



SURFACE VEHICLE STANDARD	J502™	JAN2018
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Woodruff Keys		

RATIONALE

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1. Scope

2. References—There are no referenced publications specified herein.

3. Material—Keys are to be carbon steel or alloy heat treated steel as specified. Carbon steel keys are to be 0.30 carbon minimum, with hardness of Rockwell B 90 minimum. Alloy steel keys are to be SAE 2330 or 8630 steel, heat treated to a hardness of 40-50 RC; or other alloy steels having equal physical properties at the same hardness. Alloy heat treated keys are to be marked with depressions on the top to distinguish them from carbon steel keys.

4. Dimensions—Dimensions are to be as given in Tables 1A, 1B, and 2 and Figures 1, 2, and 3.

4.1 Width A (Shown in Illustrations Accompanying Tables)—Values shown were set with the maximum key slot width as that figure which will receive a key with the greatest amount of looseness consistent with assuring the key's sticking in the slot. Minimum key slot width is that figure permitting the largest shaft distortion acceptable when assembling maximum key in minimum key slot.

4.2 Dimensions A, B, C, and E—These dimensions are to be taken at the side intersection.

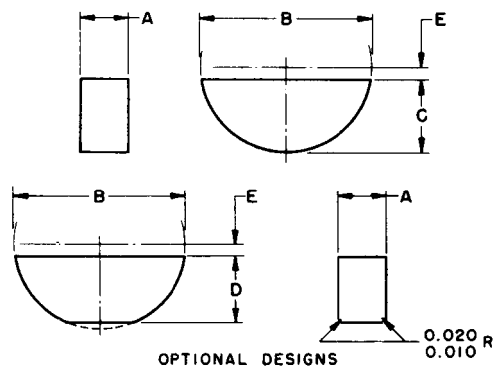


FIGURE 1—