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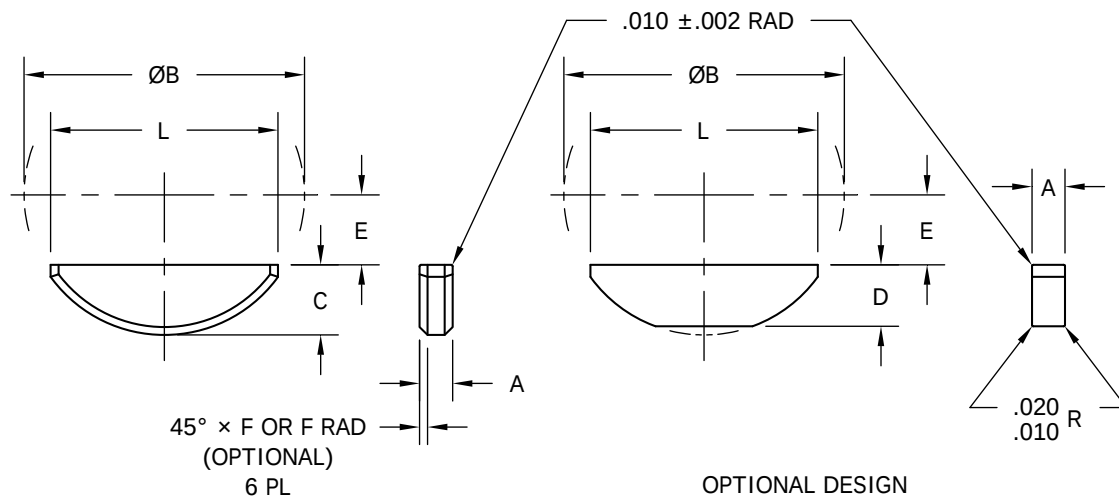
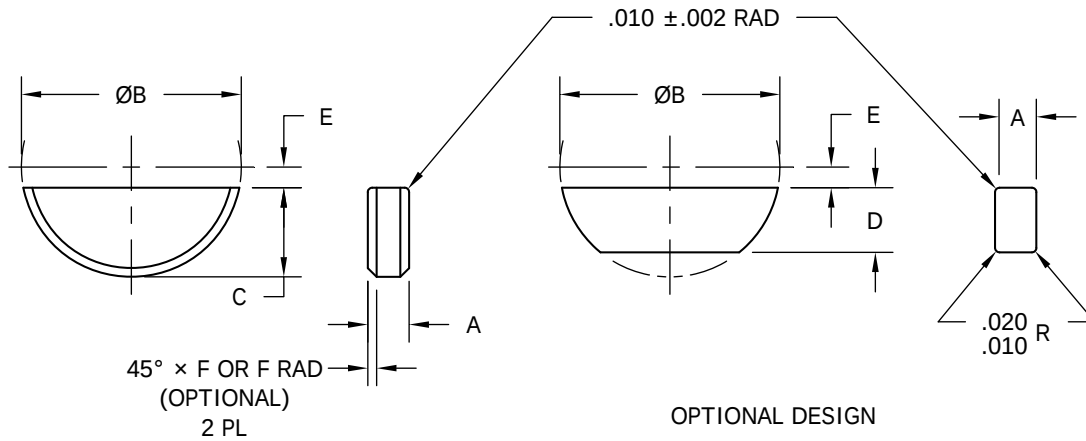


FIGURE 1 – DIMENSIONS FOR TYPES I & II

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REVISION
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PROCUREMENT
SPECIFICATION

TITLE

CLASSIFICATION
PART STANDARD

NASM27545

**KEY, WOODRUFF, STEEL, ALLOY,
WITH KEYWAY AND KEY SLOT DIMENSIONS**

NASM35756
SHEET 1 OF 8

TABLE I – TYPE I DASH NUMBERS AND DIMENSIONS

DASH NO	KEY SIZE NOMINAL	SAE NO	KEY DIMENSIONS					F		KEY AREA AT SHEAR LINE
			WIDTH A +.001 -.000	DIAMETER B +.000 -.010	HEIGHT					
					C +.000 -.005	D +.000 -.006	E NOMINAL	DIM	TOL	
1	1/16 x 1/4	201	.0625	.250	.109	-	1/64	.010		.0145
31	1/16 x 5/16	206	.0625	.312	.140	-	1/64			.0184
32	1/16 x 3/8	211	.0625	.375	.172	-	1/64			.0225
4	1/16 x 1/2	1	.0625	.500	.203	.194	1/64			.0296
2	3/32 x 5/16	207	.0938	.312	.140	-	1/64			.0264
33	3/32 x 3/8	212	.0938	.375	.172	-	1/64	.020		.0328
5	3/32 x 1/2	2	.0938	.500	.203	.194	3/64			.0434
7	3/32 x 5/8	4	.0938	.625	.250	.240	1/16			.0523
3	1/8 x 3/8	213	.1250	.375	.172	-	1/64			.0420
6	1/8 x 1/2	3	.1250	.500	.203	.194	3/64			.0512
8	1/8 x 5/8	5	.1250	.625	.250	.240	1/16	.030	+.010 -.000	.0716
10	1/8 x 3/4	7	.1250	.750	.313	.303	1/16			.0884
9	5/32 x 3/8	6	.1563	.625	.250	.240	1/16			.0871
11	5/32 x 1/2	8	.1563	.750	.313	.303	1/16			.1086
13	5/32 x 7/8	10	.1563	.875	.375	.365	1/16			.1294
34	3/16 x 5/8	61	.1875	.625	.250	.240	1/16	.040		.0105
12	3/16 x 3/4	9	.1875	.750	.313	.303	1/16			.1279
14	3/16 x 7/8	11	.1875	.875	.375	.365	1/16			.1531
16	3/16 x 1	13	.1875	1.000	.438	.428	1/16			.1781
19	3/16 x 1-1/8	16	.1875	1.125	.484	.475	5/64			.2007
39	3/16 x 1-1/4	19	.1875	1.250	.547	.537	5/64			.2284
36	7/32 x 7/8	12	.2188	.875	.375	.365	1/16			.1813
37	7/32 x 1	14	.2188	1.000	.438	.428	1/16			.2100
38	7/32 x 1-1/8	17	.2188	1.125	.484	.475	5/64			.2320
40	7/32 x 1-1/4	20	.2188	1.250	.547	.537	5/64			.2608
35	1/4 x 3/4	91	.2500	.750	.313	.303	1/16			.1623
15	1/4 x 7/8	A	.2500	.875	.375	.365	1/16			.1976
17	1/4 x 1	15	.2500	1.000	.438	.428	1/16			.2320
20	1/4 x 1-1/8	18	.2500	1.125	.484	.475	5/64			.2622
22	1/4x1-1/4	21	.2500	1.250	.547	.537	5/64			.2955
25	1/4 x 1-3/8	22	.2500	1.375	.594	.584	3/32	.050	+.015 -.000	.3259
28	1/4 x 1-1/2	24	.2500	1.500	.641	.631	7/64			.3562
18	5/16 x 1	B	.3125	1.000	.438	.428	1/16			.2811
21	5/16 x 1-1/8	C	.3125	1.125	.484	.475	5/64			.3193
23	5/16 x 1-1/4	D	.3125	1.250	.547	.537	5/64			.3621
26	5/16 x 1-3/8	23	.3125	1.375	.594	.584	3/32			.4003
29	5/16 x 1-1/2	25	.3125	1.500	.641	.631	7/64			.4384
24	3/8 x 1-1/4	E	.3750	1.250	.547	.537	5/64			.4243
27	3/8 x 1-3/8	F	.3750	1.375	.594	.584	3/32			.4705
30	3/8 x 1-1/2	G	.3750	1.500	.641	.631	7/64			.5166

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TABLE II – TYPE II DASH NUMBERS AND DIMENSIONS

DASH NO	KEY SIZE NOMINAL	SAE NO	KEY DIMENSIONS					F		KEY AREA AT SHEAR LINE	LENGTH L + .000 - .010
			WIDTH A + .001 - .000	DIAMETER B + .000 - .010	HEIGHT						
					C + .000 - .005	D + .000 - .006	E NOMINAL	DIM	TOL		
109	3/16 x 2-1/8	126	.1875	2.125	.406	.396	21/32	.060	+.015 - .000	.2578	1.380
111	3/16 x 2-1/8	26	.1875	2.125	.531	.521	17/32			.3222	1.723
101	1/4 x 2-1/8	127	.2500	2.125	.406	.396	21/32			.3437	1.380
112	1/4 x 2-1/8	27	.2500	2.125	.531	.521	17/32			.4178	1.723
103	1/4 x 2-3/4	RX	.2500	2.750	.594	.584	25/32			.5000	2.000
117	1/4 x 2-3/4	R	.2500	2.750	.750	.740	5/8			.5718	2.317
110	5/16 x 2-1/8	128	.3125	2.125	.406	.396	21/32			.4296	1.380
113	5/16 x 2-1/8	28	.3125	2.125	.531	.521	17/32			.5062	1.723
115	5/16 x 2-3/4	SX	.3125	2.750	.594	.584	25/32			.6286	2.000
118	5/16 x 2-3/4	S	.3125	2.750	.750	.740	5/8			.7071	2.317
102	3/8 x 2-1/8	129	.3750	2.125	.406	.396	21/32			.4833	1.380
114	3/8 x 2-1/8	29	.3750	2.125	.531	.521	17/32			.5868	1.723
104	3/8 x 2-3/4	TX	.3750	2.750	.594	.584	25/32			.6943	2.000
119	3/8 x 2-3/4	T	.3750	2.750	.750	.740	5/8			.8319	2.317
122	3/8 x 3-1/2	30	.3750	3.500	.938	.927	13/16			1.0781	2.880
116	7/16 x 2-3/4	UX	.4375	2.750	.594	.584	25/32			.8253	2.000
120	7/16 x 2-3/4	U	.4375	2.750	.750	.740	5/8			.9499	2.317
123	7/16 x 3-1/2	31	.4375	3.500	.938	.927	13/16			1.2371	2.880
105	1/2 x 2-3/4	VX	.5000	2.750	.594	.584	25/32	.9094	2.000		
121	1/2 x 2-3/4	V	.5000	2.750	.750	.740	5/8	1.0606	2.317		
106	1/2 x 3-1/2	32	.5000	3.500	.938	.927	13/16	1.3905	2.880		
124	9/16 x 3-1/2	33	.5625	3.500	.938	.927	13/16	1.5368	2.880		
107	5/8 x 3-1/2	34	.6250	3.500	.938	.927	13/16	1.6755	2.880		
125	11/16 x 3-1/2	35	.6875	3.500	.938	.927	13/16	1.8062	2.880		
108	3/4 x 3-1/2	36	.7500	3.500	.938	.927	13/16	1.9281	2.880		

REQUIREMENTS:

- MATERIAL. ALLOY STEEL IN ACCORDANCE WITH ASTM A322, GRADE 4130 (UNS G41300) OR GRADE 8630 (UNS G86300).
- PROTECTIVE COATING. ALLOY STEEL KEYS SHALL BE UNCOATED.
- HARDNESS. ALLOY STEEL KEYS SHALL HAVE A HARDNESS OF 38 TO 45 HRC.
- PART NUMBER. THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER, FOLLOWED BY A DASH NUMBER FROM EITHER TABLE I OR II.

EXAMPLE: NASM35756-7

DASH NUMBER

BASIC MS NUMBER

NASM35756-7 - KEY, WOODRUFF, TYPE I, .0938 WIDE; .625 DIA., ALLOY STEEL

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NASM35756

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