



Howmet Fastening Systems
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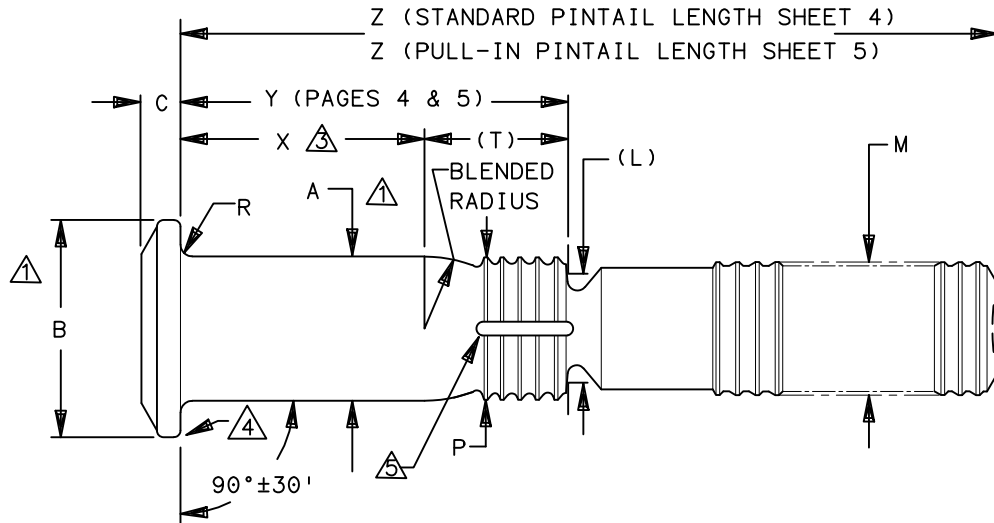
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ENGINEERING
 STANDARD

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



LGP PIN FAMILY NUMBER	NOM SIZE	A SHANK DIA + .0005 - .0000	A SHANK DIA COATED ± .0005	B HEAD DIA ± .005	C HEAD HEIGHT		(L) REF	M MAX	P DIA MAX	R RAD ±.005	S HEX △	(T) REF
					MAX	MIN						
(H)LGPL2SP-V05(*)()()	.1640	.1630	.1630	.250	.048	.038	.126	.156	.156	.020	.0045	.150
(H)LGPL2SP-V06(*)()()	.1900	.1890	.1890	.294	.057	.047	.150	.184	.184	.020	.0045	.152
(H)LGPL2SP-V08(*)()()	.2500	.2490	.2490	.376	.071	.061	.187	.244	.244	.020	.0045	.210
(H)LGPL2SP-V10(*)()()	.3125	.3115	.3115	.460	.081	.071	.244	.306	.306	.025	.0045	.269
(H)LGPL2SP-V12(*)()()	.3750	.3740	.3740	.539	.098	.086	.298	.370	.370	.025	.0060	.321
(H)LGPL2SP-V14(*)()()	.4375	.4365	.4365	.619	.109	.097	.312	.431	.431	.025	.0060	.376
(H)LGPL2SP-V16(*)()()	.5000	.4990	.4990	.707	.119	.107	.375	.492	.492	.025	.0060	.432

* INSERT A DASH (-) FOR STANDARD PINTAIL LENGTHS (SEE PAGE 4)
 INSERT THE LETTER (L) FOR PINS REQUIRING LONG PINTAILS FOR PULL-IN TYPE APPLICATIONS AVAILABLE IN 05 THRU 16 DIAMETERS ONLY (SEE PAGE 5)

- △1 CONCENTRICITY: CONICAL SURFACE OF PROTRUDING HEAD TO "A" DIAMETER TO BE WITHIN .008 TIR.
- △2 SHANK STRAIGHTNESS: WITHIN "S" VALUES TIR PER INCH OF SHANK LENGTH.
- △3 GRIP LENGTH IS MEASURED FROM THE UNDERSIDE OF THE HEAD TO THE END OF THE FULL CYLINDRICAL PORTION OF THE SHANK. (SEE DIMENSION "X" PAGES 4 & 5)
- △4 PERMISSIBLE NATURAL FLOW OF MATERIAL. MUST BE FREE FROM SHARP CORNERS.
- △5 SEALANT ESCAPE GROOVE.

PROCUREMENT SPECIFICATION: C2010
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DIMENSIONS IN INCHES

DRAWN BY	DLH	FSCM (Cage Code) 17446 - Carson FSCM (Cage Code) F6167 - France
CHECKED BY	MM	

L16 REVISED COMPANY LOGO & UPDATED TRADEMARK INFORMATION. (REF ECR2779)		PIN, LIGHTWEIGHT GROOVE PROPORTIONED PROTRUDING HEAD, SHEAR TYPE, STANDARD AND PULL-IN PINTAILS, SWAGE LOCKING, 6AL-4V TITANIUM. (95 KSI SHEAR)	(H)LGPL2SP-V()()()()
ISSUED	11/24/80		
REVISD	08/11/21		
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L16



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MATERIAL: 6AL-4V TITANIUM ALLOY PER AMS4967.

SHEAR STRENGTH: 95 KSI MINIMUM

SURFACE TEXTURE: Ra MAX PER ANSI/ASME B46.1 BEFORE COATING. BEARING SURFACE OF HEAD, HEAD TO SHANK FILLET RADIUS, SHANK AND TRANSITION RADIUS, -32, OTHER SURFACES -125.

FINISH: NO LETTER = UNCOATED PIN PLUS CETYL ALCOHOL LUBE PER AS87132.

AC = ALUMINUM COATING KAL-GARD 2240C (EU ONLY) / HI-KOTE™ 1 PER NAS4006 OR KAL-GARD 2242 / HI-KOTE™ 1 NC PER NAS4006NC, OPTIONAL ON PINTAIL END. PLUS CETYL ALCOHOL LUBE PER AS87132.

ACG = ALUMINUM COATING HI-KOTE™ 1 PER NAS4006 OR KAL-GARD 2242 / HI-KOTE™ 1 NC PER NAS4006NC, OPTIONAL ON PINTAIL END. IDENTIFIED BY GREEN COLOR ON PINTAIL END. PLUS CETYL ALCOHOL LUBE PER AS87132. (APPLICABLE TO "H" TYPE SEALANT ESCAPE GROOVE FASTENERS FOR BOEING ONLY).

ACN = ALUMINUM COATING HI-KOTE™ 1 NC PER EN4473 TYPE II, OPTIONAL ON PINTAIL END. PLUS CETYL ALCOHOL LUBE PER AS87132.

ACY = ALUMINUM COATING HI-KOTE™ 1 PER NAS4006 OR KAL-GARD 2242 / HI-KOTE™ 1 NC PER NAS4006NC, OPTIONAL ON PINTAIL END. IDENTIFY BY YELLOW COLOR ON PINTAIL END. PLUS CETYL ALCOHOL LUBE PER AS87132.

AD = ALUMINUM COATING KAL-GARD 2245 / HI-KOTE™ 1 PER EN4473 TYPE I OR HI-KOTE™ 1 NC PER EN4473 TYPE II, OPTIONAL ON PINTAIL END. OPTIONAL TO COLOR PINTAIL END WHITE. PLUS CETYL ALCOHOL LUBE PER AS87132.

APY = ALUMINUM COATING KAL-GARD 2242 / HI-KOTE™ 1 PER NAS4006 OR HI-KOTE™ 1 NC PER NAS4006NC, OPTIONAL ON PINTAIL END. IDENTIFY BY YELLOW COLOR ON PINTAIL END. APPLY SEALANT UNDER HEAD PER BMS-5-95. PLUS CETYL ALCOHOL LUBE PER AS87132.

AS = SULPHURIC ACID ANODIZE (BLUE) PER ISO 8080. PLUS CETYL ALCOHOL LUBE PER AS87132.

B = UNCOATED PIN AND NO LUBRICATION.

D = ION VAPOR DEPOSITED ALUMINUM COATING PER MIL-DTL-83488 TYPE II, CLASS 3, EXCEPT THICKNESS .0002/.0005, OPTIONAL ON PINTAIL END. OPTIONAL TO COLOR PINTAIL END BLACK. PLUS CETYL ALCOHOL LUBE PER AS87132.

PB = POWDERED BLAST TOP SURFACE OF HEAD. PLUS CETYL ALCOHOL LUBE PER AS87132 (Ra 50/80 SURFACE ROUGHNESS).

HEAD MARKING: HEADS SHALL BE MARKED WITH THE MANUFACTURER'S SYMBOL, THE BASIC PART NUMBER (LGP2), AND (V), DEPRESSED .006 MAX. DEPTH ARRANGEMENT OPTIONAL. FOR PINS REQUIRING A SEALANT ESCAPE GROOVE, AN "H" WILL BE INCLUDED ON THE HEAD IDENTIFICATION CALLOUT.

CODING: THE FIRST SET OF LETTERS DESIGNATE THE FAMILY OF LIGHTWEIGHT LGP PINS FOR SHEAR APPLICATIONS (LGPL).

THE SECOND SET OF LETTERS & NUMBER (2SP) 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 .03125 INCH INCREMENTS.

FOR PINS WITH STANDARD PINTAIL LENGTHS INSERT A DASH (-), SEE PAGE 4. FOR PINS WITH LONG PULL-IN PINTAIL LENGTH INSERT THE LETTER (L) SEE PAGE 5.

THE FINAL NUMBERS DESIGNATE THE GRIP LENGTH NUMBER OR THE NOMINAL PIN SHANK LENGTH IN .0625 INCH INCREMENTS.

SEE FINISH CODE FOR SUFFIX INFORMATION.

L 16		REVISED COMPANY LOGO & UPDATED TRADEMARK INFORMATION. (REF ECR2779)	
ISSUED	11/24/80	PIN, LIGHTWEIGHT GROOVE PROPORTIONED PROTRUDING HEAD, SHEAR TYPE, STANDARD AND PULL-IN PINTAILS, SWAGE LOCKING, 6AL-4V TITANIUM. (95 KSI SHEAR)	(H)LGPL2SP-V() () () ()
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MECHANICAL PROPERTIES						
LGP PIN PART NUMBER	PIN NOM SIZE	MINIMUM DOUBLE SHEAR POUNDS	COLLAR PART NUMBER	MIN ULTIMATE TENSILE LBS WITH LISTED COLLAR	PIN POSITION SWAGE GAGE	
					EXCEPT "ACG" SUFFIX	"ACG" SUFFIX BOEING ONLY
(H)LGPL2SP-V05-() () ()	.1640	4010	3SLC-C05	1400	HG110-05	HG160-05
			SLC-MV05		TBD	
			SLC-M05	1500	HG137-05	
			SLC-EU05	1850		
(H)LGPL2SP-V06-() () ()	.1900	5380	3SLC-C06	1600	HG110-06	HG160-06
			SLC-MV06		TBD	
			SLC-M06	2000	HG137-06	
			SLC-EU06	2250		
(H)LGPL2SP-V08-() () ()	.2500	9300	3SLC-C08	3000	HG110-08	HG160-08
			SLC-MV08		TBD	
			SLC-M08	3600	HG137-08	
			SLC-EU08	3850		
(H)LGPL2SP-V10-() () ()	.3125	14600	3SLC-C10	5000	HG110-10	HG160-10
			SLC-MV10		TBD	
			SLC-M10	5550	HG137-10	
			SLC-EU10			
(H)LGPL2SP-V12-() () ()	.3750	21000	3SLC-C12	7000	HG110-12	HG160-12
			SLC-MV12		TBD	
			SLC-M12	8340	HG137-12	
			SLC-EU12			
(H)LGPL2SP-V14-() () ()	.4375	28600	3SLC-C14	9500	HG110-14	
(H)LGPL2SP-V16-() () ()	.5000	37300	3SLC-C16	12500	HG110-16	

DIMENSIONS IN INCHES

ISSUED	11/24/80	PIN, LIGHTWEIGHT GROOVE PROPORTIONED PROTRUDING HEAD, SHEAR TYPE, STANDARD AND PULL-IN PINTAILS, SWAGE LOCKING, 6AL-4V TITANIUM. (95 KSI SHEAR)	(H)LGPL2SP-V() () () ()	
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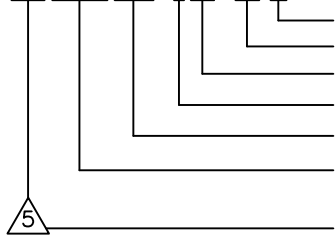
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STANDARD PINTAIL LENGTH

GRIP NUMBER TABULATION

GRIP DASH NO.	MINIMUM PERMISSIBLE GRIP OVERLAP	DESIGN GRIP RANGE		MAXIMUM PERMISSIBLE GRIP OVERLAP	X ±.005	05		06		08		10		12		14		16			
		MIN.	MAX.			Y	Z	Y	Z	Y	Z	Y	Z	Y	Z	Y	Z	Y	Z	Y	Z
02	.047	.063	.125	.141	.125	.275	.801	.277	.874	—	—	—	—	—	—	—	—	—	—		
03	.109	.126	.188	.203	.188	.338	.864	.340	.937	.398	1.051	.457	1.155	—	—	—	—	—	—		
04	.172	.189	.250	.266	.250	.400	.926	.402	.999	.460	1.113	.519	1.217	.571	1.337	.626	1.497	.682	1.706		
05	.234	.251	.312	.328	.312	.462	.988	.464	1.061	.522	1.175	.581	1.279	.633	1.399	.688	1.559	.744	1.768		
06	.297	.313	.375	.391	.375	.525	1.051	.527	1.124	.585	1.238	.644	1.342	.696	1.462	.751	1.622	.807	1.831		
07	.359	.376	.438	.453	.438	.588	1.114	.590	1.187	.648	1.301	.707	1.405	.759	1.525	.814	1.684	.870	1.894		
08	.422	.439	.500	.516	.500	.650	1.176	.652	1.249	.710	1.363	.769	1.467	.821	1.587	.876	1.747	.932	1.956		
09	.484	.501	.562	.578	.562	.712	1.238	.714	1.311	.772	1.425	.831	1.529	.883	1.649	.938	1.809	.994	2.018		
10	.547	.563	.625	.641	.625	.775	1.301	.777	1.374	.835	1.488	.894	1.592	.946	1.712	1.001	1.872	1.057	2.081		
11	.609	.626	.688	.703	.688	.838	1.364	.840	1.437	.898	1.551	.957	1.655	1.009	1.775	1.064	1.934	1.120	2.144		
12	.672	.689	.750	.766	.750	.900	1.426	.902	1.499	.960	1.613	1.019	1.717	1.071	1.837	1.126	1.997	1.182	2.206		
13	.734	.751	.812	.828	.812	.962	1.488	.964	1.561	1.022	1.675	1.081	1.779	1.133	1.899	1.188	2.059	1.244	2.268		
14	.797	.813	.875	.891	.875	1.025	1.551	1.027	1.624	1.085	1.738	1.144	1.842	1.196	1.962	1.251	2.122	1.307	2.331		
15	.859	.876	.938	.953	.938	1.088	1.614	1.090	1.687	1.148	1.801	1.207	1.905	1.259	2.025	1.314	2.184	1.370	2.394		
16	.922	.939	1.000	1.016	1.000	1.150	1.676	1.152	1.749	1.210	1.863	1.269	1.967	1.321	2.087	1.376	2.247	1.432	2.456		
17	.984	1.001	1.062	1.078	1.062	1.212	1.738	1.214	1.811	1.272	1.925	1.331	2.029	1.383	2.149	1.438	2.309	1.494	2.518		
18	1.047	1.063	1.125	1.141	1.125	1.275	1.801	1.277	1.874	1.335	1.988	1.394	2.092	1.446	2.212	1.501	2.372	1.557	2.581		
19	1.109	1.126	1.188	1.203	1.188	1.338	1.864	1.340	1.937	1.398	2.051	1.457	2.155	1.509	2.275	1.564	2.434	1.620	2.644		
20	1.172	1.189	1.250	1.266	1.250	1.400	1.926	1.402	1.999	1.460	2.113	1.519	2.217	1.571	2.337	1.626	2.497	1.682	2.706		
21	1.234	1.251	1.312	1.328	1.312	1.462	1.988	1.464	2.061	1.522	2.175	1.581	2.279	1.633	2.399	1.688	2.559	1.744	2.768		
22	1.297	1.313	1.375	1.391	1.375	1.525	2.051	1.527	2.124	1.585	2.238	1.644	2.342	1.696	2.462	1.751	2.622	1.807	2.831		
23	1.359	1.376	1.438	1.453	1.438	1.588	2.114	1.590	2.187	1.648	2.301	1.707	2.405	1.759	2.525	1.814	2.684	1.870	2.894		
24	1.422	1.439	1.500	1.516	1.500	1.650	2.176	1.652	2.249	1.710	2.363	1.769	2.467	1.821	2.587	1.876	2.747	1.932	2.956		
25	1.484	1.501	1.562	1.578	1.562	1.712	2.238	1.714	2.311	1.772	2.425	1.831	2.529	1.883	2.649	1.938	2.809	1.994	3.018		
26	1.547	1.563	1.625	1.641	1.625	1.775	2.301	1.777	2.374	1.835	2.488	1.894	2.592	1.946	2.712	2.001	2.872	2.057	3.081		
27	1.609	1.626	1.688	1.703	1.688	1.838	2.364	1.840	2.437	1.898	2.551	1.957	2.655	2.009	2.775	2.064	2.934	2.120	3.144		
28	1.672	1.689	1.750	1.766	1.750	1.900	2.426	1.902	2.499	1.960	2.613	2.019	2.717	2.071	2.837	2.126	2.997	2.182	3.206		
29	1.734	1.751	1.812	1.828	1.812	1.962	2.488	1.964	2.561	2.022	2.675	2.081	2.779	2.133	2.899	2.188	3.059	2.244	3.268		
30	1.797	1.813	1.875	1.891	1.875	2.025	2.551	2.027	2.624	2.085	2.738	2.144	2.842	2.196	2.962	2.251	3.122	2.307	3.331		
31	1.859	1.876	1.938	1.953	1.938	2.088	2.614	2.090	2.687	2.148	2.801	2.207	2.905	2.259	3.025	2.314	3.184	2.370	3.394		
32	1.922	1.939	2.000	2.016	2.000	2.150	2.676	2.152	2.749	2.210	2.863	2.269	2.967	2.321	3.087	2.376	3.247	2.432	3.456		
33	1.984	2.001	2.062	2.078	2.062	2.212	2.738	2.214	2.811	2.272	2.925	2.331	3.029	2.383	3.149	2.438	3.309	2.494	3.518		
34	2.047	2.063	2.125	2.141	2.125	2.275	2.801	2.277	2.874	2.335	2.988	2.394	3.092	2.446	3.212	2.501	3.372	2.557	3.581		
35	2.109	2.128	2.188	2.203	2.188	2.338	2.864	2.340	2.937	2.398	3.051	2.457	3.155	2.509	3.275	2.564	3.434	2.620	3.644		
36	2.172	2.189	2.250	2.266	2.250	2.400	2.926	2.402	2.999	2.460	3.113	2.519	3.217	2.571	3.337	2.626	3.497	2.682	3.706		

EXAMPLE: (H)LGPL2SP-V08-06()



- FINISH SUFFIX (SEE FINISH CODE PAGE 2).
- GRIP LENGTH IN .0625 INCH INCREMENTS.
- SHANK DIA IN .03125 INCH INCREMENTS
- 6AL-4V TITANIUM.
- PROTRUDING HEAD FOR SHEAR APPLICATIONS.
- FAMILY OF LGP LIGHTWEIGHT PINS FOR AEROSPACE APPLICATIONS.
- ADD "H" PREFIX TO PART NUMBER TO INCLUDE SEALANT ESCAPE GROOVE.

DIMENSIONS IN INCHES

ISSUED	11/24/80	PIN, LIGHTWEIGHT GROOVE PROPORTIONED PROTRUDING HEAD, SHEAR TYPE, STANDARD AND PULL-IN PINTAILS, SWAGE LOCKING, 6AL-4V TITANIUM. (95 KSI SHEAR)	(H)LGPL2SP-V()()()()	
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	PAGE			4 OF 5

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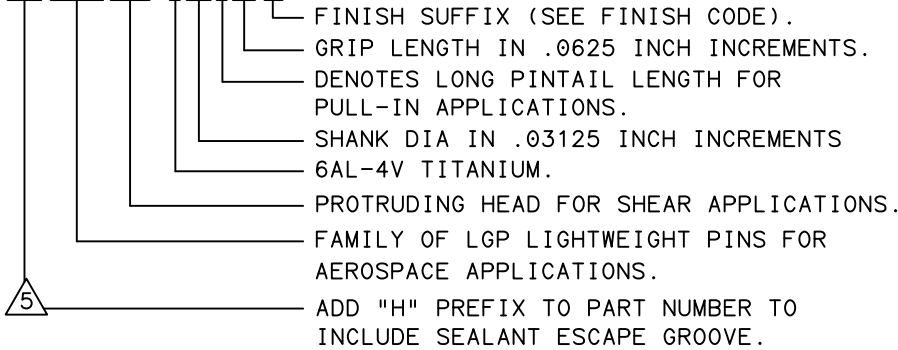
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LONG PULL-IN PINTAIL LENGTH

GRIP NUMBER TABULATION																			
GRIP DASH NO.	MINIMUM PERMISSIBLE GRIP OVERLAP	DESIGN GRIP RANGE		MAXIMUM PERMISSIBLE GRIP OVERLAP	X ±.005	05		06		08		10		12		14		16	
		MIN.	MAX.			Y	Z	Y	Z	Y	Z	Y	Z	Y	Z	Y	Z	Y	Z
07	.359	.376	.438	.453	.438	.588	1.145	—	—	—	—	—	—	—	—	—	—	—	—
08	.422	.439	.500	.516	.500	.650	1.270	—	—	—	—	—	—	—	—	—	—	—	—
09	.484	.501	.562	.578	.562	.712	1.395	.714	1.395	—	—	—	—	—	—	—	—	—	—
10	.547	.563	.625	.641	.625	.775	1.520	.777	1.520	.835	1.565	—	—	—	—	—	—	—	—
11	.609	.626	.688	.703	.688	.838	1.645	.840	1.645	.898	1.690	.957	1.710	—	—	1.064	1.949	—	—
12	.672	.689	.750	.766	.750	.900	1.770	.902	1.770	.960	1.815	1.019	1.835	—	—	1.126	2.074	—	—
13	.734	.751	.812	.828	.812	.962	1.895	.964	1.895	1.022	1.940	1.081	1.960	1.133	1.960	1.188	2.199	—	—
14	.797	.813	.875	.891	.875	1.025	2.020	1.027	2.020	1.085	2.065	1.144	2.085	1.196	2.085	1.251	2.324	1.307	2.341
15	.859	.876	.938	.953	.938	1.088	2.145	1.090	2.145	1.148	2.190	1.207	2.210	1.259	2.210	1.314	2.449	1.370	2.466
16	.922	.939	1.000	1.016	1.000	1.150	2.270	1.152	2.270	1.210	2.315	1.269	2.335	1.321	2.335	1.376	2.574	1.432	2.591
17	.984	1.001	1.062	1.078	1.062	—	—	—	—	1.272	2.440	1.331	2.460	1.383	2.460	1.438	2.699	1.494	2.716
18	1.047	1.063	1.125	1.141	1.125	—	—	—	—	1.335	2.565	1.394	2.585	1.446	2.585	1.501	2.824	1.557	2.841
19	1.109	1.126	1.188	1.203	1.188	—	—	—	—	1.398	2.690	1.457	2.710	1.509	2.710	1.564	2.949	1.620	2.966
20	1.172	1.189	1.250	1.266	1.250	—	—	—	—	1.460	2.815	1.519	2.835	1.571	2.835	1.626	3.074	1.682	3.091
21	1.234	1.251	1.312	1.328	1.312	—	—	—	—	1.522	2.940	1.581	2.960	1.633	2.960	1.688	3.199	1.744	3.216
22	1.297	1.313	1.375	1.391	1.375	—	—	—	—	1.585	3.065	1.644	3.085	1.696	3.085	1.751	3.324	1.807	3.341
23	1.359	1.376	1.438	1.453	1.438	—	—	—	—	—	—	1.707	3.210	1.759	3.210	1.814	3.449	1.870	3.466
24	1.422	1.439	1.500	1.516	1.500	—	—	—	—	—	—	1.769	3.335	1.821	3.335	1.876	3.574	1.932	3.591
25	1.484	1.501	1.562	1.578	1.562	—	—	—	—	—	—	1.831	3.460	1.883	3.460	1.938	3.699	1.994	3.716
26	1.547	1.563	1.625	1.641	1.625	—	—	—	—	—	—	1.894	3.585	1.946	3.585	2.001	3.824	2.057	3.841
27	1.609	1.626	1.688	1.703	1.688	—	—	—	—	—	—	—	—	2.009	3.710	2.064	3.949	2.120	3.966
28	1.672	1.689	1.750	1.766	1.750	—	—	—	—	—	—	—	—	2.071	3.835	2.126	4.074	2.182	4.091
29	1.734	1.751	1.812	1.828	1.812	—	—	—	—	—	—	—	—	2.133	3.960	2.188	4.199	2.244	4.216
30	1.797	1.813	1.875	1.891	1.875	—	—	—	—	—	—	—	—	2.196	4.085	2.251	4.324	2.307	4.341
31	1.859	1.876	1.938	1.953	1.938	—	—	—	—	—	—	—	—	2.259	4.210	2.314	4.449	2.370	4.466
32	1.922	1.939	2.000	2.016	2.000	—	—	—	—	—	—	—	—	2.321	4.335	2.376	4.574	2.432	4.591

EXAMPLE: (H)LGPL2SP-V08L06()



DIMENSIONS IN INCHES

ISSUED	11/24/80	PIN, LIGHTWEIGHT GROOVE PROPORTIONED PROTRUDING HEAD, SHEAR TYPE, STANDARD AND PULL-IN PINTAILS, SWAGE LOCKING, 6AL-4V TITANIUM. (95 KSI SHEAR)	(H)LGPL2SP-V()()()()
	08/11/21		
	5 OF 5		
REVISED COMPANY LOGO & UPDATED TRADEMARK INFORMATION. (REF ECR2779)		LGP102	

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