

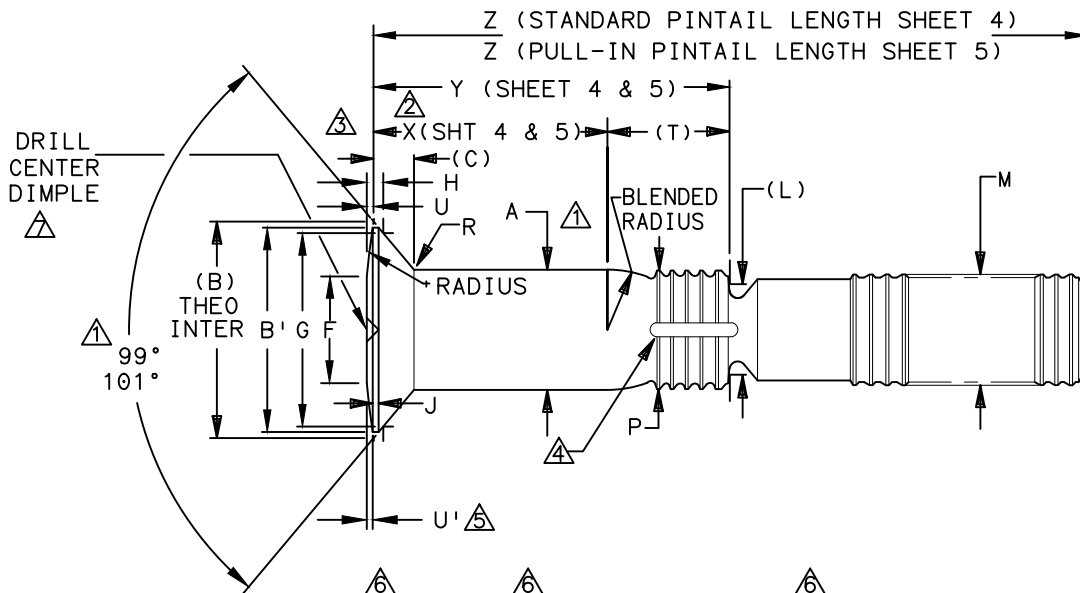
Howmet Fastening Systems
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LGP®
ENGINEERING
STANDARD



LGP PIN FAMILY NUMBER	NOM SIZE	A SHANK DIA +.0005 -.0000	A SHANK DIA COATED ±.0005	(B) THEO DIA NOM	B' HEAD DIA ±.0025	(C) HEAD HEIGHT NOM	F FLAT DIA ±.005	G GAGE DIA ±.0001	H GAGE HEIGHT MAX	J	(L) REF	M DIA MAX	P DIA MAX	R RAD ±.005	(T) REF	U ±.0010	U' REF
(H)LGPL18SCV05(*)()	.1640	.1630	.1630	.2569	.2435	.0394	.125	.2027	.0286 .0256		.126	.156	.156	.020	.150	.0043	.0035
(H)LGPL18SCV06(*)()	.1900	.1890	.1890	.2974	.2840	.0455	.156	.2440	.0282 .0252	.010 MAX	.150	.184	.184	.025	.152	.0043	.0035
(H)LGPL18SCV08(*)()	.2500	.2490	.2490	.3908	.3770	.0595	.190	.3314	.0316 .0286		.187	.244	.244	.025	.210	.0052	.0045
(H)LGPL18SCV10(*)()	.3125	.3115	.3115	.4695	.4525	.0663	.250	.4046	.0346 .0316	.012 MAX	.244	.306	.306	.035	.269	.0059	.0050
(H)LGPL18SCV12(*)()	.3750	.3740	.3740	.5556	.5390	.0762	.312	.4853	.0385 .0355		.298	.370	.370	.035	.321	.0075	.0065
(H)LGPL18SCV14(*)()	.4375	.4365	.4365	.6616	.6390	.0944	.375	.5697	.0495 .0465	.015 MAX	.312	.431	.431	.045	.376	.0094	.0080
(H)LGPL18SCV16(*)()	.5000	.4990	.4990	.7474	.7245	.1042	.438	.6499	.0529 .0499		.375	.492	.492	.045	.432	.0105	.0090

* 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 .003 TIR.
- ② GRIP LENGTH IS MEASURED FROM THE THEORETICAL INTERSECTION OF THE CROWN RADIUS AND HEAD ANGLE TO THE END OF THE FULL CYLINDRICAL PORTION OF THE SHANK.
- ③ DIMENSIONS (B), (C), U, Y AND Z ARE MEASURED FROM THE THEORETICAL INTERSECTION OF THE CROWN RADIUS AND HEAD ANGLE.
- ④ SEALANT ESCAPE GROOVE (SEE SHEET 4 & 5).
- ⑤ DIMENSION U' IS MEASURED AT TOP OF "J" LAND.
- ⑥ DIMENSIONS (B), (C) AND U' ARE FOR ENGINEERING REFERENCE ONLY AND ARE NOT TO BE USED FOR INSPECTION PURPOSES.
- ⑦ DRILL CENTER DIMPLE IN TOP OF HEAD .035 MAX DIA, .010 MAX DEPTH AND CONCENTRIC TO "A" WITHIN .008.

DIMENSIONS IN INCHES

PROCUREMENT SPECIFICATION: C2010

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

C ₁₆	CHANGED MAX HEAD ANGLE FROM 100° TO 101° ON SHEET 1 (REF. ECR 3309)	
ISSUED	09/08/92	PIN, LIGHTWEIGHT GROOVE PROPORTIONED
REVISED	03/30/26	100° CLOSE TOLERANCE CROWN COUNTERSUNK HEAD,
PAGE	1 OF 5	SHEAR TYPE, STANDARD AND PULL-IN PINTAILS,
		SWAGE LOCKING, 6AL-4V TITANIUM (95 KSI SHEAR)
		(H)LGPL18SCV()()()()
		LGP109



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

MINIMUM SHEAR STRENGTH: 95 KSI.

SURFACE TEXTURE: Ra MAX PER ANSI-B46.1 BEFORE COATING. CONICAL 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 MIL-L-87132.

SUFFIX "ACG" = ALUMINUM COAT (KAL-GARD 2242 OR HI-KOTE I) IDENTIFIED BY GREEN COLOR ON PINTAIL END PLUS CETYL ALCOHOL LUBE PER MIL-L-8712. (APPLICABLE TO "H" TYPE SEALANT ESCAPE GROOVE FASTENERS FOR BOEING ONLY).

SUFFIX "ACY" = ALUMINUM COAT (KAL-GARD 2242 OR HI-KOTE I) PER IDENTIFIED IDENTIFIED BY YELLOW COLOR ON THE PINTAIL END PLUS CETYL ALCOHOL LUBE PER MIL-L-87132.

SUFFIX "APY" = ALUMINUM COAT (KAL-GARD 2242 OR HI-KOTE I) PER BMS 10-85 IDENTIFIED BY YELLOW COLOR ON PINTAIL END PLUS APPLY SEALANT UNDER HEAD PER BMS-5-95 AND CETYL ALCOHOL LUBE PER MIL-L-87132.

SUFFIX "AS" = SULFURIC ACID ANODIZE (BLUE) PER ISO 8080 PLUS CETYL ALCOHOL LUBE PER MIL-L-87132.

SUFFIX "B" = UNCOATED PIN AND NO LUBRICATION.

SUFFIX "D" = ION VAPOR DEPOSITED ALUMINUM COATING PER MIL-DTL-83488 TYPE II CLASS 3 OPTIONAL TO COLOR PINTAIL END BLACK, PLUS CETYL ALOCHOL LUBE PER MIL-L-87132.

SUFFIX "EPR" = PHOSPHATE FLUORIDE PER BAC5861. IDENTIFIED BY RED COLOR ON THE TYPE II CLASS 3 PLUS CETYL ALCOHOL LUBE PER MIL-L-87132.

SUFFIX "PB" = POWDERED BLAST TOP SURFACE OF HEAD PLUS CETYL ALCOHOL LUBE PER MIL-L-87132 (Ra 50/80 SURFACE ROUGHNESS).

HEAD MARKING: HEADS SHALL BE MARKED WITH THE MANUFACTURER'S SYMBOL, THE BASIC NUMBER (LGP18) 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 18SC 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.

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

C 16	CHANGED MAX HEAD ANGLE FROM 100° TO 101° ON SHEET 1 (REF. ECR 3309)			
ISSUED	09/08/92	PIN, LIGHTWEIGHT GROOVE PROPORTIONED 100° CLOSE TOLERANCE CROWN COUNTERSUNK HEAD, SHEAR TYPE, STANDARD AND PULL-IN PINTAILS, SWAGE LOCKING, 6AL-4V TITANIUM (95 KSI SHEAR)	(H)LGPL18SCV()(())()	
REVISED	03/30/26			
PAGE	2 OF 5		LGP109	

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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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)LGPL18SCV05()()()	.1640	4010	3SLC-C05	1290	HG110-05	HG160-05
			SLC-MV05		TBD	
			SLC-M05			
			SLC-EU05		HG137-05	
(H)LGPL18SCV06()()()	.1900	5380	3SLC-C06	1600	HG110-06	HG160-06
			SLC-MV06		TBD	
			SLC-M06	2000		
			SLC-EU06	2250	HG137-06	
(H)LGPL18SCV08()()()	.2500	9300	3SLC-C08	3000	HG110-08	HG160-08
			SLC-MV08		TBD	
			SLC-M08	3600		
			SLC-EU08	3850	HG137-08	
(H)LGPL18SCV10()()()	.3125	14600	3SLC-C10	5000	HG110-10	HG160-10
			SLC-MV10		TBD	
			SLC-M10			
			SLC-EU10	5550	HG137-10	
(H)LGPL18SCV12()()()	.3750	21000	3SLC-C12	7000	HG110-12	HG160-12
			SLC-MV12		TBD	
			SLC-M12			
			SLC-EU12	8340	HG137-12	
(H)LGPL18SCV14()()()	.4375	28600	3SLC-C14	9500	HG110-14	
(H)LGPL18SCV16()()()	.5000	37300	3SLC-C16	12500	HG110-16	

DIMENSIONS IN INCHES

C₁₅

CHANGED MAX HEAD ANGLE FROM 100° TO 101° ON SHEET 1 (REF. ECR 3309)

ISSUED	09/08/92	PIN, LIGHTWEIGHT GROOVE PROPORTIONED 100° CLOSE TOLERANCE CROWN COUNTERSUNK HEAD SHEAR TYPE, STANDARD AND PULL-IN PINTAILS, SWAGE LOCKING, 6AL-4V TITANIUM. (95 KSI SHEAR)	(H)LGPL18SCV()()()()
REVISED	03/30/26		
PAGE	3 OF 5		LGP109



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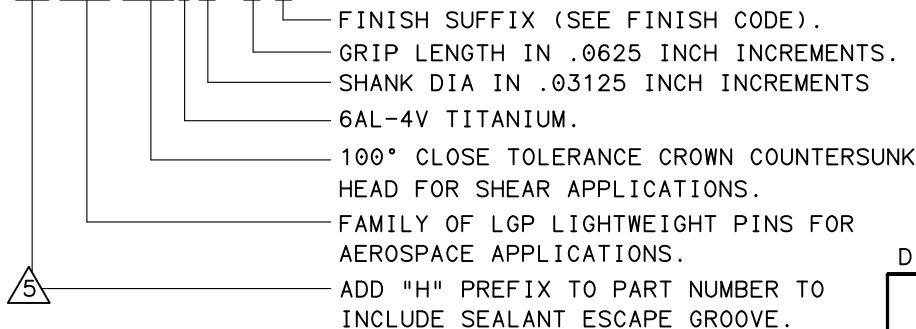
ENGINEERING
STANDARD

STANDARD PINTAIL LENGTH

GRIP NUMBER TABULATION																			
GRIP DASH NO.	MINIMUM PERMIS- SIBLE GRIP OVERLAP	DESIGN GRIP RANGE		MAXIMUM PERMIS- SIBLE 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	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

PART NO (H)LGPL18SCV08-06()

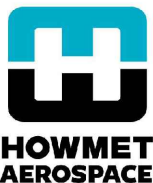
EXAMPLE:



DIMENSIONS IN INCHES

C₁₆ CHANGED MAX HEAD ANGLE FROM 100° TO 101° ON SHEET 1 (REF. ECR 3309)

ISSUED	09/08/92	PIN, LIGHTWEIGHT GROOVE PROPORTIONED 100° CLOSE TOLERANCE CROWN COUNTERSUNK HEAD SHEAR TYPE, STANDARD AND PULL-IN PINTAILS, SWAGE LOCKING, 6AL-4V TITANIUM (95 KSI SHEAR)	(H)LGPL18SCV()()()()
REVISED	03/30/26		
PAGE	4 OF 5		LGP109



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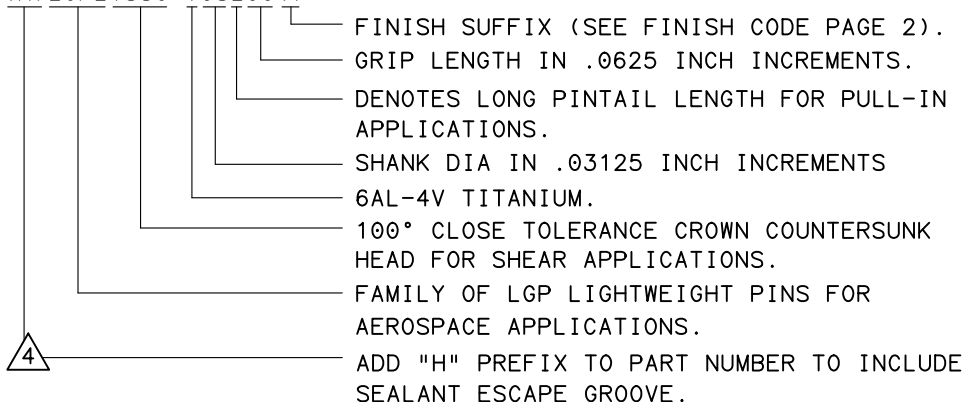
ENGINEERING
STANDARD

LONG PULL-IN PINTAIL LENGTH

GRIP NUMBER TABULATION																			
GRIP DASH NO.	MINIMUM PERMIS- SIBLE GRIP OVERLAP	DESIGN GRIP RANGE		MAXIMUM PERMIS- SIBLE 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
						±.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	1.231	—	—	—	—	—	—	—	—	—	—	—	—
09	.484	.501	.562	.578	.562	.712	1.356	.714	1.350	—	—	—	—	—	—	—	—	—	—
10	.547	.563	.625	.641	.625	.775	1.481	.777	1.475	—	—	—	—	—	—	—	—	—	—
11	.609	.626	.688	.703	.688	.838	1.606	.840	1.600	.898	1.631	—	—	—	—	—	—	—	—
12	.672	.689	.750	.766	.750	.900	1.731	.902	1.725	.960	1.756	1.019	1.769	—	—	—	—	—	—
13	.734	.751	.812	.828	.812	.962	1.856	.964	1.850	1.022	1.881	1.081	1.894	—	—	1.188	2.103	—	—
14	.797	.813	.875	.891	.875	1.025	1.981	1.027	1.975	1.085	2.006	1.144	2.019	1.196	2.009	1.251	2.228	—	—
15	.859	.876	.938	.953	.938	1.088	2.106	1.090	2.100	1.148	2.131	1.207	2.144	1.259	2.134	1.314	2.353	—	—
16	.922	.939	1.000	1.016	1.000	1.150	2.231	1.152	2.225	1.210	2.256	1.269	2.269	1.321	2.259	1.376	2.478	1.432	2.485
17	.984	1.001	1.062	1.078	1.062	—	—	—	—	1.272	2.381	1.331	2.394	1.383	2.384	1.438	2.603	1.494	2.610
18	1.047	1.063	1.125	1.141	1.125	—	—	—	—	1.335	2.506	1.394	2.519	1.446	2.509	1.501	2.728	1.557	2.735
19	1.109	1.126	1.188	1.203	1.188	—	—	—	—	1.398	2.631	1.457	2.644	1.509	2.634	1.564	2.853	1.620	2.860
20	1.172	1.189	1.250	1.266	1.250	—	—	—	—	1.460	2.756	1.519	2.769	1.571	2.759	1.626	2.978	1.682	2.985
21	1.234	1.251	1.312	1.328	1.312	—	—	—	—	1.522	2.881	1.581	2.894	1.633	2.884	1.688	3.103	1.744	3.110
22	1.297	1.313	1.375	1.391	1.375	—	—	—	—	1.585	3.006	1.644	3.019	1.696	3.009	1.751	3.228	1.807	3.235
23	1.359	1.376	1.438	1.453	1.438	—	—	—	—	—	—	1.707	3.144	1.759	3.134	1.814	3.353	1.870	3.360
24	1.422	1.439	1.500	1.516	1.500	—	—	—	—	—	—	1.769	3.269	1.821	3.259	1.876	3.478	1.932	3.485
25	1.484	1.501	1.562	1.578	1.562	—	—	—	—	—	—	1.831	3.394	1.883	3.384	1.938	3.603	1.994	3.610
26	1.547	1.563	1.625	1.641	1.625	—	—	—	—	—	—	1.894	3.519	1.946	3.509	2.001	3.728	2.057	3.735
27	1.609	1.626	1.688	1.703	1.688	—	—	—	—	—	—	—	—	2.009	3.634	2.064	3.853	2.120	3.860
28	1.672	1.689	1.750	1.766	1.750	—	—	—	—	—	—	—	—	2.071	3.759	2.126	3.978	2.182	3.985
29	1.734	1.751	1.812	1.828	1.812	—	—	—	—	—	—	—	—	2.133	3.884	2.188	4.103	2.244	4.110
30	1.797	1.813	1.875	1.891	1.875	—	—	—	—	—	—	—	—	2.196	4.009	2.251	4.228	2.307	4.235
31	1.859	1.876	1.938	1.953	1.938	—	—	—	—	—	—	—	—	2.259	4.134	2.314	4.353	2.370	4.360
32	1.922	1.939	2.000	2.016	2.000	—	—	—	—	—	—	—	—	2.321	4.259	2.376	4.478	2.432	4.485

PART NO.

EXAMPLE: (H)LGPL18SC-V08L06()



DIMENSIONS IN INCHES

C₁₆ CHANGED MAX HEAD ANGLE FROM 100° TO 101° ON SHEET 1 (REF. ECR 3309)

ISSUED	09/08/92	PIN, LIGHTWEIGHT GROOVE PROPORTIONED 100° CLOSE TOLERANCE CROWN COUNTERSUNK HEAD, SHEAR TYPE, STANDARD AND LONG PINTAILS, SWAGE LOCKING, 6AL-4V TITANIUM. (95 KSI SHEAR)	(H)LGPL18SCV()()()()
REVISED	03/30/26		
PAGE	5 OF 5		LGP109