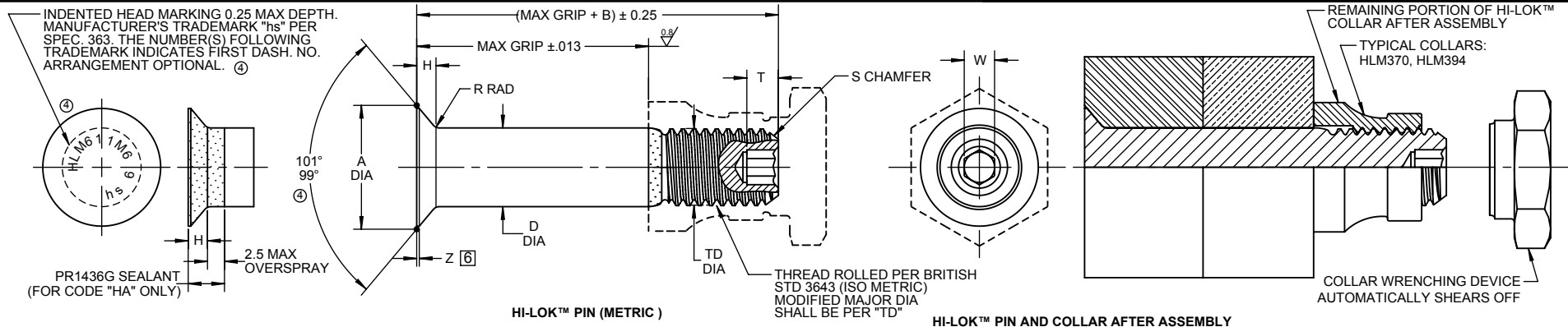




1																		6																	
FIRST DASH NO.	HEAD MARKING	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET		DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTON MINIMUM																		
					HLM611	HLM611AP AND HLM611HA								W HEX	T DEPTH MIN																				
04	HLM11M5	5			NOTE: Use HLM11-05 (See HLM11 Sales Drawing for Collar Selection)																														
05	HLM11M6	6			NOTE: Use HLM11-06 (See HLM11 Sales Drawing for Collar Selection)																														
06	HLM611M6	7	10.68 10.54	11.7	6.990 6.978	6.990 6.965	5.88 5.81	0.16	1.55 1.49	0.75 0.50	0.38	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	50400	14700																		
08	HLM611M8 X 1	9	13.73 13.59	14.0	8.987 8.972	8.987 8.962	7.88 7.80	0.18	1.99 1.93	1.00 0.75	0.38	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	83300	24400																		
10	HLM611M10 X 1	11	16.68 16.54	16.2	10.987 10.972	10.987 10.962	9.88 9.80	0.21	2.39 2.33	1.00 0.75	0.38	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	124500	37800																		
12	HLM611M12 X 1.25	13	19.42 19.28	19.4	12.984 12.966	12.984 12.959	11.87 11.76	0.23	2.70 2.64	1.25 1.00	0.56	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	5.10 4.55	173900	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.
 - Surface texture per ISO/DR221.
 - Dimensions are in millimeters and to be met after finish.
 - Curved or flat edge manufacturer's option.
 - After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: 6AL-4V titanium alloy per Spec. AMS4928 or AMS4967 for all sizes. 6AL-6V-2SN titanium alloy per Spec. AMS4971 is acceptable for -10 size and larger.

HEAT TREAT: 655 MPa shear minimum.

- FINISH:** HLM611-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet (equivalent to LN9368 Blatt 4), and cetyl alcohol lube per Hi-Shear Spec. 305.
- ④ ⑦ HLM611AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
- ④ ⑦ HLM611HA()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and apply precoat No. PR1436G sealant (.051-.127 mm thick) plus and cetyl alcohol lube per Hi-Shear Spec. 305.

CODE: First dash number indicates nominal diameter in 1 mm. which HLM611 oversize pin replaces. Second dash number indicates maximum grip in 1 mm. See Finish note for explanation of code letters.

HOW TO ORDER
④ **EXAMPLE:**

Pin Part Number
HLM611AP-04-8
8 mm Maximum Grip Length
4 mm Nominal Diameter Pin
Finish Code
Pin Basic Part Number

Pin and Collar Assembly Part Number combination
HLM611370-04-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

* INCH STANDARD HEX.

** The Double shear values shown are based on cross sectional area for nominal diameter pin.

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY D.P.S.	DATE 1975-10-15	TITLE HI-LOK™ PIN (METRIC SERIES) 100° FLUSH SHEAR HEAD TITANIUM 1 mm GRIP VARIATION 1 mm OVERSIZE
APPROVED R. TING	DATE 1975-12-15	
REVISION ④	DATE K. TRAN 2017-12-06	DRAWING NUMBER HLM611