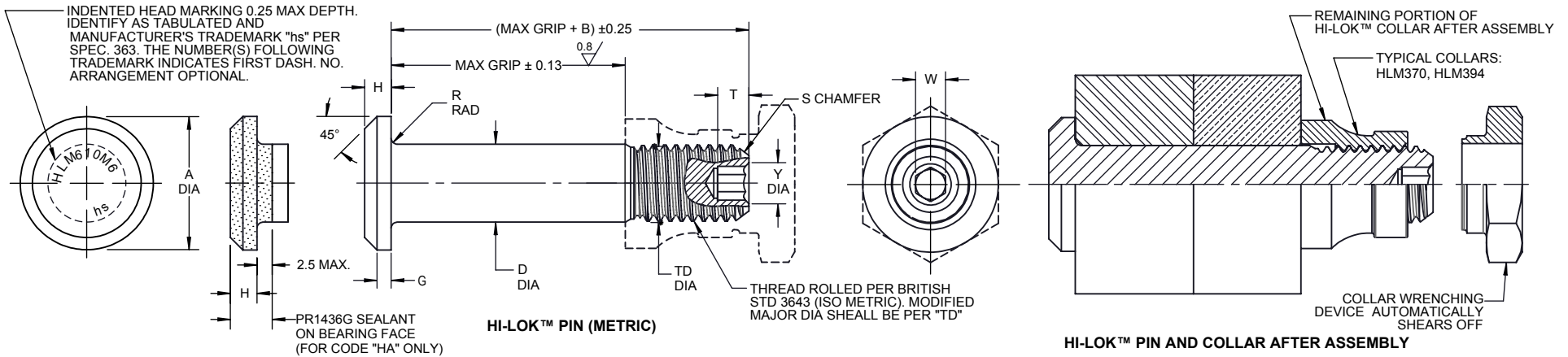




FIRST DASH NO.	MARKING	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					HLM610	HLM610AP AND HLM610HA							W HEX	T DEPTH	Y DIA		
04	HLM10M5	5			NOTE: Use HLM10-05 (See HLM10 Sales Drawing for Collar Selection)												
05	HLM10M6	6			NOTE: Use HLM10-06 (See HLM10 Sales Drawing for Collar Selection)												
06	HLM610M6	7	10.70 10.20	11.7	6.990 6.978	6.990 6.965	5.88 5.81	0.9	1.75 1.50	0.65 0.40	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	3.60 3.10	50400	18200
08	HLM610M8 X 1	9	13.35 12.75	14.0	8.987 8.972	8.987 8.962	7.88 7.80	1.0	2.20 1.95	0.75 0.50	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	4.60 4.05	83300	31600
10	HLM610M10 X 1	11	16.70 15.90	16.2	10.987 10.972	10.987 10.962	9.88 9.80	1.3	2.65 2.40	0.75 0.50	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	5.55 5.00	124500	48900
12	HLM610M12 X 1.25	13	19.30 18.50	19.4	12.984 12.966	12.984 12.959	11.87 11.76	1.5	2.95 2.70	0.75 0.50	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	5.10 4.55	6.45 5.90	173900	66700

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

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within 0.25 FIM.
- Dimensions are in millimeters and to be met after finish.
- Surface texture per ISO/R468.
- Oversize Replacement Pin for HLM310 and HLM10.
- 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.

MATERIAL:

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

HEAT TREAT:

655 MPa shear minimum.

FINISH:

- ⓈHLM610-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet (equivalent to LN9368 Blatt 4), plus cetyl alcohol lube per Hi-Shear Spec. 305.
- Ⓢ HLM610AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
- Ⓢ HLM610HA()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, apply precoat No. PR1436G sealant (.051-.127mm thick), plus cetyl alcohol lube per Hi-Shear Spec. 305.

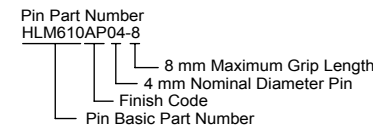
SPECIFICATION:

HI-LOK™ Product Specification M342.

CODE:

First dash number indicates nominal diameter in 1 mm. which HLM610 oversize pin replaces.
 Second dash number indicates maximum grip in 1 mm.
 See Finish note for explanation of code letters.

**HOW TO ORDER
 EXAMPLE:**



"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) PROTRUDING SHEAR HEAD TITANIUM 1 mm GRIP VARIATION, 1 mm OVERSIZE
APPROVED R. TING	DATE 1975-12-15	
REVISION 6	DATE S. KARNO 2018-08-28	DRAWING NUMBER HLM610 1 OF 1