

**HOWMET
AEROSPACE**

Howmet Fastening Systems
Carson Operations
900 E. Watson Center Road
Carson, California 90745 U.S.A.

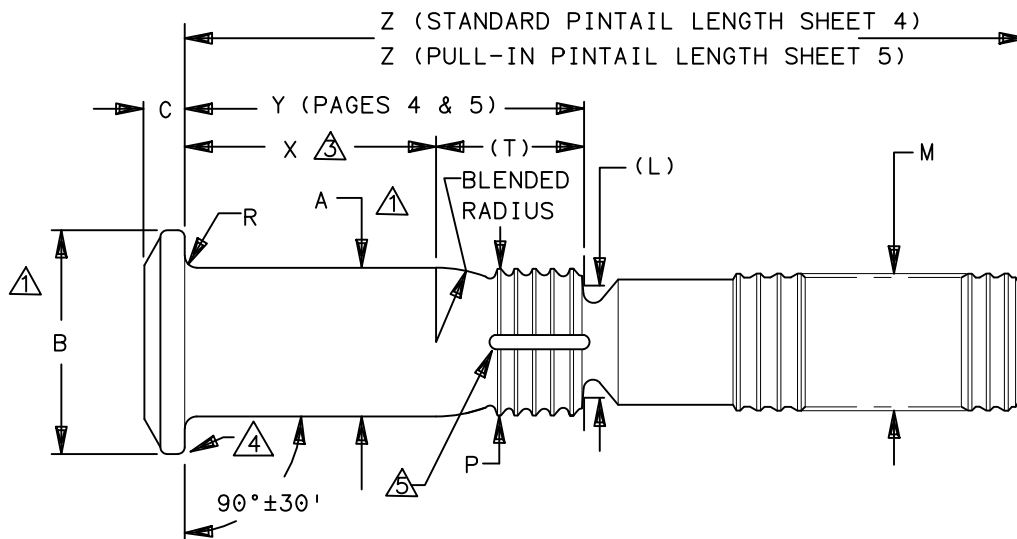
Phone (310) 830-8200
HFS_Carson_Engineering@howmet.com

Howmet Fastening Systems
Us Operations
Clos D' Asseville BP 30004
95450 Us Par Vigny France

Phone +33-1-30.27.95.00
Fax +33-1-34.66.06.00

LGP®

**ENGINEERING
STANDARD**



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

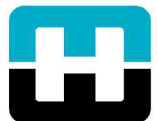
DRAWN BY	DLH	FSCM (Cage Code) 17446 - Carson FSCM (Cage Code) F6167 - France
CHECKED BY	MM	

L 17 REF ECR 3455; REVISED FINISH CODE DESCRIPTIONS FOR ALUMINUM COATING, ADDED
PERMISSIBLE ALUMINUM COATING TABLE, ADDED KG1123ZA AS A PERMISSIBLE COATING

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()()()()
REVISED	04/24/26		
PAGE	1 OF 5		

LGP102

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



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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.

PERMISSIBLE ALUMINUM COATINGS	
ALUMINUM COATING NAME	COATING SPECIFICATIONS
HI-KOTE™ 1	NAS4006 EN4473 TYPE I
HI-KOTE™ 1 NC	NAS4006NC EN4473 TYPE II
KAL-GARD 2240C	NAS4006
KAL-GARD 2242	NAS4006NC
KAL-GARD 2245	NAS4006 EN4473 TYPE I
KG1123ZA	NAS4006NC EN4473 TYPE II

AC = ALUMINUM COATING PER NAS4006 OR NAS4006NC, OPTIONAL ON PINTAIL END. PLUS CETYL ALCOHOL LUBE PER AS87132.

ACG = ALUMINUM COATING PER NAS4006 OR 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 PER EN4473 TYPE II, OPTIONAL ON PINTAIL END. PLUS CETYL ALCOHOL LUBE PER AS87132.

ACY = ALUMINUM COATING PER NAS4006 OR NAS4006NC, OPTIONAL ON PINTAIL END. IDENTIFY BY YELLOW COLOR ON PINTAIL END. PLUS CETYL ALCOHOL LUBE PER AS87132.

AD = ALUMINUM COATING PER EN4473 TYPE I OR EN4473 TYPE II, OPTIONAL ON PINTAIL END. OPTIONAL TO COLOR PINTAIL END WHITE. PLUS CETYL ALCOHOL LUBE PER AS87132.

APY = ALUMINUM COATING PER NAS4006 OR NAS4006NC, OPTIONAL ON PINTAIL END. IDENTIFY BY YELLOW COLOR ON PINTAIL END. APPLY SEALANT UNDER HEAD PER BMS5-95. 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.

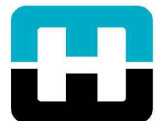
THE FINAL NUMBERS DESIGNATE THE GRIP LENGTH NUMBER OR THE NOMINAL PIN SHANK LENGTH IN .0625 INCH INCREMENTS.

SEE FINISH CODE FOR SUFFIX INFORMATION.

L17	REF ECR 3455; REVISED FINISH CODE DESCRIPTIONS FOR ALUMINUM COATING, ADDED PERMISSIBLE ALUMINUM COATING TABLE, ADDED KG1123ZA AS A PERMISSIBLE COATING			
	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()()()()
	REVISED	04/24/26		
	PAGE	2 OF 5		LGP102

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L17



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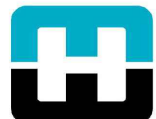
MECHANICAL PROPERTIES						
LGP PIN PART NUMBER	PIN NOM SIZE	MINIMUM DOUBLE SHEAR POUNDS	COLLAR PART NUMBER	MIN ULTIMATE TENSILE LBS WITH LISTED COLLAR	PIN POSITION SWAGE GAGE	
					EXCEPT "ACG" SUFFIX	"ACG" SUFFIX BOEING ONLY
(H)LGPL2SP-V05-()()()	.1640	4010	3SLC-C05	1400	HG110-05	HG160-05
			SLC-MV05		TBD	
			SLC-M05	1500		
			SLC-EU05	1850	HG137-05	
(H)LGPL2SP-V06-()()()	.1900	5380	3SLC-C06	1600	HG110-06	HG160-06
			SLC-MV06		TBD	
			SLC-M06	2000		
			SLC-EU06	2250	HG137-06	
(H)LGPL2SP-V08-()()()	.2500	9300	3SLC-C08	3000	HG110-08	HG160-08
			SLC-MV08		TBD	
			SLC-M08	3600		
			SLC-EU08	3850	HG137-08	
(H)LGPL2SP-V10-()()()	.3125	14600	3SLC-C10	5000	HG110-10	HG160-10
			SLC-MV10		TBD	
			SLC-M10			
			SLC-EU10	5550	HG137-10	
(H)LGPL2SP-V12-()()()	.3750	21000	3SLC-C12	7000	HG110-12	HG160-12
			SLC-MV12		TBD	
			SLC-M12			
			SLC-EU12	8340	HG137-12	
(H)LGPL2SP-V14-()()()	.4375	28600	3SLC-C14	9500	HG110-14	
(H)LGPL2SP-V16-()()()	.5000	37300	3SLC-C16	12500	HG110-16	

DIMENSIONS IN INCHES

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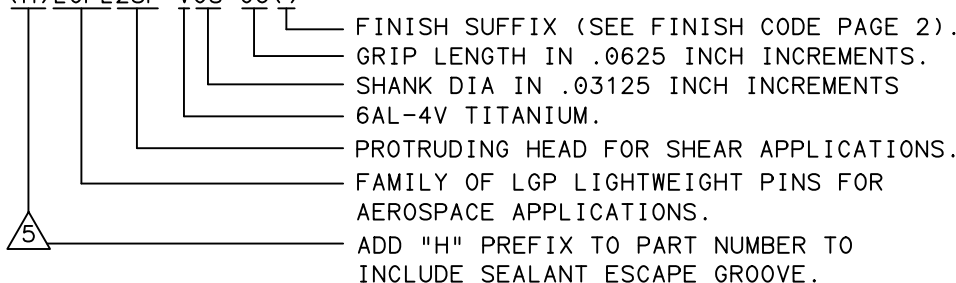
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STANDARD PINTAIL LENGTH

GRIP NUMBER TABULATION																			
GRIP DASH NO.	MINIMUM PERMISSIBLE GRIP OVERLAP	DESIGN GRIP RANGE		MAXIMUM PERMISSIBLE GRIP OVERLAP	X ±.005	05		06		08		10		12		14		16	
		MIN.	MAX.			Y ±.010	Z +.060 -.000	Y ±.010	Z +.060 -.000	Y ±.010	Z +.060 -.000	Y ±.010	Z +.060 -.000	Y ±.010	Z +.060 -.000	Y ±.010	Z +.060 -.000		
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()

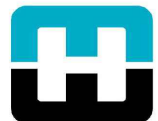


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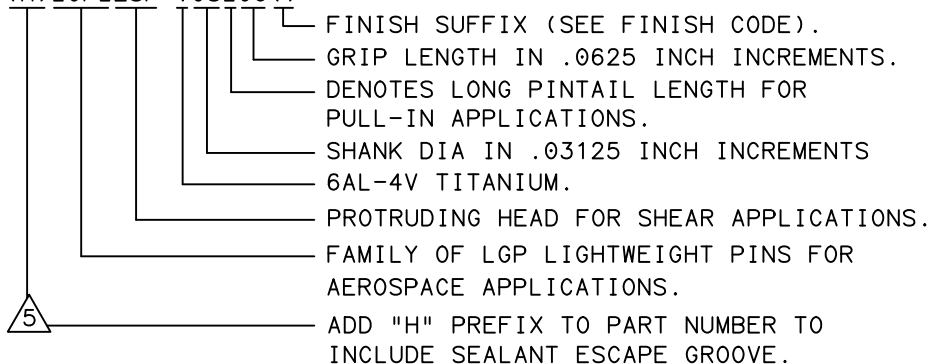
**ENGINEERING
STANDARD**

LONG PULL-IN PINTAIL LENGTH

GRIP NUMBER TABULATION

GRIP NUMBER TABULATION																			
GRIP DASH NO.	MINIMUM PERMISS- IBLE GRIP OVERLAP	DESIGN GRIP RANGE		MAXIMUM PERMISS- IBLE 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

REF ECR 3455; REVISED FINISH CODE DESCRIPTIONS FOR ALUMINUM COATING, ADDED
PERMISSIBLE ALUMINUM COATING TABLE, ADDED KG1123ZA AS A PERMISSIBLE COATING

ISSUED 11/24/80
REVISED 04/24/26
PAGE 5 OF 5

PIN, LIGHTWEIGHT GROOVE PROPORTIONED PROTRUDING
HEAD, SHEAR TYPE, STANDARD AND PULL-IN PINTAILS,
SWAGE LOCKING,
6AL-4V TITANIUM. (95 KSI SHEAR)

(H)LGPL2SP-V()()()()
LGP102