5 x 0.8-4h	1.61	1.65	25700	12500
-06	HLM411M6	6	9.11	8.97	4.978	4.84	0.13	1.67	0.50	0.13	0.8 x 37°	M6 x 1.0-4h	2.05	2.55	37000	18500
-08	HLM411M8 x 1	8	11.39	10.70	5.990	5.88	0.16	2.27	0.75	0.38	1.2 x 37°	M8 x 1.0-4h	2.46	2.80	65800	33200
-10	HLM411M10 x 1	10	14.40	12.95	7.972	7.80	0.18	2.63	0.75	0.13	1.2 x 37°	M10 x 1.0-4h	3.25	3.35	102900	52900
-12	HLM411M12 x 1.25	12	18.84	15.20	9.972	9.80	0.21	3.72	1.00	0.38	1.2 x 37°	M12 x 1.0-4h	4.11	4.35	148100	76100

- 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 before finish.
 - Surface texture per ISO/DR221.
 - Use HLM511 for oversize replacement.

MATERIAL: 6Al-4V titanium alloy per Spec. AMS4928 or AMS4967.

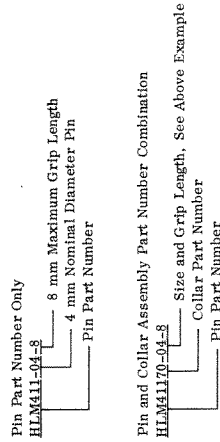
HEAT TREAT: 655 N/mm² shear minimum.

FINISH: HLM411-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet (equivalent to IN9368 Blatt 4), and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM411FM-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet, and M88 solid film lubricant (0.003 mm minimum thickness).

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:



* INCH STANDARD HEX.

U.S. patent 2,882,773; 2,927,491; 2,940,495; 3,027,789; 3,138,987; design patent 1,91,883; other U.S. and foreign patents granted and pending; property of Hi-Shear Corporation. "Hi-Lok" and "Hi-" are registered trademarks of Hi-Shear Corporation.

DRAWN	DATE	1/4N	5-5-77
APPROVED	DATE	AS	5-16-72
REVISION	DATE	1	1-16-73
DRAWING NUMBER		HLM411	
PIN (METRIC SERIES)		100° FLUSH MEDIUM HEAD	
TITANIUM		1 mm GRIP VARIATION	