



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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 NEWTONS MINIMUM
					HLM613	HLM613AP HLM613AU AND HLM613HA								W HEX	T DEPTH		
04	HLM13M5	5				NOTE: Use HLM13-05 (See HLM13 Sales Drawing for Collar Selection)											
05	HLM13M6	6				NOTE: Use HLM13-06 (See HLM13 Sales Drawing for Collar Selection)											
06	HLM613M6	7	13.13 12.99	11.7	6.990 6.978	6.990 6.965	5.88 5.81	0.16	2.58 2.52	0.75 0.50	0.38	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	50400	22200
08	HLM613M8 x 1	9	17.13 16.99	14.0	8.978 8.972	8.987 8.962	7.88 7.80	0.18	3.42 3.36	1.00 0.75	0.38	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	83300	42000
10	HLM613M10 x 1	11	21.13 20.99	16.2	10.987 10.972	10.987 10.962	9.88 9.80	0.21	4.26 4.20	1.00 0.75	0.38	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	124500	68000
12	HLM613M12 x 1.25	12	25.13 24.99	19.4	12.984 12.966	12.984 12.959	11.87 11.76	0.23	5.10 5.04	1.25 1.00	0.56	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	5.10 4.55	173900	100200

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

- GENERAL NOTES:**
- [1] Head edge out of roundness shall not exceed "F".
 2. Concentricity: Conical surface of head to "D" diameter within .08 FIM.
 3. "H" is dimensioned from maximum "D" diameter.
 4. Surface texture per ISO/R468.
 5. Dimensions are in millimeters and to be met after finish.
 - [6] Curved or flat edge manufacturer's option.
 - [7] After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

CODE: First dash number indicates nominal diameter in 1 mm.
Which HLM613 oversize pin replaces.
Second dash number indicates maximum grip in 1 mm.
See Finish note for explanation of code letters.

HOW TO ORDER
EXAMPLE:

Pin Part Number
HLM613AP04-8
└── 8 mm Maximum Grip Length
└── 4 mm Nominal Diameter Pin
└── Finish Code
└── Pin Basic Part Number

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

HEAT TREAT: 655 MPa shear minimum.

FINISH: HLM613-()-() = 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.

[7] HLM613AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.

HLM613AU()-() = Solid film lube per "Electrofilm" XSF-104.

[7] HLM613HA()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and apply precoat No. PR1436G sealant (.051-.127 mm thick) plus cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ Product Specification M342.

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY VAN	DATE 1977-05-17	TITLE HI-LOK™ PIN (METRIC SERIES) 100° FLUSH TENSION HEAD TITANIUM 1 mm GRIP VARIATION, 1 mm OVERSIZE
APPROVED R. TING	DATE 1977-05-19	
REVISION 5	DATE F. CARINGELLA 2017-10-23	DRAWING NUMBER HLM613 1 OF 1