

FED. SUPPLY CLASS

5315

This specification is approved for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers requirements for alloy steel woodruff keys.

1.2 Classification. The keys shall be of the following types:

Type I – Full length key

Type II – Flat end key

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications and standards. The following specifications and standards form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of these documents shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation.

Military

MIL-STD-2073-1

Standard Practice for Military Packaging

(Copies of specifications, standards and Government documents required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting activity.)

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of the documents which are DOD adopted shall be those listed in the issue of the DODISS specified in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS shall be the issue of the non-government documents which is current on the date of the solicitation.

American Society for Quality (ASQ)

ASQ Z1.4

Sampling Procedures and Tables for Inspection by Attributes

(Copies of ASQ publications can be obtained from the American Society for Quality, 600 North Plankinton Avenue, Milwaukee, WI 53203.)

Aerospace Industries Association (AIA)

NASM1312

Fasteners, Test Methods

NASM35756

Keys, Woodruff - Steel Alloy, With Keyway and Key Slot Dimensions

(Copies of AIA publications can be obtained from the Aerospace Industries Association, 1000 Wilson Boulevard, Suite 1700, Arlington, VA, 22209. www.aia-aerospace.org)

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THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MIL-K-27545B.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION NONE	TITLE KEY, WOODRUFF, ALLOY STEEL	CLASSIFICATION SPECIFICATION NASM27545 SHEET 1 OF 4

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME
PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST
REVISION DATE.

FORM 09-01

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ISSUE DATE: OCTOBER 1998

American Society for Testing and Materials (ASTM)

ASTM A 29/A 29M Steel Bars, Carbon and Alloy, Hot Wrought and Cold Finished, General Requirements for.
ASTM D 3951 Standard Practice for Commercial Packaging

(Copies of ASTM publications can be obtained from ASTM International, 100 Barr Harbor Drive, West
Conshohocken, PA 19428-2959.)

Society of Automotive Engineers (SAE)

SAE J502 Woodruff Keys.
SAE J503 Woodruff Key Slots and Keyways.
AMS2759 Heat Treatment of Steel Parts

(Copies of SAE publications can be obtained from SAE International, 400 Commonwealth Drive, Warrendale, PA
15096.)

(Non-government standards and other publications are normally available from the organizations which prepare or
which distribute the documents. These documents also may be available in or through libraries or other
informational services.)

- 2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein
(except for associated detail specifications, specification sheets or NASM standards), the text of this specification
shall take precedence. Nothing in this specification, however, shall supersede applicable laws and regulations unless
a specific exemption has been obtained.

3. REQUIREMENTS

- 3.1 Part standards. The individual item requirements shall be as specified herein and in accordance with the applicable
NASM part standard. In the event of any conflict between the requirements of this specification and the
specification sheet or standard, the latter shall govern.
- 3.2 Material. Keys shall be manufactured from alloy steel, Grades 4130 (UNS G41300) or 8630 (UNS G86300) as
specified in ASTM A 29/A 29M.
- 3.3 Dimensions. Dimensions and tolerances for keys shall be in accordance with the NASM part standard (see 3.1) or
SAE J502, SAE J503 as applicable.
- 3.4 Hardness. Keys shall have a hardness of 40–50 HRC (see 4.3.2).
- 3.5 Workmanship. The workmanship shall be uniform in quality and free of irregularities or detrimental defects. The
surfaces shall not contain any foreign matter. Edges and corners, as applicable, shall be broken or rounded.

4. QUALITY ASSURANCE PROVISIONS

- 4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is
responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in
the contract or purchase order, the contractor may use his own or any other facilities suitable for the performance
of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves
the right to perform any of the inspections set forth in the specification where such inspections are deemed
necessary to assure supplies and services conform to prescribed requirements.

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SHEET 2



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