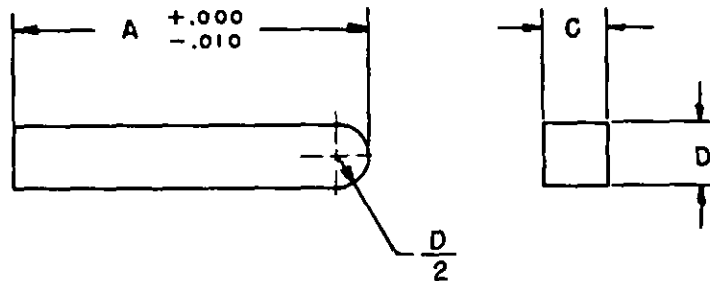


FED. SUP CLASS
5315

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 | .4365 | .501 | .5635 | .626 | .751 | .876 | 1.001 |
| MINIMUM | .4375 | .500 | .5625 | .625 | .750 | .875 | 1.000 |

- (A) **MATERIAL:** 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 B and C materials shall conform to the procurement specification.
- (A) **HARDNESS:** Grade B keys shall be hardened in accordance with procurement specification.
- PROTECTIVE COATING:** Uncoated.
- 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: MS20067-1.
- NOTES:**
- (1) Edges and corners shall be rounded (.010-.020 Rad.).
 - (2) The keys covered in this standard correspond to Type II, Style 3 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.

| | | |
|---------------------------------------|---|---|
| P.A. WC Other Cust. WP 69 | TITLE KEY, MACHINE-SQUARE IN CROSS SECTION, ONE END SQUARE, OTHER END ROUND | MILITARY STANDARD MS 20067 |
| PROCUREMENT SPECIFICATION 00-K-220 | SUPERSEDES: | SHEET 1 OF 3 |

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

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

FED. SUP CLASS
5315REVIEWER: IS, WP, 69, WC, MO
USER : MC, SH, MU, YD, NSA

| LENGTH A | DASH NUMBER | | | | | | | |
|-------------|-------------|---------|-------------|---------|-----------|---------|-------------|---------|
| | 1/16 X 1/16 | | 3/32 X 3/32 | | 1/8 X 1/8 | | 3/16 X 3/16 | |
| | GRADE B | GRADE C | GRADE B | GRADE C | GRADE B | GRADE C | GRADE B | GRADE C |
| 1/4 | 1 | 4 | 7 | 28 | 49 | 70 | 91 | 114 |
| 5/16 | 2 | 5 | 8 | 29 | 50 | 71 | 92 | 115 |
| 3/8 | 3 | 6 | 9 | 30 | 51 | 72 | 93 | 116 |
| 7/16 | | | 10 | 31 | 52 | 73 | 94 | 117 |
| 1/2 | | | 11 | 32 | 53 | 74 | 95 | 118 |
| 3/4 | | | 12 | 33 | 54 | 75 | 96 | 119 |
| 7/8 | | | 13 | 34 | 55 | 76 | 97 | 120 |
| 1 | | | 14 | 35 | 56 | 77 | 98 | 121 |
| 1-1/8 | | | 15 | 36 | 57 | 78 | 99 | 122 |
| 1-1/4 | | | 16 | 37 | 58 | 79 | 100 | 123 |
| 1-3/8 | | | 17 | 38 | 59 | 80 | 101 | 124 |
| 1-1/2 | | | 18 | 39 | 60 | 81 | 102 | 125 |
| 1-3/4 | | | 19 | 40 | 61 | 82 | 103 | 126 |
| 2 | | | 20 | 41 | 62 | 83 | 104 | 127 |
| 2-1/4 | | | 21 | 42 | 63 | 84 | 105 | 128 |
| 2-1/2 | | | 22 | 43 | 64 | 85 | 106 | 129 |
| 3 | | | 23 | 44 | 65 | 86 | 107 | 130 |
| 3-1/2 | | | 24 | 45 | 66 | 87 | 108 | 131 |
| 4 | | | 25 | 46 | 67 | 88 | 109 | 132 |
| 4-1/2 | | | 26 | 47 | 68 | 89 | 110 | 133 |
| 5 | | | 27 | 48 | 69 | 90 | 111 | 134 |
| 5-1/2 | | | | | | | 112 | 135 |
| 6 | | | | | | | 113 | 136 |
| 6-1/2 | | | | | | | | |
| 7 | | | | | | | | |

| LENGTH A | DASH NUMBER | | | | | | | |
|-------------|-------------|---------|-------------|---------|-----------|---------|-------------|---------|
| | 1/4 X 1/4 | | 5/16 X 5/16 | | 3/8 X 3/8 | | 7/16 X 7/16 | |
| | GRADE B | GRADE C | GRADE B | GRADE C | GRADE B | GRADE C | GRADE B | GRADE C |
| 1/4 | 137 | 162 | 187 | 212 | 237 | 264 | 291 | 320 |
| 5/16 | 138 | 163 | 188 | 213 | 238 | 265 | 292 | 321 |
| 3/8 | 139 | 164 | 189 | 214 | 239 | 266 | 293 | 322 |
| 7/16 | 140 | 165 | 190 | 215 | 240 | 267 | 294 | 323 |
| 1/2 | 141 | 166 | 191 | 216 | 241 | 268 | 295 | 324 |
| 3/4 | 142 | 167 | 192 | 217 | 242 | 269 | 296 | 325 |
| 7/8 | 143 | 168 | 193 | 218 | 243 | 270 | 297 | 326 |
| 1 | 144 | 169 | 194 | 219 | 244 | 271 | 298 | 327 |
| 1-1/8 | 145 | 170 | 195 | 220 | 245 | 272 | 299 | 328 |
| 1-1/4 | 146 | 171 | 196 | 221 | 246 | 273 | 300 | 329 |
| 1-3/8 | 147 | 172 | 197 | 222 | 247 | 274 | 301 | 330 |
| 1-1/2 | 148 | 173 | 198 | 223 | 248 | 275 | 302 | 331 |
| 1-3/4 | 149 | 174 | 199 | 224 | 249 | 276 | 303 | 332 |
| 2 | 150 | 175 | 200 | 225 | 250 | 277 | 304 | 333 |
| 2-1/4 | 151 | 176 | 201 | 226 | 251 | 278 | 305 | 334 |
| 2-1/2 | 152 | 177 | 202 | 227 | 252 | 279 | 306 | 335 |
| 3 | 153 | 178 | 203 | 228 | 253 | 280 | 307 | 336 |
| 3-1/2 | 154 | 179 | 204 | 229 | 254 | 281 | 308 | 337 |
| 4 | 155 | 180 | 205 | 230 | 255 | 282 | 309 | 338 |
| 4-1/2 | 156 | 181 | 206 | 231 | 256 | 283 | 310 | 339 |
| 5 | 157 | 182 | 207 | 232 | 257 | 284 | 311 | 340 |
| 5-1/2 | 158 | 183 | 208 | 233 | 258 | 285 | 312 | 341 |
| 6 | 159 | 184 | 209 | 234 | 259 | 286 | 313 | 342 |
| 6-1/2 | 160 | 185 | 210 | 235 | 260 | 287 | 314 | 343 |
| 7 | 161 | 186 | 211 | 236 | 261 | 288 | 315 | 344 |
| 7-1/2 | | | | | 262 | 289 | 316 | 345 |
| 8 | | | | | 263 | 290 | 317 | 346 |
| 9 | | | | | | | 318 | 347 |
| 10 | | | | | | | 319 | 348 |
| 11 | | | | | | | | |

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

(A) FIIN columns removed.

| | | |
|---------------------------------------|--|-------------------|
| P.A. WC | TITLE | MILITARY STANDARD |
| Other Cast WP 69 | KEY, MACHINE-SQUARE IN CROSS SECTION, ONE END SQUARE, OTHER END ROUND | MS 20067 |
| PROCUREMENT SPECIFICATION 00-K-220 | SUPERSEDES: | SHEET 2 OF |

APPROVED 22 SEPT 56 REVISED (A) FOR CHANGES SEE SHEETS 1, 2, AND 3

This military standard is approved by the Department of Defense and is mandatory on all activities. Substitution for all non-engineering and design applications and for repetitive use shall be made from this document.

FED. SUP CLASS
5315REVIEWER: IS, WP, 69, WC, MO
USER : MC, SH, MU, YU, NSA

| LENGTH A | DASH NUMBER | | | | | | | |
|-------------|-------------|---------|-------------|---------|-----------|---------|-----------|---------|
| | 1/2 X 1/2 | | 9/16 X 9/16 | | 5/8 X 5/8 | | 3/4 X 3/4 | |
| | GRADE B | GRADE C | GRADE B | GRADE C | GRADE B | GRADE C | GRADE B | GRADE C |
| 1/4 | 349 | 379 | | | | | | |
| 5/16 | 350 | 380 | | | | | | |
| 3/8 | 351 | 381 | | | | | | |
| 7/16 | 352 | 382 | | | | | | |
| 1/2 | 353 | 383 | | | | | | |
| 3/4 | 354 | 384 | | | | | | |
| 7/8 | 355 | 385 | | | | | | |
| 1 | 356 | 386 | | | | | | |
| 1-1/8 | 357 | 387 | | | | | | |
| 1-1/4 | 358 | 388 | | | | | | |
| 1-3/8 | 359 | 389 | | | | | | |
| 1-1/2 | 360 | 390 | 409 | 429 | 449 | 469 | | |
| 1-3/4 | 361 | 391 | 410 | 430 | 450 | 470 | | |
| 2 | 362 | 392 | 411 | 431 | 451 | 471 | 489 | 507 |
| 2-1/4 | 363 | 393 | 412 | 432 | 452 | 472 | 490 | 508 |
| 2-1/2 | 364 | 394 | 413 | 433 | 453 | 473 | 491 | 509 |
| 3 | 365 | 395 | 414 | 434 | 454 | 474 | 492 | 510 |
| 3-1/2 | 366 | 396 | 415 | 435 | 455 | 475 | 493 | 511 |
| 4 | 367 | 397 | 416 | 436 | 456 | 476 | 494 | 512 |
| 4-1/2 | 368 | 398 | 417 | 437 | 457 | 477 | 495 | 513 |
| 5 | 369 | 399 | 418 | 438 | 458 | 478 | 496 | 514 |
| 5-1/2 | 370 | 400 | 419 | 439 | 459 | 479 | 497 | 515 |
| 6 | 371 | 401 | 420 | 440 | 460 | 480 | 498 | 516 |
| 6-1/2 | 372 | 402 | 421 | 441 | 461 | 481 | 499 | 517 |
| 7 | 373 | 403 | 422 | 442 | 462 | 482 | 500 | 518 |
| 7-1/2 | 374 | 404 | 423 | 443 | 463 | 483 | 501 | 519 |
| 8 | 375 | 405 | 424 | 444 | 464 | 484 | 502 | 520 |
| 9 | 376 | 406 | 425 | 445 | 465 | 485 | 503 | 521 |
| 10 | 377 | 407 | 426 | 446 | 466 | 486 | 504 | 522 |
| 11 | 378 | 408 | 427 | 447 | 467 | 487 | 505 | 523 |
| 12 | | | 428 | 448 | 468 | 488 | 506 | 524 |

| LENGTH A | DASH NUMBER | | | | | | | |
|-------------|-------------|---------|---------|---------|--|--|--|--|
| | 7/8 X 7/8 | | 1 X 1 | | | | | |
| | GRADE B | GRADE C | GRADE B | GRADE C | | | | |
| 2-1/2 | 525 | 541 | 557 | 573 | | | | |
| 3 | 526 | 542 | 558 | 574 | | | | |
| 3-1/2 | 527 | 543 | 559 | 575 | | | | |
| 4 | 528 | 544 | 560 | 576 | | | | |
| 4-1/2 | 529 | 545 | 561 | 577 | | | | |
| 5 | 530 | 546 | 562 | 578 | | | | |
| 5-1/2 | 531 | 547 | 563 | 579 | | | | |
| 6 | 532 | 548 | 564 | 580 | | | | |
| 6-1/2 | 533 | 549 | 565 | 581 | | | | |
| 7 | 534 | 550 | 566 | 582 | | | | |
| 7-1/2 | 535 | 551 | 567 | 583 | | | | |
| 8 | 536 | 552 | 568 | 584 | | | | |
| 9 | 537 | 553 | 569 | 585 | | | | |
| 10 | 538 | 554 | 570 | 586 | | | | |
| 11 | 539 | 555 | 571 | 587 | | | | |
| 12 | 540 | 556 | 572 | 588 | | | | |

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

(A) FIIN columns removed.

| | | | |
|---------------------------|-------------|--|-------------------|
| P.A. | WC | TITLE | MILITARY STANDARD |
| Other Cust | WP | KEY, MACHINE- SQUARE IN CROSS SECTION, | MS 20067 |
| | 69 | ONE END SQUARE, OTHER END ROUND | |
| PROCUREMENT SPECIFICATION | SUPERSEDES: | SHEET | 3 OF |
| 00-K-220 | | | |