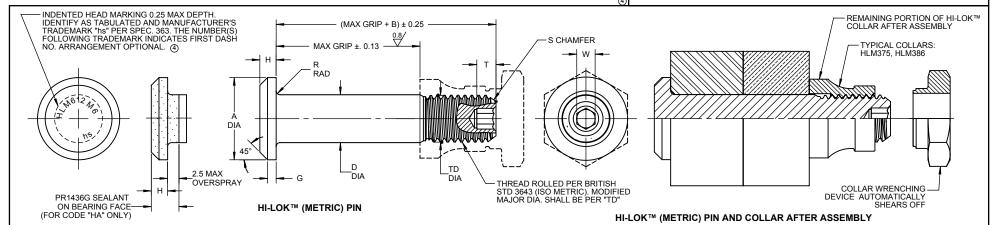
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FIRST DASH NO.	HEAD MARKING	NOM DIA	<b>A</b> DIA	<b>B</b> REF	<b>D</b> DIA								SOCKET		DOUBLE	TENSION
					HLM612	HLM612AP HLM612AU AND HLM612HA	T <b>D</b> DIA	<b>G</b> REF	Н	R RAD	S CHAMFER REF	THREAD MODIFIED	* W HEX	T DEPTH	SHEAR NEWTONS MINIMUM	NEWTONS MINIMUM
04	HLM12M5	5			NOTE: Use HLM12-05 (See HLM12 Sales Drawing for Collar Seclection)											
05	HLM12M6	6			NOTE: Use HLM12-06 (See HLM12 Sales Drawing for Collar Seclection)											
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

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

**GENERAL NOTES:** 

- 1. Concentricity: Head to "D" diameter within 0.25 FIR.
- 2. Surface texture per ISO/DR221.3. Dimensions are in millimeters and to be met after finish.
- ④ 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.

(a) 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.

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

**(4) EXAMPLE:** Pin Part Number HLM612AU-08-8

<sup>1</sup>—8 mm Maximum Grip Length -Replaces 8 mm Nominal Diameter Pin -Finish Code

Pin Basic Part Number

\* Inch standard hex

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

-Size and Grip Length, See Above Example

Collar Part Number Pin Part Number

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	DATE	TITLE			
D.P.S.	1977-05-17	HI-LOK™ PIN (METRIC SERIES) PROTRUDING TENSION HEAD			
APPROVED	DATE	TITANIUM			
R. TING	1977-05-19	1 mm GRIP VARIATION- 1 mm OVERSIZ			
		TIIIII GRIF VARIATION-TIIIII OVERSIZE			
DEVISION	DATE	DRAWING NUMBER			

K. TRAN 2017-12-06

**HLM612** 

1 OF 1

SPECIFICATION: HI-LOK™ Product Specification M342.