



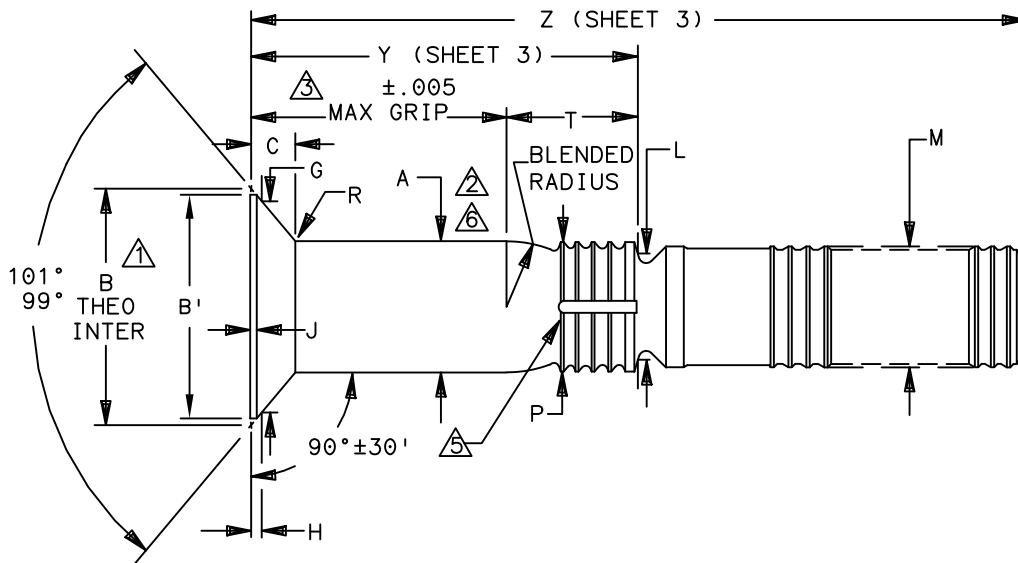
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LGP®

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	B THEO INTER NOM	B' HEAD DIA MIN	C HEAD HEIGHT NOM	G GAGE DIA ±.0001	H GAGE HEIGHT		J MAX	L REF	M MAX	P DIA MAX	R RAD ±.005	S \triangle 2	T REF
							MAX	MIN							
(H)LGPL4SCEB05()	.1640	.1635 .1630	.2775	.260	.0480	.2027	.0330	.0298	.010	.126	.156	.156	.020	.0045	.170
(H)LGPL4SCEB06()	.1900	.1895 .1890	.3224	.293	.0559	.2440	.0345	.0313	.015	.150	.184	.184	.025	.0045	.172
(H)LGPL4SCEB07()	.2187	.2182 .2177	.3715	.342	.0644	.2981	.0324	.0292	.015	.173	.213	.213	.025	.0045	.230
(H)LGPL4SCEB08()	.2500	.2495 .2490	.4234	.394	.0731	.3314	.0402	.0370	.015	.187	.244	.244	.025	.0045	.230

- 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 MAXIMUM GRIP IS MEASURED TO THE END OF THE FULL CYLINDRICAL PORTION OF THE SHANK.
- 4 DIMENSIONS B & C FOR ENGINEERING REFERENCE ONLY. NOT FOR INSPECTION PURPOSES
- 5 "V" OR "U" SHAPED SEALANT ESCAPE GROOVE MAY BE FORMED BY ROLLING, MILL OR SAW CUTTING. THE GROOVE MAY BE STRAIGHT (MILLED OR CUT) OR ON ANGLE (ROLLED). MANUFACTURER'S OPTION.
- 6 UNDERFILL PERMISSIBLE, MUST BE WITHIN "A" DIAMETER WHEN MEASURED WITH A STANDARD 1/4" (6,35 MM) DIAMETER MICROMETER.

MATERIAL: 7050-T73 ALUMINUM ALLOY PER QQ-A-430.

SHEAR STRENGTH: 41 TO 47 KSI.

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

DIMENSIONS IN INCHES

PROCUREMENT SPECIFICATION: C2027

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DRAWN BY	DH	FSCM (Cage Code) 71446 - Carson
CHECKED BY	MM	

ISSUED	03/16/98	PIN, LIGHTWEIGHT GROOVE PROPORTIONED 100° COUNTERSUNK TENSION HEAD, SHEAR TYPE SWAGE LOCKING, 7050-T73 ALUMINUM ALLOY (41/47 KSI SHEAR)	(H)LGPL4SCEB()()()
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FINISH: NO LETTER = CHEMICAL FILM PER MIL-C-5541 "GOLD" PLUS CETYL ALCOHOL LUBRICATION PER MIL-L-87132.

SUFFIX AE = CHEMICAL FILM PER MIL-C-5541 "GOLD" UNLUBRICATED.

SUFFIX AN = ANODIZE PER MIL-A-8625 "CLEAR" PLUS CETYL ALCOHOL LUBRICATION PER MIL-L-87132.

SUFFIX BS = ANODIZE PER MIL-A-8625 "CLEAR" PLUS DRIFILM LUBRICATION PER AS5272. (DIMENSIONS APPLY PRIOR TO LUBRICATION)

HEAD MARKING: HEADS SHALL BE MARKED WITH THE MANUFACTURER'S SYMBOL, THE BASIC NUMBER (LGP4), AND (EB) DEPRESSED .006 MAX DEPTH ARRANGEMENT OPTIONAL. FOR PINS SPECIFIED WITH A SEALANT ESCAPE GROOVE, AN "H" IS ADDED TO THE HEAD MARKING.

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

THE SECOND SET OF LETTERS & NUMBER (4SC) DESIGNATE HEAD SIZE, STYLE, AND LOAD APPLICATION.

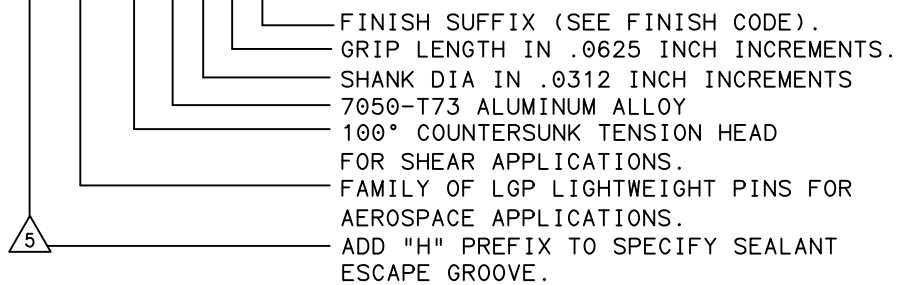
THE NEXT LETTERS (EB) IS THE MATERIAL DESIGNATOR FOR 7050-T73 ALUMINUM ALLOY, SHEAR STRENGTH: 41 TO 47 KSI.

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

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

SEE FINISH CODE FOR SUFFIX INFORMATION.

EXAMPLE: (H)LGPL4SCEB0606()



MECHANICAL PROPERTIES						
LGP PIN PART NUMBER	PIN NOM SIZE	SHEAR POUNDS		COLLAR PART NUMBER	MIN ULTIMATE TENSILE LBS WITH LISTED COLLAR	PIN POSITION SWAGE GAGE
		SINGLE	DOUBLE			
(H)LGPL4SCEB05()	.1640	856 987	1712 1974	3SLC-G05	495	HG171-05
(H)LGPL4SCEB06()	.1900	1150 1326	2300 2652	3SLC-F06	750	HG171-06
(H)LGPL4SCEB07()	.2187	1526 1758	3052 3516	3SLC-F07	1236	HG171-07
(H)LGPL4SCEB08()	.2500	1997 2298	3994 4596	3SLC-F08	1500	HG171-08

DIMENSIONS IN INCHES

B7

ISSUED	03/16/98	PIN, LIGHTWEIGHT GROOVE PROPORTIONED 100° COUNTERSUNK TENSION HEAD, SHEAR TYPE SWAGE LOCKING, 7050-T73 ALUMINUM ALLOY (41/47 KSI SHEAR)	(H)LGPL4SCEB()
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GRIP NUMBER TABULATION										
△ GRIP DASH NO.	DESIGN GRIP RANGE		05		06		07		08	
	MIN	MAX	Y ±.010	Z +.060 -.000	Y ±.010	Z +.060 -.000	Y ±.010	Z +.060 -.000	Y ±.010	Z +.060 -.000
02	.063	.125	.295	.972	.297	1.045	—	—	—	—
03	.126	.188	.358	1.035	.360	1.128	.418	1.210	.418	1.210
04	.189	.250	.420	1.160	.422	1.253	.480	1.335	.480	1.335
05	.251	.312	.482	1.285	.484	1.378	.542	1.460	.542	1.460
06	.313	.375	.545	1.410	.547	1.503	.605	1.585	.605	1.585
07	.376	.438	.608	1.535	.610	1.628	.668	1.710	.668	1.710
08	.439	.500	.670	1.660	.672	1.753	.730	1.835	.730	1.835
09	.501	.562	.732	1.785	.734	1.878	.792	1.960	.792	1.960
10	.563	.625	.795	1.910	.797	2.003	.855	2.085	.855	2.085
11	.626	.688	—	—	—	—	—	—	.918	2.210

DIMENSIONS IN INCHES

B₇

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