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GP™

ENGINEERING  
 STANDARD

THIS DRAWING, THE STRUCTURAL DESIGN DISCLOSED THEREIN AND THE TECHNICAL DATA AND ENGINEERING SERVICE REPRESENTED THEREBY ARE THE EXCLUSIVE PROPERTY OF HUCK INTERNATIONAL INCORPORATED.

FINISH: SUFFIX "ACH" = ALUMINUM COAT (HI-KOTE 1) PER NAS4006 WITH ORANGE COLOR ON PIN PLUS CETYL ALCOHOL LUBE PER MIL-L-87132.

SUFFIX "EG" = LUBRICATION PER MCDONNELL DOUGLAS SPECIFICATION 23D0002. IDENTIFIED WITH ORANGE DYE OR PAINT ON END OF STUMP. ALL DIMENSIONS PRIOR TO LUBE.

HEAD MARKING: HEADS SHALL BE MARKED WITH THE MANUFACTURER'S BASIC SYMBOL, BASIC NUMBER (GP6) AND MATERIAL DESIGNATOR (V), DEPRESSED .006 MAX. ARRANGEMENT OPTIONAL. FOR STUMPS WITH A SEALANT ESCAPE GROOVE AND (H) MARK WILL BE INCLUDED.

CODING: THE FIRST SET OF LETTERS DESIGNATE THE FAMILY OF GROOVE PROPORTIONED GP STUMPS FOR AEROSPACE APPLICATIONS (GPS).

THE SECOND SET OF LETTERS & NUMBER (6TC) DESIGNATE HEAD SIZE, STYLE, AND LOAD APPLICATION.

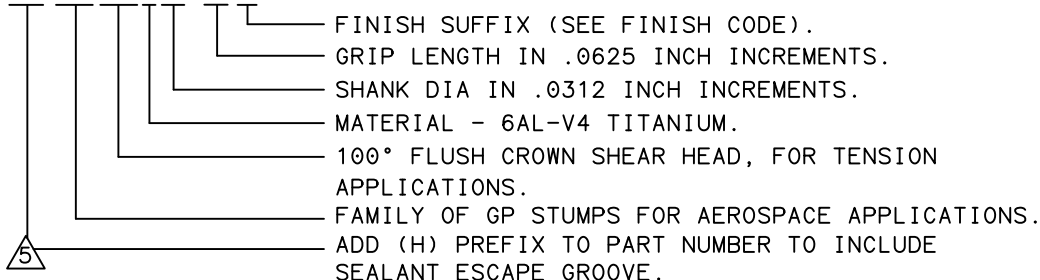
THE NEXT LETTER (V) IS THE MATERIAL DESIGNATOR FOR 6AL-4V TITANIUM ALLOY, MIN SHEAR STRENGTH: 95 KSI.

THE NUMBERS FOLLOWING THE MATERIAL DESIGNATE THE NOMINAL PIN SHANK DIAMETER IN .0312 INCH INCREMENTS.

THE FINAL NUMBER(S) DESIGNATES THE GRIP LENGTH NUMBER OR THE NOMINAL PIN SHANK LENGTH IN .0625 INCH INCREMENTS.

SEE FINISH CODE FOR SUFFIX INFORMATION.

EXAMPLE: (H)GPS6TCV08-06()



MECHANICAL PROPERTIES						
PART NUMBER	NOM SIZE	MINIMUM DOUBLE SHEAR POUNDS	COLLAR PART NUMBER	MIN ULTIMATE TENSILE LBS	PIN POSITION SWAGE GAGE	MAX SQUEEZE LOAD LBS
GPS6TCV05-()()	.164	4010	2TC-C05	2180	HG106-05	TBD
GPS6TCV06-()()	.190	5380	2TC-C06	2750	HG106-06	3000
GPS6TCV08-()()	.250	9300	2TC-C08	5000	HG106-08	5950
GPS6TCV10-()()	.312	14600	2TC-C10	8300	HG106-10	7050
GPS6TCV12-()()	.375	21000	2TC-C12	12700	HG106-12	10400

DIMENSIONS IN INCHES

H <sub>2</sub>	REVISED COMPANY LOGO & UPDATED TRADEMARK INFORMATION.(REF. ECR2779)		
ISSUED	11/15/88	STUMP, GROOVE PROPORTIONED GP™, SWAGE LOCKING, 100° FLUSH CROWN (MS20426) HEAD FOR TENSION APPLICATIONS, 6AL-4V TITANIUM, (95 KSI SHEAR)	GPS6TCV()-( ) ( )
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GRIP NUMBER TABULATION							
 GRIP DASH NO.	DESIGN GRIP RANGE		05	06	08	10	12
	MIN.	MAX.	Y	Y	Y	Y	Y
			±.010	±.010	±.010	±.010	±.010
02	.063	.125	.379	.428	—	—	—
03	.126	.188	.442	.491	.578	.684	—
04	.189	.250	.504	.553	.640	.746	.812
05	.251	.312	.566	.615	.702	.808	.874
06	.313	.375	.629	.678	.765	.871	.937
07	.376	.438	.692	.741	.828	.934	1.000
08	.439	.500	.754	.803	.890	.996	1.062
09	.501	.562	.816	.865	.952	1.058	1.124
10	.563	.625	.879	.928	1.015	1.121	1.187
11	.626	.688	.942	.991	1.078	1.184	1.250
12	.689	.750	1.004	1.053	1.140	1.246	1.312
13	.751	.812	1.066	1.115	1.202	1.308	1.374
14	.813	.875	1.129	1.178	1.265	1.371	1.437
15	.876	.938	1.192	1.241	1.328	1.434	1.500
16	.939	1.000	1.254	1.303	1.390	1.496	1.562
17	1.001	1.062	1.316	1.365	1.452	1.558	1.624
18	1.063	1.125	1.379	1.428	1.515	1.621	1.687
19	1.126	1.188	1.442	1.491	1.578	1.684	1.750
20	1.189	1.250	1.504	1.553	1.640	1.746	1.812
21	1.251	1.312	1.566	1.615	1.702	1.808	1.874
22	1.313	1.375	1.629	1.678	1.765	1.871	1.937
23	1.376	1.438	1.692	1.741	1.828	1.934	2.000
24	1.439	1.500	1.754	1.803	1.890	1.996	2.062
25	1.501	1.562	1.816	1.865	1.952	2.058	2.124
26	1.563	1.625	1.879	1.928	2.015	2.121	2.187
27	1.626	1.688	1.942	1.991	2.078	2.184	2.250
28	1.689	1.750	2.004	2.053	2.140	2.246	2.312
29	1.751	1.812	2.066	2.115	2.202	2.308	2.374
30	1.813	1.875	2.129	2.178	2.265	2.371	2.437
31	1.876	1.938	2.192	2.241	2.328	2.434	2.500
32	1.939	2.000	2.254	2.303	2.390	2.496	2.562

DIMENSIONS IN INCHES

H <sub>2</sub>	REVISED COMPANY LOGO & UPDATED TRADEMARK INFORMATION. (REF. ECR2779)		
ISSUED	05/27/85	STUMP, GROOVE PROPORTIONED GP™, SWAGE LOCKING, 100° FLUSH CROWN (MS20426) HEAD FOR TENSION APPLICATIONS, 6AL-4V TITANIUM, (95 KSI SHEAR)	GPS6TCV( )-( ) ( )
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