



FIRST DASH NO.	HEAD MARKING	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
					HLM612	HLM612AP HLM612AU AND HLM612HA							* W HEX	T DEPTH		
04	HLM12M5	5			NOTE: Use HLM12-05 (See HLM12 Sales Drawing for Collar Selection)											
05	HLM12M6	6			NOTE: Use HLM12-06 (See HLM12 Sales Drawing for Collar Selection)											
06	HLM612M6	7	11.90 11.40	11.7	6.990 6.978	6.990 6.965	5.88 5.81	1.3	2.30 2.05	0.65 0.40	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	50400	22200
08	HLM612M8 X 1	9	13.85 13.25	14.0	8.987 8.972	8.987 8.962	7.88 7.80	1.6	3.05 2.80	0.75 0.50	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	83300	42000
10	HLM612M10 X 1	11	17.20 16.40	16.2	10.987 10.972	10.987 10.962	9.88 9.80	1.9	3.75 3.50	0.75 0.50	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	124500	68000
12	HLM612M12 X 1.25	13	19.80 19.00	19.4	12.984 12.966	12.984 12.959	11.87 11.76	2.3	4.45 4.20	0.75 0.50	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	5.10 4.55	173900	100200

GENERAL NOTES:

- Concentricity: Head to "D" diameter within 0.25 FIR.
- Surface texture per ISO/DR221.
- Dimensions are in millimeters and to be met after finish.
- 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: HLM612-()-() = 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 HLM612AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.

HLM612AU()-() = Solid film lube per "ELECTROFILM" XSF-104.

④ HLM612HA()-() = 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.

CODE: First dash number indicates nominal diameter in 1 mm. which HLM612 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
HLM612AU-08-8
 — 8 mm Maximum Grip Length
 — Replaces 8 mm Nominal Diameter Pin
 — Finish Code
 — Pin Basic Part Number

Pin and Collar Assembly Part Number combination
HLM612386-08-8

— 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 1977-05-17	TITLE HI-LOK™ PIN (METRIC SERIES) PROTRUDING TENSION HEAD TITANIUM 1 mm GRIP VARIATION- 1 mm OVERSIZE
APPROVED R. TING	DATE 1977-05-19	
REVISION ④	DATE K. TRAN 2017-12-06	DRAWING NUMBER HLM612 1 OF 1