



Howmet Fastening Systems
 Carson Operations
 900 E. Watson Center Road
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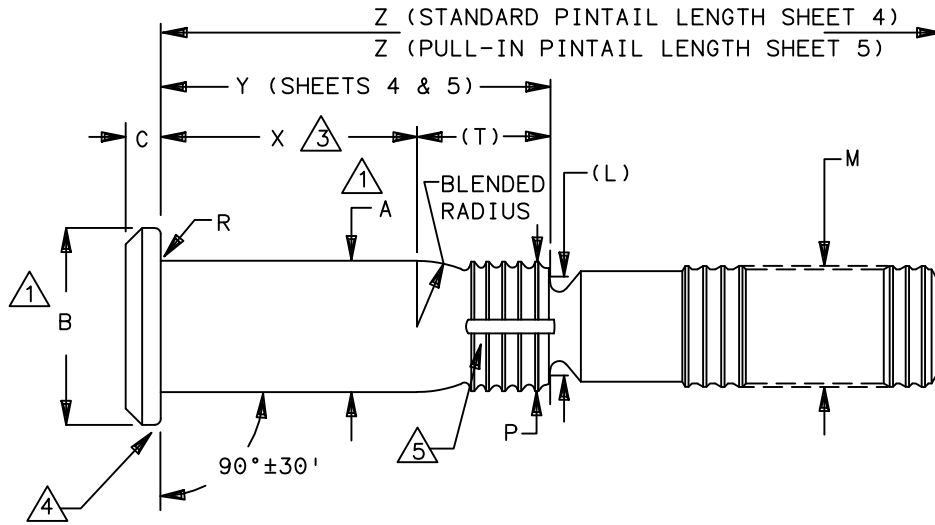
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ENGINEERING
 STANDARD

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 ±.010	C HEAD HEIGHT		(L) REF	M MAX	P DIA MAX	R RAD ±.005	S Δ	(T) REF
					MAX	MIN						
(H)LGPL4SP-V05(*)()()	.1640	.1630	.1630	.312	.056	.046	.126	.156	.156	.020	.0045	.150
(H)LGPL4SP-V06(*)()()	.1900	.1890	.1890	.367	.067	.057	.150	.184	.184	.020	.0045	.152
(H)LGPL4SP-V07(*)()()	.2187	.2177	.2177	.400	.074	.064	.173	.213	.213	.020	.0045	.210
(H)LGPL4SP-V08(*)()()	.2500	.2490	.2490	.425	.085	.075	.187	.244	.244	.020	.0045	.210
(H)LGPL4SP-V10(*)()()	.3125	.3115	.3115	.483	.102	.092	.244	.306	.306	.025	.0045	.269
(H)LGPL4SP-V12(*)()()	.3750	.3740	.3740	.553	.117	.107	.298	.370	.370	.025	.0060	.321
(H)LGPL4SP-V14(*)()()	.4375	.4365	.4365	.634	.129	.119	.312	.431	.431	.025	.0060	.376
(H)LGPL4SP-V16(*)()()	.5000	.4990	.4990	.689	.143	.133	.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 (SEE PAGE 5)

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

J16	REVISED COMPANY LOGO & UPDATED TRADEMARK INFORMATION. (REF. ECR2779)		
ISSUED	11/19/80	PIN, LIGHTWEIGHT GROOVE PROPORTIONED INTERMEDIATE PROTRUDING HEAD, SHEAR TYPE, STANDARD AND PULL-IN PINTAILS, SWAGE LOCKING, 6AL-4V TITANIUM. (95 KSI SHEAR)	(H)LGPL4SP-V()()()()
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J16



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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 (4SP) 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

J 16		REVISED COMPANY LOGO & UPDATED TRADEMARK INFORMATION. (REF. ECR2779)		
ISSUED	11/19/80	PIN, LIGHTWEIGHT GROOVE PROPORTIONED INTERMEDIATE PROTRUDING HEAD, SHEAR TYPE, STANDARD AND PULL-IN PINTAILS, SWAGE LOCKING, 6AL-4V TITANIUM. (95 KSI SHEAR)	(H)LGPL4SP-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)LGPL4SP-V05()()()	.1640	4010	3SLC-C05	1400	HG110-05
			SLC-MV05		
			SLC-M05	1500	HG137-05
			SLC-EU05	1850	
(H)LGPL4SP-V06()()()	.1900	5380	3SLC-C06	1600	HG110-06
			SLC-MV06		
			SLC-M06	2000	HG137-06
			SLC-EU06	2250	
(H)LGPL4SP-V07()()()	.2187	7200	3SLC-C07	2250	HG110-07
			SLC-M07		HG137-07
(H)LGPL4SP-V08()()()	.2500	9300	3SLC-C08	3000	HG110-08
			SLC-MV08		
			SLC-M08	3600	HG137-08
			SLC-EU08	3850	
(H)LGPL4SP-V10()()()	.3125	14600	3SLC-C10	5000	HG110-10
			SLC-MV10		
			SLC-M10	5550	HG137-10
			SLC-EU10		
(H)LGPL4SP-V12()()()	.3750	21000	3SLC-C12	7000	HG110-12
			SLC-MV12		
			SLC-M12	8340	HG137-12
			SLC-EU12		
(H)LGPL4SP-V14()()()	.4375	28600	3SLC-C14	9500	HG110-14
(H)LGPL4SP-V16()()()	.5000	37300	3SLC-C16	12500	HG110-16

DIMENSIONS IN INCHES

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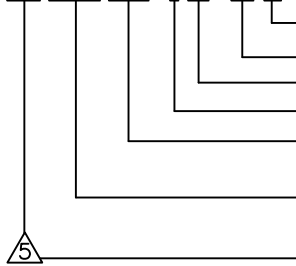
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STANDARD PINTAIL LENGTH

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	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
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)LGPL4SP-V08-06()



- FINISH SUFFIX (SEE FINISH CODE PAGE 2).
- GRIP LENGTH IN .0625 INCH INCREMENTS.
- SHANK DIA IN .03125 INCH INCREMENTS
- 6AL-4V TITANIUM.
- INTERMEDIATE 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

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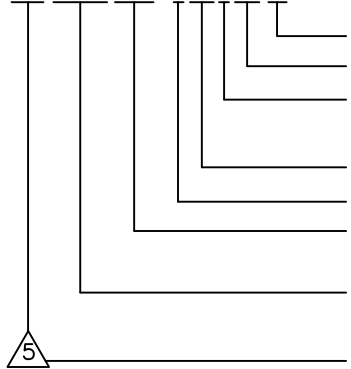
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STANDARD

LONG PULL-IN PINTAIL LENGTH

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
		GRIP NUMBER TABULATION																					
07	.359	.376	.438	.453	.438	.588	1.145	—	—	—	—	—	—	—	—	—	—	—	—	—	—		
08	.422	.439	.500	.516	.500	.650	1.270	—	—	.710	1.310	—	—	—	—	—	—	—	—	—	—		
09	.484	.501	.562	.578	.562	.712	1.395	.714	1.395	.772	1.435	—	—	—	—	—	—	—	—	—	—		
10	.547	.563	.625	.641	.625	.775	1.520	.777	1.520	.835	1.560	.835	1.565	—	—	—	—	—	—	—	—		
11	.609	.626	.688	.703	.688	.838	1.645	.840	1.645	.898	1.685	.898	1.690	.957	1.710	—	—	—	1.064	1.949	—	—	
12	.672	.689	.750	.766	.750	.900	1.770	.902	1.770	.960	1.810	.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	1.022	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	2.060	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	2.185	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	2.310	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	2.435	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	2.560	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	2.685	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	2.810	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	2.935	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	3.060	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	1.707	3.210	1.759	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) LGPL4SP-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.
INTERMEDIATE 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

J 16	REVISED COMPANY LOGO & UPDATED TRADEMARK INFORMATION. (REF. ECR2779)			
ISSUED	11/19/80	PIN, LIGHTWEIGHT GROOVE PROPORTIONED INTERMEDIATE PROTRUDING HEAD, SHEAR TYPE, STANDARD AND PULL-IN PINTAILS, SWAGE LOCKING, 6AL-4V TITANIUM. (95 KSI SHEAR)		(H) LGPL4SP-V() () () ()
REVISED	08/12/21			
PAGE	5 OF 5			LGP106

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