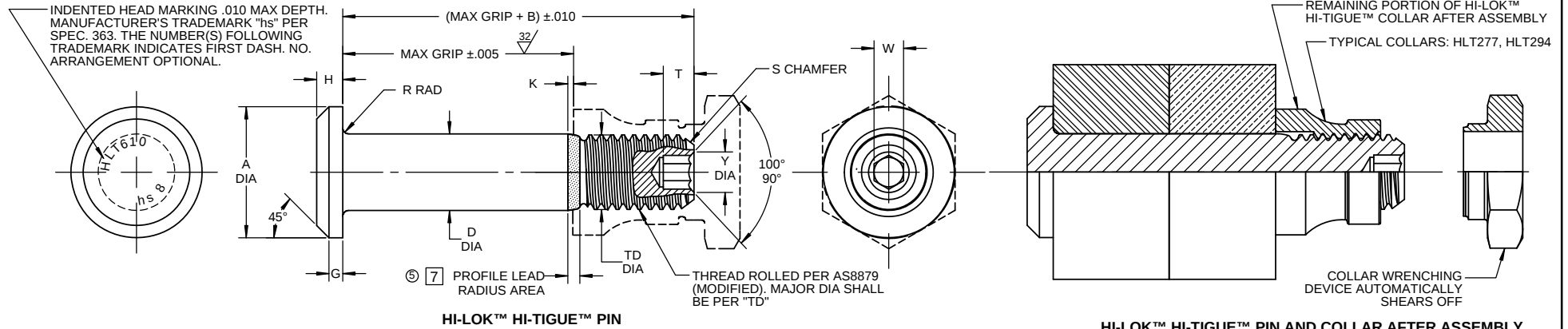


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SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	K REF	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING	WITH COATING								W HEX	T DEPTH	Y DIA		
5				NOTE: USE HLT310()6-(), HLT334()6-() or HLT450()6-()													
6	13/64	.315 .295	.360	.2026 .2021	.2026 .2016	.1840 .1810	.025	.055 .045	.020	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,130	2,500
8	17/64	.412 .387	.435	.2651 .2646	.2651 .2641	.2440 .2410	.030	.069 .059	.025	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	10,490	4,300
10	21/64	.505 .475	.545	.3276 .3271	.3276 .3266	.3060 .3020	.035	.078 .068	.031	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	16,000	6,300
12	25/64	.600 .565	.590	.3901 .3896	.3901 .3891	.3680 .3640	.040	.088 .078	.037	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	22,700	8,700
14	29/64	.676 .641	.690	.4526 .4521	.4526 .4516	.4310 .4260	.045	.105 .093	.039	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	30,600	12,100
16	33/64	.770 .735	.740	.5151 .5146	.5151 .5141	.4930 .4880	.050	.116 .103	.045	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	39,600	15,300
18	37/64	.864 .829	.825	.5771 .5766	.5771 .5761	.5550 .5500	.055	.127 .112	.043	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	49,700	19,000
20	41/64	.953 .918	.890	.6396 .6391	.6396 .6386	.6180 .6120	.060	.137 .122	.045	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	61,000	23,000
24	49/64	1.108 1.066	1.115	.7646 .7641	.7646 .7636	.7430 .7370	.070	.151 .136	.045	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	87,200	30,700

"HI-LOK", "HI-TIGUE", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY D.P.S.	DATE 1977-05-11	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING SHEAR HEAD TITANIUM
APPROVED R. TING	DATE 1977-05-12	
REVISION ⑤	DATE M.BEARD 2017-07-20	DRAWING NUMBER HLT610
		1 OF 2

- GENERAL NOTES:**
- 1. Concentricity: "A" to "D" diameter within .010 FIM.
 - ⑤ 2. Dimensions are in inches and to be met after finish.
 - ⑤ 3. Surface texture per ASME B46.1.
 - 4. Hole preparation per NAS618.
 - 5. Use HLT710 for oversize replacement.
 - ⑥ 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 per Hi-Shear Spec. 294 on fasteners coated in European Union.
 - ⑤ ⑦ This area has a special profile lead radius instead of the HI-TIGUE™ feature.

MATERIAL: 6Al-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

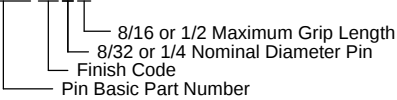
- FINISH:**
- HLT610()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑥ HLT610AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑥ HLT610AZ()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, black identification on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑥ HLT610FD()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, red identification on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT610FE()-() = Grit blast top of head, cetyl alcohol lube per Hi-Shear Spec. 305, and red identification on thread end.
 - HLT610FH()-() = Cetyl alcohol lube per Hi-Shear Spec. 305, and red identification on thread end.
 - HLT610YT()-() = Grit blast top of head, color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ HI-TIGUE™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT610 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER

⑤ **EXAMPLE:** Pin Part Number
HLT610AP8-8



HLT610

DRAWING NUMBER

HLT610

2 OF 2