

RR-K-795A  
 August 19, 1974  
 SUPERSEDING  
 Fed. Spec. RR-K-793  
 May 4, 1965

## FEDERAL SPECIFICATION

### KEY CHAIN, REEL (DOOR KEY AND DRILL CHUCK KEYS)

This specification was approved by the Commissioner, Federal Supply Service, General Services Administration, for the use of all Federal agencies.

#### 1. SCOPE AND CLASSIFICATION

1.1 Scope. This specification covers key chain reels, and drill chuck key chain reel.

1.2 Classification.

1.2.1 Types. Reel key chains shall be of the following types, as specified (see 6.2):

- Type I - Key ring, with belt loop.
- Type II - Key ring, with belt clip.
- Type III - Drill chuck key, with mounting plate.

#### 2. APPLICABLE DOCUMENTS

2.1 The following documents, of the issues in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein:

##### Federal Specifications:

- CGG-C-350 - Chuck, Drill; and Arbors and Keys, Drill-Chuck.
- PPP-B-566 - Boxes, Folding, Paperboard.
- PPP-B-585 - Boxes, Wood, Wirebound.
- PPP-B-591 - Boxes, Fiberboard, Wood-Cleated.
- PPP-B-601 - Boxes, Wood, Cleated-Plywood.
- PPP-B-621 - Boxes, Wood, Nailed and Lock-Corner.
- PPP-B-636 - Boxes, Shipping, Fiberboard.
- PPP-B-640 - Boxes, Folding, Fiberboard, Corrugated, Triple Wall.
- PPP-B-665 - Boxes, Paperboard, Metal Stayed (Including Stay Material).
- PPP-B-676 - Boxes, Set-Up; Paperboard.

##### Federal Standard:

- Fed. Std. No. 123 - Marking for Domestic Shipment (Civil Agencies).

(Activities outside the Federal Government may obtain copies of Federal Specifications, Standards, and Handbooks as outlined under General Information in the Index of Federal Specifications and Standards and at the prices indicated in the Index. The Index, which includes cumulative monthly supplements as issued, is for sale on a subscription basis by the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.

(Single copies of this specification and other Federal Specifications required by activities outside the Federal Government for bidding purposes are available without charge at the General Services Administration Regional Offices in Boston, New York, Washington, DC, Atlanta, Chicago, Kansas City, MO, Fort Worth, Denver, San Francisco, Los Angeles, Seattle, WA.

(Federal Government activities may obtain copies of Federal Specifications, Standards, and Handbooks and the Index of Federal Specifications and Standards from established distribution points in their agencies.)

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Military Standards:

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes.

MIL-STD-129 - Marking for Shipment and Storage.

(Copies of Military Specifications and Standards required by suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless a specific issue is identified, the issue in effect on date of invitation for bids or request for proposal shall apply.

National Motor Freight Traffic Association, Inc., Agent:

National Motor Freight Classification.

(Application for copies should be addressed to the American Trucking Association, Inc., Tariff Order Section, 1616 P Street, N.W., Washington, DC 20036.)

Uniform Classification Committee, Agent:

Uniform Freight Classification.

(Application for copies should be addressed to the Uniform Classification Committee, Room 1106, 222 South Riverside Plaza, Chicago, IL 60606.)

(Technical society and technical association specifications and standards are generally available for reference from libraries. They are also distributed among technical groups and using Federal agencies.)

## 3. REQUIREMENTS

3.1 Design and construction.

3.1.1 Reels. All types of key chain reels shall consist of case, spring, and chain. The reel case shall be of chrome-plated metal or corrosion resisting steel having a wall thickness of not less than 0.020 inch. The reel case when measured at its largest dimension shall be not less than 2 inches nor more than 2-1/2 inches in length, width, or diameter. The spring used to retrieve the chain into the case shall be of a high carbon spring steel of such a length as to reel the chain into the reel and have sufficient tension to support 8 tumbler type door keys or one drill chuck key against the case as applicable. The chain shall be of corrosion resisting steel and shall be at least 21-3/4 inches long. The end of the chain shall be provided with swivel or other device to prevent the chain from twisting when using key. All reels shall meet the requirements of 4.4.

3.1.2 Type I. Type I key chain reel shall be furnished with a key ring of such size as to hold at least eight tumbler type door keys. The back of the case shall have a metal loop of chrome-plated metal or corrosion resisting steel for the purpose of threading and supporting the key reel on the user's belt.

3.1.3 Type II. Type II key chain reel shall be furnished with a key ring of such size as to hold at least eight tumbler type door keys. The back of the case shall have a metal clip of chrome-plated metal or corrosion resisting steel for clipping and supporting the key chain reel on user's belt.

3.1.4 Type III. Type III key chain reel shall be furnished with a steel band loop for holding a drill chuck key. The back of reel case shall have a chrome-plated metal or corrosion resisting mounting plate with two holes for fastening key chain reel on the machinery.

3.1.4.1 Drill chuck key. Type III key chain reel shall be furnished with a self-ejecting safety key, Jacobs K3 size, conforming to GGG-C-350.

3.2 Workmanship. Reel key chain shall be free from defects such as sharp edges, loose plating, burrs, pits, rust, or any other defects which will adversely affect their serviceability.

#### 4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the supplier 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 that supplies and services conform to prescribed requirements.

4.2 Sampling. The sample size levels of inspection shall be in accordance with MIL-STD-105.

4.2.1 Lot. Unless otherwise specified (see 6.2), a lot shall consist of each type submitted for inspection at the same time.

4.2.2 Dimensional and visual examination of end item. Sampling for these characteristics shall be in accordance with level S-2 in MIL-STD-105.

4.2.3 Testing of end item. Sampling for tests shall be in accordance with level S-2 in MIL-STD-105.

#### 4.3 Inspection.

4.3.1 End item. Reel key chains shall be examined and measured for defects listed in table I. The acceptable quality levels (AQL's) for defects shall be 2.5 percent defective for major defects and 4.0 percent defective for minor defects.

TABLE I. Classification of defects, end item		
Defects	Major	Minor
Component parts missing.....	X	
Reel diameter not as specified.....	X	
Spring will not retrieve chain as required.....	X	
Swivel missing on end.....	X	
Chain less than 21-3/4 inches long.....	X	
Plating not as specified.....	X	
Burrs, sharp edges, rust, pits.....		X
Damaged or defective not affecting function or serviceability.....		X

4.3.2 Inspection of preparation for delivery requirements. An inspection shall be made to determine that packaging, packing and marking requirements of section 5 of this specification are complied with. Defects shall be scored in accordance with table II. For examination of contents the sample unit shall be one shipping container fully prepared for delivery selected just prior to the closing operations. Defects of closure listed shall be examined on shipping containers fully prepared for delivery. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the AQL shall be 4.0 defects per hundred units.

TABLE II. Classification of preparation for delivery defects	
Examine	Defects
Markings (exterior and interior)	omitted; incorrect; illegible; or improper size, location, sequence, or method of application.
Materials	Any component missing, or damaged.
Workmanship	Inadequate application of components such as incomplete closure of container flaps, loose strapping, inadequate stapling. Bulging or distortion of container.

4.4 Test. A test shall be performed to determine durability, strength, smoothness, and ease of operation. The acceptable quality level (AQL) for defects shall be 2.5 percent defective.

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4.4.1 Test method. Each sample reel chain shall be attached to a 3 pound weight and cycled through (1) full extension of chain at a steady velocity (approximately a 3 second stroke), (2) suspension of weight, and (3) retrieve of chain (at approximately a 3 second stroke), for 5,000 cycles at an even rate of 10 cycles per minute. Any breaking, binding, halting, or uneven operation shall constitute a defect.

## 5. PREPARATION FOR DELIVERY

(For civil agency procurement, the definitions and application of levels of packaging and packing shall be in accordance with Fed. Std. No. 102.)

5.1 Packaging. Packaging shall be level A, B, or C as specified (see 6.2).

### 5.1.1 Level A.

5.1.1.1 Unit packaging. Each reel shall be packaged in a close-fitting box conforming to PPP-B-566, PPP-B-665 or PPP-B-676.

5.1.1.2 Intermediate packaging. Unit packages of reels of like description shall be intermediate packaged in quantities as specified (see 6.2) in a close-fitting box conforming to PPP-B-636, W5c. The box shall be closed and waterproofed, sealed with tape in accordance with the appendix to the box specification.

### 5.1.2 Level B.

5.1.2.1 Unit packaging. The reels shall be packaged as specified in 5.1.1.1.

5.1.2.2 Intermediate packaging. Twelve unit packages of reels of like description shall be packaged in a box conforming to PPP-B-566, PPP-B-665, or PPP-B-676.

5.1.3 Level C. The reels shall be packaged in accordance with the supplier's commercial practice.

5.2 Packing. Packing shall be level A, B, or C as specified (see 6.2).

5.2.1 Level A. Reels of like description shall be packed in a close-fitting box conforming to PPP-B-585, class 3; PPP-B-591, class II; PPP-B-601, type III; PPP-B-621, class 2; PPP-B-636, class weather resistant; or PPP-B-640, class 2 grade A. The boxes shall be closed and stripped in accordance with the applicable specification or appendix thereto. The gross weight of the triple wall box or the wood boxes shall not exceed 200 pounds. The gross weight of the PPP-B-636 box shall not exceed the weight limitations of the box specification.

5.2.2 Level B. Ten intermediate packages of reels of like description shall be packed in a box conforming to PPP-B-636, class domestic. The box shall be closed in accordance with the appendix to the box specification.

5.2.3 Level C. The reels shall be packed to insure carrier acceptance and safe delivery at destination in containers complying with the rules and regulations applicable to the mode of transportation.

### 5.3 Marking.

5.3.1 Civil agencies. In addition to markings required by the contract or order, the packages and shipping containers shall be marked in accordance with Fed. Std. No. 123.

5.3.2 Military activities. In addition to markings required by the contract or order, the packages and shipping containers shall be marked in accordance with MIL-STD-129.

## 6. NOTES

6.1 Intended use. Type I and Type II real key chains are intended for use as an accessible key chain that can be attached to a belt, hold a number of keys, allowing them to be used and automatically retrieve the user's belt. Type III is intended to be attached to machinery which uses a drill chuck, for accessibility, safety allowed by automatic reeling action.

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6.2 Ordering data. Purchasers should select the preferred options permitted herein, and include the following information in procurement documents:

- (a) Title, number, and date of this specification.
- (b) Type required (see 1.2).
- (c) Size of lot, if different from 4.2.1.
- (d) Level of packaging and packing required (see 5.1 and 5.2).
- (e) Intermediate package quantities required (see 5.1.1.2).
- (f) Whether civil or military marking is required (see 5.4).

Preparing activity:

GSA-FSS

U. S. GOVERNMENT PRINTING OFFICE : 1974 - 585-643/1344

Orders for this publication are to be placed with General Services Administration, acting as an agent for the Superintendent of Documents. See Section 2 of this specification to obtain extra copies and other documents referenced herein. Price 25 cents each.