



HI-LOK PIN (METRIC)

HI-LOK PIN AND COLLAR AFTER ASSEMBLY

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

FIRST DASH NO.	HEAD MARKING	NON. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	H	R RAD.	Z	5 CHAMFER REF.	THREAD (MODIFIED)	SOCKET		DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
													* W HEX.	T DEPTH		
-04	HLM419M4	4	7.31	7.17	3.930	3.91	0.11	1.33	0.65	0.23	0.8 x 45°	M4 x 0.7-4h	1.64	2.05	16400	8000
-05	HLM419M5	5	9.11	8.97	4.930	4.90	0.13	1.73	0.75	0.38	0.8 x 45°	M5 x 0.8-4h	2.05	2.55	25700	12500
-06	HLM419M6	6	11.39	11.25	5.930	5.88	0.16	2.27	0.75	0.38	0.8 x 45°	M6 x 1.0-4h	2.46	2.90	37000	18500
-08	HLM419M8 x 1	8	14.40	14.26	7.987	7.88	0.18	2.69	1.00	0.38	1.2 x 45°	M8 x 1.0-4h	3.29	3.33	65800	33200
-10	HLM419M10 x 1	10	18.84	18.70	10.962	10.80	0.21	3.72	1.00	0.38	1.2 x 45°	M10 x 1.0-4h	4.11	4.35	102900	52900
-12	HLM419M12 x 1.25	12	21.83	21.69	13.984	13.87	0.23	4.13	1.25	0.56	1.2 x 45°	M12 x 1.25-4h	4.90	5.10	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 after finish.
 - Surface texture per ISO/DR221.
 - Use HLM4519 for oversize replacement.

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: HLM419-()-() = Cadmium plate per Spec. QQ-P-416, Type I, Class 3, and cetyl alcohol tube per Hi-Shear Spec. 305.
HLM419PB-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 3, and cetyl alcohol tube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Product Specification 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:

Pin Part Number Only
HLM419-04-3
 8 mm Maximum Grip Length
 4 mm Nominal Diameter Pin
 Pin Part Number

Pin and Collar Assembly Part Number Combination
HLM41970-04-3
 Size and Grip Length, See Above Example
 Collar Part Number
 Pin Part Number

* INCH STANDARD HEX.
U.S. patents 2,882,773; 2,927,401; 2,940,495; 3,037,789; 3,138,987; design patent 191,883; other U.S. and Foreign patents granted and pending, property of Hi-Shear Corporation. "Hi-Lok" and "H" are Registered Trademarks of Hi-Shear Corporation.

DATE	5-15-72
APPROVED	[Signature]
REVISION	1
DRAWING NUMBER	HLM419
100° FLUSH MEDIUM HEAD	
1 mm GRIP VARIATION	
ALLOY STEEL	
hi-Lok® PIN (METRIC SERIES)	