



Howmet Fastening Systems
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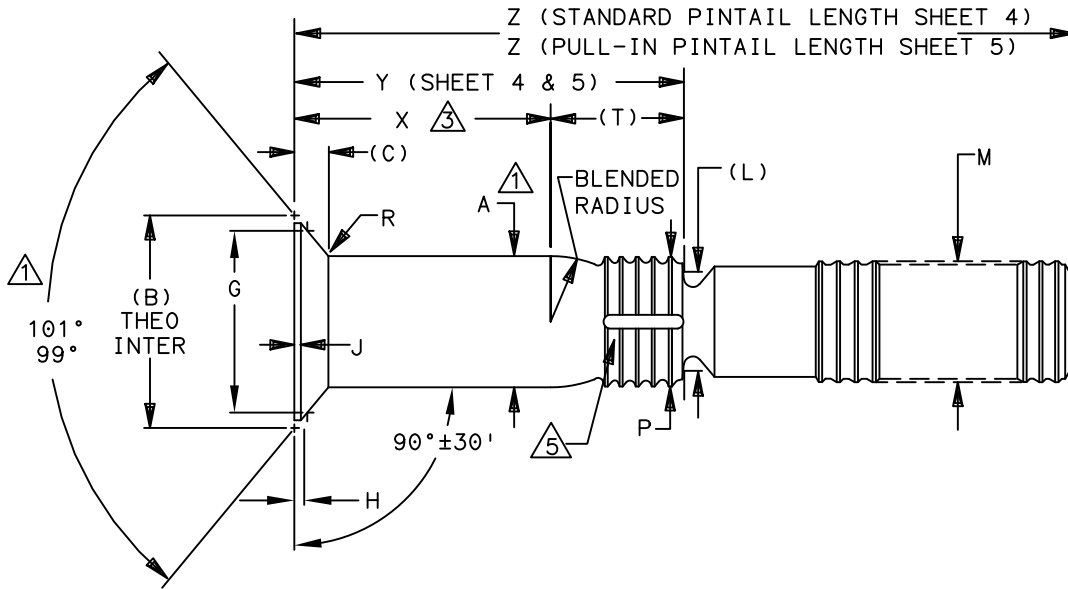
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ENGINEERING
 STANDARD

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) THEO DIA NOM	(C) HEAD HEIGHT NOM	G GAGE DIA ±.0001	H GAGE HEIGHT		J MAX	(L) REF	M MAX	P DIA MAX	R RAD ±.005	S △	(T) REF
							MAX	MIN							
(H)LGPL4SC-V05(*) () ()	.1640	.1630	.1630	.2775	.0481	.2027	.0330	.0298	.010	.126	.156	.156	.020	.0045	.150
(H)LGPL4SC-V06(*) () ()	.1900	.1890	.1890	.3224	.0560	.2440	.0345	.0313	.015	.150	.184	.184	.025	.0045	.152
(H)LGPL4SC-V07(*) () ()	.2187	.2177	.2177	.3715	.0646	.2981	.0323	.0293	.010	.173	.213	.213	.025	.0045	.210
(H)LGPL4SC-V08(*) () ()	.2500	.2490	.2490	.4234	.0732	.3314	.0402	.0370	.015	.187	.244	.244	.025	.0045	.210
(H)LGPL4SC-V10(*) () ()	.3125	.3115	.3115	.5305	.0919	.4319	.0432	.0396	.015	.244	.306	.306	.035	.0045	.269
(H)LGPL4SC-V12(*) () ()	.3750	.3740	.3740	.6357	.1098	.4853	.0649	.0613	.015	.298	.370	.370	.035	.0060	.321
(H)LGPL4SC-V14(*) () ()	.4375	.4365	.4365	.7360	.1257	.6581	.0347	.0307	.022	.312	.431	.431	.045	.0060	.376
(H)LGPL4SC-V16(*) () ()	.5000	.4990	.4990	.8353	.1411	.7199	.0504	.0464	.022	.375	.492	.492	.045	.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 (SEE PAGE 5)

- 1 △ CONCENTRICITY: CONICAL SURFACE OF COUNTERSUNK HEAD TO "A" DIAMETER TO BE WITHIN .005 TIR
- 2 △ SHANK STRAIGHTNESS: WITHIN "S" VALUES TIR PER INCH OF SHANK LENGTH
- 3 △ GRIP LENGTH IS MEASURED FROM THE TOP OF THE HEAD TO THE END OF THE FULL CYLINDRICAL PORTION OF THE SHANK. (SEE DIMENSION "X" SHEET 4 & 5).
- 4 DIMENSIONS B AND C ARE FOR REFERENCE ONLY, NOT FOR INSPECTION PURPOSES
- 5 △ SEALANT ESCAPE GROOVE.

PROCUREMENT SPECIFICATION: C2010
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DIMENSIONS IN INCHES

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

J17 REVISED COMPANY LOGO & UPDATED TRADEMARK INFORMATION. (REF. ECR2779)

ISSUED	11/19/80	PIN, LIGHTWEIGHT GROOVE PROPORTIONED 100° INTERMEDIATE COUNTERSUNK HEAD, SHEAR TYPE, STANDARD AND PULL-IN PINTAILS, SWAGE LOCKING, 6AL-4V TITANIUM. (95 KSI SHEAR)	(H)LGPL4SC-V() () () ()
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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.

ACN = ALUMINUM COATING HI-KOTE™ 1 NC PER EN4473 TYPE II, OPTIONAL 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.

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

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.

HEAD MARKING: HEADS SHALL BE MARKED WITH THE MANUFACTURER'S SYMBOL, THE BASIC PART NUMBER (LGP4), 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 (4SC) 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.

DIMENSIONS IN INCHES

J17		REVISED COMPANY LOGO & UPDATED TRADEMARK INFORMATION. (REF. ECR2779)		
ISSUED	11/19/80	PIN, LIGHTWEIGHT GROOVE PROPORTIONED 100° INTERMEDIATE COUNTERSUNK HEAD, SHEAR TYPE, STANDARD AND PULL-IN PINTAILS, SWAGE LOCKING, 6AL-4V TITANIUM. (95 KSI SHEAR)	(H)LGPL4SC-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
(H)LGPL4SC-V05()()()	.1640	4010	3SLC-C05	1400	HG110-05
			SLC-MV05		
			SLC-M05	1500	HG137-05
			SLC-EU05	1850	
(H)LGPL4SC-V06()()()	.1900	5380	3SLC-C06	1600	HG110-06
			SLC-MV06	2000	HG137-06
			SLC-M06		
			SLC-EU06	2250	
(H)LGPL4SC-V07()()()	.2187	7200	3SLC-C07	2250	HG110-07
			SLC-M07		HG137-07
(H)LGPL4SC-V08()()()	.2500	9300	3SLC-C08	3000	HG110-08
			SLC-MV08		
			SLC-M08	3600	HG137-08
			SLC-EU08	3850	
(H)LGPL4SC-V10()()()	.3125	14600	3SLC-C10	5000	HG110-10
			SLC-MV10		
			SLC-M10	5550	HG137-10
			SLC-EU10		
(H)LGPL4SC-V12()()()	.3750	21000	3SLC-C12	7000	HG110-12
			SLC-MV12		
			SLC-M12	8340	HG137-12
			SLC-EU12		
(H)LGPL4SC-V14()()()	.4375	28600	3SLC-C14	9500	HG110-14
(H)LGPL4SC-V16()()()	.5000	37300	3SLC-C16	12500	HG110-16

DIMENSIONS IN INCHES

J17	REVISED COMPANY LOGO & UPDATED TRADEMARK INFORMATION. (REF. ECR2779)			
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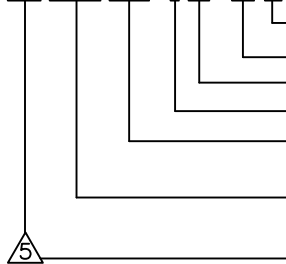
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STANDARD PINTAIL LENGTH

GRIP NUMBER TABULATION																					
GRIP DASH NO.	MINIMUM PERMISSIBLE GRIP OVERLAP	DESIGN GRIP RANGE		MAXIMUM PERMISSIBLE GRIP OVERLAP	X ±.005	05		06		07		08		10		12		14		16	
		MIN.	MAX.			Y	Z	Y	Z	Y	Z	Y	Z	Y	Z	Y	Z	Y	Z	Y	Z
						±.010	+ .060 - .000	±.010	+ .060 - .000	±.010	+ .060 - .000	±.010	+ .060 - .000	±.010	+ .060 - .000	±.010	+ .060 - .000	±.010	+ .060 - .000	±.010	+ .060 - .000
02	.047	.063	.125	.141	.125	.275	.801	.277	.874	.335	.898	—	—	—	—	—	—	—	—	—	—
03	.109	.126	.188	.203	.188	.338	.864	.340	.937	.398	.961	.398	1.051	.457	1.155	.509	1.275	—	—	—	—
04	.172	.189	.250	.266	.250	.400	.926	.402	.999	.460	1.023	.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	1.085	.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	1.148	.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	1.211	.648	1.301	.707	1.405	.759	1.525	.814	1.685	.870	1.894
08	.422	.439	.500	.516	.500	.650	1.176	.652	1.249	.710	1.273	.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	1.335	.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	1.398	.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	1.461	.898	1.551	.957	1.655	1.009	1.775	1.064	1.935	1.120	2.144
12	.672	.689	.750	.766	.750	.900	1.426	.902	1.499	.960	1.523	.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	1.585	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	1.648	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	1.711	1.148	1.801	1.207	1.905	1.259	2.025	1.314	2.185	1.370	2.394
16	.922	.939	1.000	1.016	1.000	1.150	1.676	1.152	1.749	1.210	1.773	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	1.835	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	1.898	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	1.961	1.398	2.051	1.457	2.155	1.509	2.275	1.564	2.435	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	2.023	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	2.085	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	2.148	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	2.211	1.648	2.301	1.707	2.405	1.759	2.525	1.814	2.685	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	2.273	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	2.335	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	2.398	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	2.461	1.898	2.551	1.957	2.655	2.009	2.775	2.064	2.935	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	2.523	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	2.585	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	2.648	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	2.711	2.148	2.801	2.207	2.905	2.259	3.025	2.314	3.185	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	2.773	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	2.835	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	2.898	2.335	2.988	2.394	3.092	2.446	3.212	2.501	3.372	2.557	3.581
35	2.109	2.126	2.188	2.203	2.188	2.338	2.864	2.340	2.937	2.398	2.961	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	3.023	2.460	3.113	2.519	3.217	2.571	3.337	2.626	3.497	2.682	3.706

EXAMPLE: (H)LGPL4SC-V08-06()



- FINISH SUFFIX (SEE FINISH CODE PAGE 2).
- GRIP LENGTH IN .0625 INCH INCREMENTS.
- SHANK DIA IN .03125 INCH INCREMENTS
- 6AL-4V TITANIUM.
- 100° INTERMEDIATE COUNTERSUNK HEAD FOR SHEAR APPLICATIONS.
- FAMILY OF LGP LIGHTWEIGHT PINS FOR AEROSPACE APPLICATIONS.
- ADD "H" PREFIX TO PART NUMBER TO INCLUDE SEALANT ESCAPE GROOVE.

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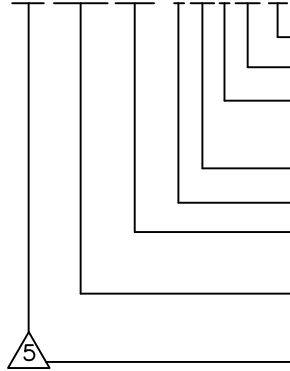
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LONG PULL-IN PINTAIL LENGTH

GRIP NUMBER TABULATION																							
GRIP DASH NO.	MINIMUM PERMISSIBLE GRIP OVERLAP	DESIGN GRIP RANGE		MAXIMUM PERMISSIBLE GRIP OVERLAP	X ±.005	05		06		07		08		10		12		14		16			
		MIN.	MAX.			Y	Z	Y	Z	Y	Z	Y	Z	Y	Z	Y	Z	Y	Z	Y	Z	Y	Z
						±.010	+ .060 - .000	±.010	+ .060 - .000	±.010	+ .060 - .000	±.010	+ .060 - .000	±.010	+ .060 - .000	±.010	+ .060 - .000	±.010	+ .060 - .000	±.010	+ .060 - .000	±.010	+ .060 - .000
08	.422	.439	.500	.516	.500	.650	1.222	—	—	—	—	—	—	—	—	—	—	—	—	—	—		
09	.484	.501	.562	.578	.562	.712	1.347	.714	1.339	.772	1.371	—	—	—	—	—	—	—	—	—	—		
10	.547	.563	.625	.641	.625	.775	1.472	.777	1.464	.835	1.496	—	—	—	—	—	—	—	—	—	—		
11	.609	.626	.688	.703	.688	.838	1.597	.840	1.589	.898	1.621	.898	1.617	—	—	—	—	—	—	—	—		
12	.672	.689	.750	.766	.750	.900	1.722	.902	1.714	.960	1.746	.960	1.742	1.019	1.743	—	—	—	—	—	—		
13	.734	.751	.812	.828	.812	.962	1.847	.964	1.839	1.022	1.871	1.022	1.867	1.081	1.868	—	—	1.188	2.074	—	—		
14	.797	.813	.875	.891	.875	1.025	1.972	1.027	1.964	1.085	1.996	1.085	1.992	1.144	1.993	—	—	1.251	2.199	—	—		
15	.859	.876	.938	.953	.938	1.088	2.097	1.090	2.089	1.148	2.121	1.148	2.117	1.207	2.118	1.259	2.100	1.314	2.324	—	—		
16	.922	.939	1.000	1.016	1.000	1.150	2.222	1.152	2.214	1.210	2.246	1.210	2.242	1.269	2.243	1.321	2.225	1.376	2.449	—	—		
17	.984	1.001	1.062	1.078	1.062	—	—	—	—	1.272	2.371	1.272	2.367	1.331	2.368	1.383	2.350	1.438	2.574	1.494	2.573		
18	1.047	1.063	1.125	1.141	1.125	—	—	—	—	1.335	2.496	1.335	2.492	1.394	2.493	1.446	2.475	1.501	2.699	1.557	2.699		
19	1.109	1.126	1.188	1.203	1.188	—	—	—	—	1.398	2.621	1.398	2.617	1.457	2.618	1.509	2.600	1.564	2.824	1.620	2.824		
20	1.172	1.189	1.250	1.266	1.250	—	—	—	—	1.460	2.746	1.460	2.742	1.519	2.743	1.571	2.725	1.626	2.949	1.682	2.949		
21	1.234	1.251	1.312	1.328	1.312	—	—	—	—	1.522	2.871	1.522	2.867	1.581	2.868	1.633	2.850	1.688	3.074	1.744	3.073		
22	1.297	1.313	1.375	1.391	1.375	—	—	—	—	1.585	2.996	1.585	2.992	1.644	2.993	1.696	2.975	1.751	3.199	1.807	3.199		
23	1.359	1.376	1.438	1.453	1.438	—	—	—	—	—	—	—	—	1.707	3.118	1.759	3.100	1.814	3.324	1.870	3.324		
24	1.422	1.439	1.500	1.516	1.500	—	—	—	—	—	—	—	—	1.769	3.243	1.821	3.225	1.876	3.449	1.932	3.449		
25	1.484	1.501	1.562	1.578	1.562	—	—	—	—	—	—	—	—	1.831	3.368	1.883	3.350	1.938	3.574	1.994	3.573		
26	1.547	1.563	1.625	1.641	1.625	—	—	—	—	—	—	—	—	1.894	3.493	1.946	3.475	2.001	3.699	2.057	3.699		
27	1.609	1.626	1.688	1.703	1.688	—	—	—	—	—	—	—	—	—	—	2.009	3.600	2.064	3.824	2.120	3.824		
28	1.672	1.689	1.750	1.766	1.750	—	—	—	—	—	—	—	—	—	—	2.071	3.725	2.126	3.949	2.182	3.949		
29	1.734	1.751	1.812	1.828	1.812	—	—	—	—	—	—	—	—	—	—	2.133	3.850	2.188	4.074	2.244	4.073		
30	1.797	1.813	1.875	1.891	1.875	—	—	—	—	—	—	—	—	—	—	2.196	3.975	2.251	4.199	2.307	4.199		
31	1.859	1.876	1.938	1.953	1.938	—	—	—	—	—	—	—	—	—	—	2.259	4.100	2.314	4.324	2.370	4.324		
32	1.922	1.939	2.000	2.016	2.000	—	—	—	—	—	—	—	—	—	—	2.321	4.225	2.376	4.449	2.432	4.449		

EXAMPLE: (H)LGPL4SC-V08L06((



- FINISH SUFFIX (SEE FINISH CODE PAGE 2).
- GRIP LENGTH IN .0625 INCH INCREMENTS.
- DENOTES LONG PINTAIL LENGTH FOR PULL-IN APPLICATIONS.
- SHANK DIA IN .03125 INCH INCREMENTS
- 6AL-4V TITANIUM.
- 100° INTERMEDIATE COUNTERSUNK 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

J17	REVISED COMPANY LOGO & UPDATED TRADEMARK INFORMATION. (REF. ECR2779)		
ISSUED	11/19/80	PIN, LIGHTWEIGHT GROOVE PROPORTIONED 100° INTERMEDIATE COUNTERSUNK HEAD, SHEAR TYPE, STANDARD AND PULL-IN PINTAILS, SWAGE LOCKING, 6AL-4V TITANIUM. (95 KSI SHEAR)	(H)LGPL4SC-V(())(())(())
REVISED	08/12/21		
PAGE	5 OF 5		LGP105

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