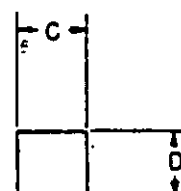
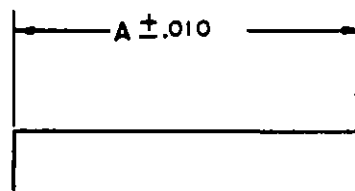


REVIEWER: IS, WP, 69, VC, MO
USER : MC, SH, MU, YD, NSA

FED. SUP CLASS
5315



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	.4385	.501	.5635	.626	.751	.876	1.001
MINIMUM	.4375	.500	.5625	.625	.750	.875	1.000

- (A) **MATERIAL:** Corrosion-resisting steel, Grade A, in accordance with procurement specification.
Alloy steel, Grade B, in accordance with procurement specification.
Carbon steel, Grade C, in accordance with procurement specification.

- (A) **SHEAR STRENGTH (MIN.):** Shear strength for grades A, B, and C materials shall conform to the procurement specification.

- (A) **HARDNESS:** Grade B keys shall be hardened in accordance with procurement specification.

- (A) **PROTECTIVE COATING:** Grade A keys shall be passivated in accordance with Specification QQ-P-35.

DIMENSIONS: All dimensions are in inches unless otherwise specified.

PART NUMBER: The MS part number consists of the MS number plus the dash number.
Example: MS20066-1

- NOTES:**
- (1) Edges and corners shall be rounded (.010-.020 Rad.).
 - (2) The keys covered on this standard correspond to Type II Style 1 of the procurement specification.
 - (3) For design feature purposes, this standard takes precedence over procurement documents referenced herein.
 - (4) Referenced documents shall be of the issue in effect on date of invitations for bid.

(A) For changes see sheets 1, 2, 3, and 4.

P.A. 6C Other Cust WP 69	TITLE KEY, MACHINE-SQUARE IN CROSS SECTION, BOTH ENDS SQUARE	MILITARY STANDARD MS 20066
PROCUREMENT SPECIFICATION DD-A-220	SUPERSEDES:	SHEET 1 OF 4

This military standard is approved by the Department of Defense and is mandatory on all contractors. Selection for all new engineering and design specifications and for revisions thereto shall be made from this document.

DD FORM 672-1 (Continued)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

APPROVED 22 SEPT 58 REVISED (A) 13 NOV 1964

REVIEWER: IS, WP, 69, MC, MO
USER : MC, SH, MU, YD, NSA

FED. SUP CLASS 5315									
LENGTH A	DASH NUMBER								
	1/16 X 1/16			3/32 X 3/32			1/8 X 1/8		
	GRADE A	GRADE B	GRADE C	GRADE A	GRADE B	GRADE C	GRADE A	GRADE B	GRADE C
1/4	1	4	7	10	31	32	73	94	115
5/16	2	5	8	11	32	33	74	95	116
3/8	3	6	9	12	33	34	75	96	117
7/16				13	34	35	76	97	118
1/2				14	35	36	77	98	119
3/4				15	36	37	78	99	120
7/8				16	37	38	79	100	121
1				17	38	39	80	101	122
1-1/8				18	39	40	81	102	123
1-1/4				19	40	41	82	103	124
1-3/8				20	41	42	83	104	125
1-1/2				21	42	43	84	105	126
1-3/4				22	43	44	85	106	127
2				23	44	45	86	107	128
2-1/4				24	45	46	87	108	129
2-1/2				25	46	47	88	109	130
3				26	47	48	89	110	131
3-1/2				27	48	49	90	111	132
4				28	49	50	91	112	133
4-1/2				29	50	51	92	113	134
5				30	51	52	93	114	135

LENGTH A	DASH NUMBER								
	3/16 X 3/16			1/4 X 1/4			5/16 X 5/16		
	GRADE A	GRADE B	GRADE C	GRADE A	GRADE B	GRADE C	GRADE A	GRADE B	GRADE C
1/4	136	157	178	199	222	243	266	293	318
5/16	137	158	179	200	223	246	269	294	319
3/8	138	159	180	201	224	247	270	295	320
7/16	139	160	181	202	225	248	271	296	321
1/2	140	161	182	203	226	249	272	297	322
3/4	141	162	183	204	227	250	273	298	323
7/8	142	163	184	205	228	251	274	299	324
1	143	164	185	206	229	252	275	300	325
1-1/8	144	165	186	207	230	253	276	301	326
1-1/4	145	166	187	208	231	254	277	302	327
1-3/8	146	167	188	209	232	255	278	303	328
1-1/2	147	168	189	210	233	256	279	304	329
1-3/4	148	169	190	211	234	257	280	305	330
2	149	170	191	212	235	258	281	306	331
2-1/4	150	171	192	213	236	259	282	307	332
2-1/2	151	172	193	214	237	260	283	308	333
3	152	173	194	215	238	261	284	309	334
3-1/2	153	174	195	216	239	262	285	310	335
4	154	175	196	217	240	263	286	311	336
4-1/2	155	176	197	218	241	264	287	312	337
5	156	177	198	219	242	265	288	313	338
5-1/2				220	243	266	289	314	339
6				221	244	267	290	315	340
6-1/2							291	316	341
7							292	317	342

NOTE: For material, protective coating and other pertinent data, see sheet 1.

(A) FILL columns removed.

This military standard is approved by the Department of Defense and is mandatory on all activities. Selection for all new engineering and design applications and for replacement use shall be made from this document.

P.A.	60	TITLE	MILITARY STANDARD
Other Code	WP 99	KEY, MACHINE-SQUARE IN CROSS SECTION, BOTH ENDS SQUARE	MS 20066
PROCUREMENT SPECIFICATION	SUPERSEDES:	SHEET	OF

DD FORM 672-1 (Continued)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

APPROVED 22 SEPT 58 REVISED (A) FOR CHANGES SEE SHEETS 1, 2, 3, AND 4.

REVIEWER: 1S, VP, 69, VC, MO
USER : MC, SH, MU, YD, NSA

(A) FIIN columns removed.								FED. SUP CLASS 5315	
LENGTH A	DASH NUMBER								
	3/8 X 3/8			7/16 X 7/16			1/2 X 1/2		
	GRADE A	GRADE B	GRADE C	GRADE A	GRADE B	GRADE C	GRADE A	GRADE B	GRADE C
1/4	343	368	393	418	443	472	499	528	557
5/16	344	369	394	419	446	473	500	529	558
3/8	345	370	395	420	447	474	501	530	559
7/16	346	371	396	421	448	475	502	531	560
1/2	347	372	397	422	449	476	503	532	561
3/4	348	373	398	423	450	477	504	533	562
7/8	349	374	399	424	451	478	505	534	563
1	350	375	400	425	452	479	506	535	564
1-1/8	351	376	401	426	453	480	507	536	565
1-1/4	352	377	402	427	454	481	508	537	566
1-3/8	353	378	403	428	455	482	509	538	567
1-1/2	354	379	404	429	456	483	510	539	568
1-3/4	355	380	405	430	457	484	511	540	569
2	356	381	406	431	458	485	512	541	570
2-1/4	357	382	407	432	459	486	513	542	571
2-1/2	358	383	408	433	460	487	514	543	572
3	359	384	409	434	461	488	515	544	573
3-1/2	360	385	410	435	462	489	516	545	574
4	361	386	411	436	463	490	517	546	575
4-1/2	362	387	412	437	464	491	518	547	576
5	363	388	413	438	465	492	519	548	577
5-1/2	364	389	414	439	466	493	520	549	578
6	365	390	415	440	467	494	521	550	579
6-1/2	366	391	416	441	468	495	522	551	580
7	367	392	417	442	469	496	523	552	581
7-1/2				443	470	497	524	553	582
8				444	471	498	525	554	583
9							526	555	584
10							527	556	585

LENGTH A	DASH NUMBER								
	9/16 X 9/16			5/8 X 5/8			3/4 X 3/4		
	GRADE A	GRADE B	GRADE C	GRADE A	GRADE B	GRADE C	GRADE A	GRADE B	GRADE C
1/4	586	616	646						
5/16	587	617	647						
3/8	588	618	648						
7/16	589	619	649						
1/2	590	620	650						
3/4	591	621	651						
7/8	592	622	652						
1	593	623	653						
1-1/8	594	624	654						
1-1/4	595	625	655						
1-3/8	596	626	656						
1-1/2	597	627	657	676	696	716			
1-3/4	598	628	658	677	697	717			
2	599	629	659	678	698	718	736	754	772
2-1/4	600	630	660	679	699	719	737	755	773
2-1/2	601	631	661	680	700	720	738	756	774
3	602	632	662	681	701	721	739	757	775
3-1/2	603	633	663	682	702	722	740	758	776
4	604	634	664	683	703	723	741	759	777
4-1/2	605	635	665	684	704	724	742	760	778
5	606	636	666	685	705	725	743	761	779
5-1/2	607	637	667	686	706	726	744	762	780
6	608	638	668	687	707	727	745	763	781
6-1/2	609	639	669	688	708	728	746	764	782
7	610	640	670	689	709	729	747	765	783
7-1/2	611	641	671	690	710	730	748	766	784
8	612	642	672	691	711	731	749	767	785
9	613	643	673	692	712	732	750	768	786
10	614	644	674	693	713	733	751	769	787
11	615	645	675	694	714	734	752	770	788
12				695	715	735	753	771	789

NOTE: For material protective coating and other pertinent data, see sheet 1.

P.A. : WC Other: VP 69	TITLE KEY, MACHINE-SQUARE IN CROSS SECTION, BOTH ENDS SQUARE	MILITARY STANDARD MS 20066
PROCUREMENT SPECIFICATION 00-K-220	SUPSEDES:	SHEET 3 OF

This military standard is approved by the Department of Defense and is mandatory on all activities. Substitutions for all items employing and design applications and for reference use shall be made from this document.

FED. SUP CLASS
 5315

LENGTH A	DASH NUMBERS					
	7/8 X 7/8			1 X 1		
	GRADE A	GRADE B	GRADE C	GRADE A	GRADE B	GRADE C
2-1/2	790	806	822	838	854	870
3	791	807	823	839	855	871
3-1/2	792	808	824	840	856	872
4	793	809	825	841	857	873
4-1/2	794	810	826	842	858	874
5	795	811	827	843	859	875
5-1/2	796	812	828	844	860	876
6	797	813	829	845	861	877
6-1/2	798	814	830	846	862	878
7	799	815	831	847	863	879
7-1/2	800	816	832	848	864	880
8	801	817	833	849	865	881
9	802	818	834	850	866	882
10	803	819	835	851	867	883
11	804	820	836	852	868	884
12	805	821	837	853	869	885

NOTE: For material, protective coating and other pertinent data, see sheet 1.

(A) FIIN columns removed.

APPROVED 22 SEPT 58 REVISED (A) FOR CHANGES SEE SHEETS 1, 2, 3, AND 4.

P.A. WC Other Cast WP 59	TITLE KEY, MACHINE-SQUARE IN CROSS SECTION, BOTH ENDS SQUARE	MILITARY STANDARD MS 20066
PROCUREMENT SPECIFICATION 00-A-120	SUPERSEDES:	SHEET 1 OF 2

DD FORM 672-1 (Continued)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

This military standard is approved by the Department of Defense and is mandatory on all activities. Subsequent to all new engineering and design specifications and for revisions are shall be made from this document.

REVIEWER: IS, VP, 69, WC, MO
USER: MC, SH, MU, YD, NSA