

INCH-POUND

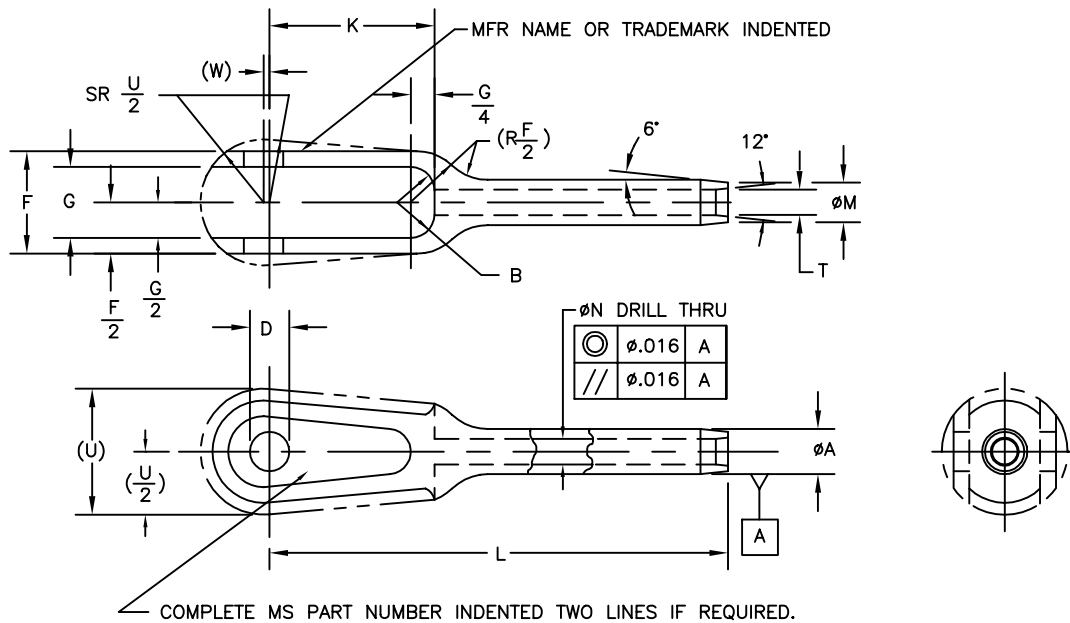
MS20658C
 15 AUGUST 1997
 SUPERSEDING
 MS20658B
 9 OCTOBER 1964

MILITARY SPECIFICATION SHEET

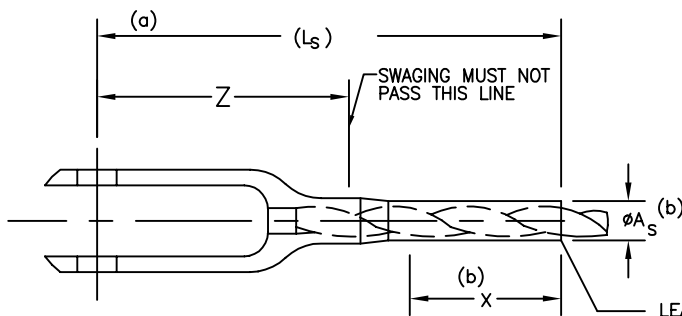
TERMINAL, WIRE ROPE, SWAGING, FORK END

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING DOCUMENT LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION: MIL-DTL-781.



BEFORE SWAGING



AFTER SWAGING

LEAD END AFTER SWAGING MAY HAVE DOUBLE THE TOLERANCE GIVEN FOR THE ϕ_{A_s} IN AREA OF ORIGINAL TAPER, PROVIDED THERE ARE NO RAPID DIMENSIONAL CHANGES IN CROSS SECTION OR EVIDENCE OF SPLITS, CRACKS, OR OTHER INJURIOUS DEFECTS.

Ⓒ ENTIRE DOCUMENT REVISED

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TABLE I. PART NUMBERS AND DIMENSIONS.

MS PART NUMBERS	APPLICABLE BEARING PART NUMBER REF	NOM CABLE DIA REF	(c) MINIMUM BREAKING STRENGTH POUNDS	ϕA +.000 -.005	ϕA_s +.000 -.005	B $\pm .016$ RAD	D +.002 -.000	F +.010 -.005	G $\pm .005$	K
MS20658-3	AN200KP3	.093 (3/32)	920	.218	.190	.156	.190	.500	.302	1.062
MS20658-4	AN200KP4	.125 (1/8)	2000	.250	.219	.188	.250	.750	.489	1.188
MS20658-5		.156 (5/32)	2800	.297	.250					
MS20658-6		.187 (3/16)	4200	.359	.313					
MS20658-7	AN200KP5						.313	.813	.563	1.313

MS PART NUMBERS	L +.020 -.000	L_s REF	ϕM +.010 -.000	ϕN +.005 -.000	T +.000 -.005	U REF.	W REF.	X MIN	Z
MS20658-3	2.531	2.65	.119	.109	.190	.750	.031	.80	1.344
MS20658-4	3.062	3.32	.154	.141	.219	.875	.047	1.05	1.625
MS20658-5	3.313	3.66	.188	.172	.250			1.29	
MS20658-6	3.562	3.73	.223	.203	.313			1.31	
MS20658-7	3.687	3.86				1.000	1.750		

- (a) REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY AND ARE NOT INSPECTION REQUIREMENT.
(b) SWAGED TERMINAL SHALL CONFORM TO ϕA_s FOR LENGTH X.
(c) TO ACHIEVE THE MINIMUM BREAKING STRENGTH, FOR THE TERMINAL TEST ONLY, A GALVANIZED CARBON STEEL WIRE ROPE SHALL BE USED.

REQUIREMENTS:

- MATERIAL:** CORROSION RESISTANT STEEL, 303Se (UNS S30323) OR 304 (UNS S30400).
- FINISH:** FINISH IN ACCORDANCE WITH MIL-DTL-781.
- SWAGE:** SWAGE IN ACCORDANCE WITH MIL-DTL-6117.
- TOLERANCES:** UNLESS OTHERWISE SPECIFIED: DECIMALS $\pm .010$, ANGLES $\pm 3^\circ$.

NOTES:

- DIMENSIONS ARE IN INCHES.
- INTERPRET DRAWING IN ACCORDANCE WITH ASME Y14.5M.
- REMOVE BURRS AND BREAK SHARP EDGES.
- INTERCHANGEABILITY RELATIONSHIP: MS20658 AND AN658 PARTS IDENTIFIED BY THE SAME DASH NUMBER ARE UNIVERSALLY, FUNCTIONALLY, AND DIMENSIONALLY INTERCHANGEABLE.
- IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS DOCUMENT AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS DOCUMENT SHALL TAKE PRECEDENCE.
- UNLESS OTHERWISE SPECIFIED, ISSUES OF REFERENCED DOCUMENTS ARE THOSE IN EFFECT AT THE TIME OF SOLICITATION.
- MS20658 SUPERSEDES AN658.
- CORROSION RESISTANT STEEL PARTS CAN BE UNIVERSALLY SUBSTITUTED FOR CARBON AND ALLOY STEEL PARTS IN ACCORDANCE WITH THE SUBSTITUTION TABLE. CARBON AND ALLOY STEEL PARTS CANNOT BE SUBSTITUTED FOR CORROSION RESISTANT STEEL PARTS.

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SUBSTITUTION TABLE

MS PART NUMBERS	
CORROSION RESISTANT STEEL	CARBON STEEL CAD. PLATED
MS20658-3	MS20658F3
MS20658-4	MS20658F4
MS20658-5	MS20658F5
MS20658-6	MS20658F6
MS20658-7	MS20658F7

CUSTODIANS:

NAVY - AS
ARMY - ME
AIR FORCE - 99

REVIEW:

ARMY - AR, MD
NAVY - MC, NAVAIR
AIR FORCE - 69

PREPARING ACTIVITY:
DLA - IS

(PROJECT. 4030-0285)