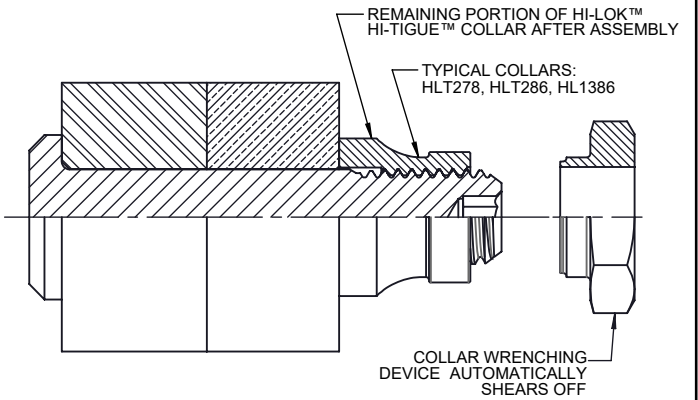
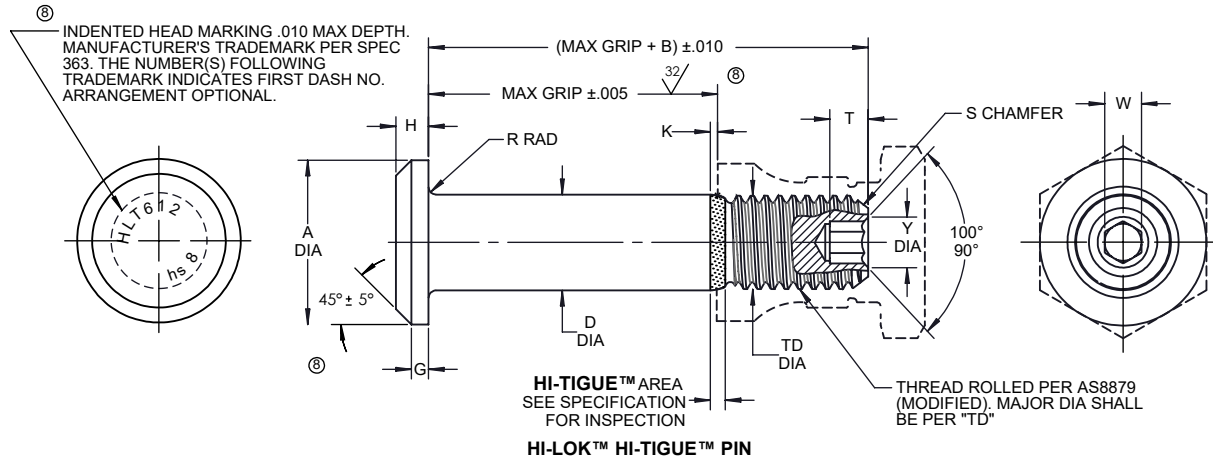




FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	K REF	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING, S.F.L.	WITH COATING, S.F.L.								W HEX	T DEPTH	Y DIA		
5				NOTE: USE HLT336()6-() OR HLT452()6-()													
6	13/64	.377 .357	.360	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.020	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,130	2,750
8	17/64	.440 .415	.435	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .080	.025	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	10,490	5,820
10	21/64	.505 .475	.545	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .102	.031	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	16,000	9,200
12	25/64	.600 .565	.590	.3901 .3896	.3901 .3891	.3680 .3640	.075	.140 .130	.037	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	22,700	14,000
14	29/64	.676 .641	.690	.4526 .4521	.4526 .4516	.4310 .4260	.095	.160 .150	.039	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	30,600	18,900
16	33/64	.770 .735	.740	.5151 .5146	.5151 .5141	.4930 .4880	.095	.188 .178	.045	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	39,600	25,500
18	37/64	.877 .842	.825	.5771 .5766	.5771 .5761	.5550 .5500	.125	.210 .200	.043	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	49,700	32,400
20	41/64	.953 .918	.890	.6396 .6391	.6396 .6386	.6180 .6120	.140	.238 .228	.045	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	61,000	41,000
24	49/64	1.150 1.110	1.115	.7646 .7641	.7646 .7636	.7430 .7370	.200	.335 .320	.045	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	87,200	59,500

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

"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 TENSION HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED R.TING	DATE 1977-05-12	
REVISION 8	DATE A.CHAE 2022-09-29	DRAWING NUMBER HLT612

GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions are in inches and to be met after finish.
 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 5. Use HLT712 for oversize replacement.
 [6] Broach petals removed.

⑤ [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 the UK and European Union.

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

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).

FINISH: HLT612(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.

⑤ [7] HLT612AP(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

⑤ [7] HLT612FD(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, red identification on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT612FE(-)(-) = Grit blast top of head, with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT612FH(-)(-) = Red identification on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT612FU(-)(-) = Grit blast top of head, HI-KOTE™ 2 solid film lube on threads only per Hi-Shear Spec. 292, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

⑤ [7] HLT612KM(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

[6] HLT612MA(-)(-) = Solid film lube per Kal-Gard RA.

HLT612ST(-)(-) = Grit blast top of head, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT612HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

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

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT612 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER

EXAMPLE:

Pin Part Number
 HLT612AP8-8

8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

HLT612

DRAWING NUMBER

HLT612

2 OF 2