

FED. SUPPLY CLASS

5315

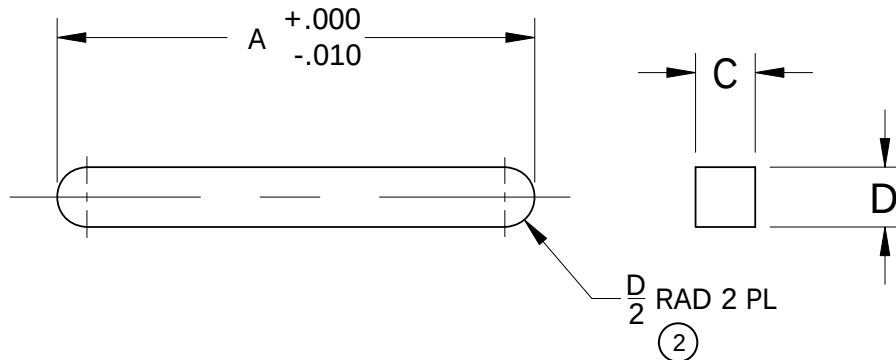


TABLE I – LIMITS FOR DIMENSIONS C AND D

|         | NOMINAL SIZE |             |           |             |           |             |           |
|---------|--------------|-------------|-----------|-------------|-----------|-------------|-----------|
|         | 1/16 x 1/16  | 3/32 x 3/32 | 1/8 x 1/8 | 3/16 x 3/16 | 1/4 x 1/4 | 5/16 x 5/16 | 3/8 x 3/8 |
| MAXIMUM | .0635        | .0948       | .126      | .1885       | .251      | .3135       | .376      |
| MINIMUM | .0625        | .0937       | .125      | .1875       | .250      | .3125       | .375      |

|         | NOMINAL SIZE |           |             |           |           |           |       |
|---------|--------------|-----------|-------------|-----------|-----------|-----------|-------|
|         | 7/16 x 7/16  | 1/2 x 1/2 | 9/16 x 9/16 | 5/8 x 5/8 | 3/4 x 3/4 | 7/8 x 7/8 | 1 x 1 |
| MAXIMUM | .4395        | .501      | .5635       | .626      | .751      | .876      | 1.001 |
| MINIMUM | .4375        | .500      | .5625       | .625      | .750      | .875      | 1.000 |

**MATERIAL:**

ALLOY STEEL, GRADE B, IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.

CARBON STEEL, GRADE C, IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.

**SHEAR STRENGTH (MIN):**

SHEAR STRENGTH FOR GRADES B AND C MATERIAL SHALL CONFORM TO THE PROCUREMENT SPECIFICATION.

**HARDNESS:**

GRADE B KEYS SHALL BE HARDENED IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.

**FINISH:**

UNCOATED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS20068, REVISION A. PART NUMBERS REMAIN MS20068.

|                              |                                                                                     |                                        |                                                           |
|------------------------------|-------------------------------------------------------------------------------------|----------------------------------------|-----------------------------------------------------------|
| THIRD<br>ANGLE<br>PROJECTION |  | CUSTODIAN                              | REVISION                                                  |
|                              |                                                                                     | NATIONAL AEROSPACE STANDARDS COMMITTEE | 2                                                         |
| PROCUREMENT<br>SPECIFICATION | OO-K-220                                                                            | TITLE                                  | CLASSIFICATION<br>PART STANDARD                           |
|                              |                                                                                     |                                        | KEY, MACHINE, SQUARE IN CROSS SECTION,<br>BOTH ENDS ROUND |

## EXAMPLE OF PART NUMBER:

THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE II.

② MS20068-1 = KEY, ALLOY STEEL GRADE B, 1/16 x 1/16 x .2500 LONG.

## NOTES:

- (1) EDGES AND CORNERS SHALL BE ROUNDED .015 ±.005 RADIUS.
- (2) THE KEYS COVERED IN THIS STANDARD CORRESPOND TO TYPE II, STYLE 2 OF THE PROCUREMENT SPECIFICATION.
- (3) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- ② (4) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (5) DIMENSIONS IN INCHES.
- (6) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (7) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

TABLE II – DASH NUMBERS

| LENGTH<br>A | DASH NUMBER |         |             |         |           |         |             |         |
|-------------|-------------|---------|-------------|---------|-----------|---------|-------------|---------|
|             | 1/16 x 1/16 |         | 3/32 x 3/32 |         | 1/8 x 1/8 |         | 3/16 x 3/16 |         |
|             | GRADE B     | GRADE C | GRADE B     | GRADE C | GRADE B   | GRADE C | GRADE B     | GRADE C |
| .2500       | 1           | 4       | 7           | 28      | 49        | 70      | 91          | 114     |
| .3125       | 2           | 5       | 8           | 29      | 50        | 71      | 92          | 115     |
| .3750       | 3           | 6       | 9           | 30      | 51        | 72      | 93          | 116     |
| .4375       |             |         | 10          | 31      | 52        | 73      | 94          | 117     |
| .5000       |             |         | 11          | 32      | 53        | 74      | 95          | 118     |
| .7500       |             |         | 12          | 33      | 54        | 75      | 96          | 119     |
| .8750       |             |         | 13          | 34      | 55        | 76      | 97          | 120     |
| 1.0000      |             |         | 14          | 35      | 56        | 77      | 98          | 121     |
| 1.1250      |             |         | 15          | 36      | 57        | 78      | 99          | 122     |
| 1.2500      |             |         | 16          | 37      | 58        | 79      | 100         | 123     |
| 1.3750      |             |         | 17          | 38      | 59        | 80      | 101         | 124     |
| 1.5000      |             |         | 18          | 39      | 60        | 81      | 102         | 125     |
| 1.7500      |             |         | 19          | 40      | 61        | 82      | 103         | 126     |
| 2.0000      |             |         | 20          | 41      | 62        | 83      | 104         | 127     |
| 2.2500      |             |         | 21          | 42      | 63        | 84      | 105         | 128     |
| 2.5000      |             |         | 22          | 43      | 64        | 85      | 106         | 129     |
| 3.0000      |             |         | 23          | 44      | 65        | 86      | 107         | 130     |
| 3.5000      |             |         | 24          | 45      | 66        | 87      | 108         | 131     |
| 4.0000      |             |         | 25          | 46      | 67        | 88      | 109         | 132     |
| 4.5000      |             |         | 26          | 47      | 68        | 89      | 110         | 133     |
| 5.0000      |             |         | 27          | 48      | 69        | 90      | 111         | 134     |
| 5.5000      |             |         |             |         |           |         | 112         | 135     |
| 6.0000      |             |         |             |         |           |         | 113         | 136     |

REVISION

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**NASM20068**

SHEET 2



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