

INCH-POUND

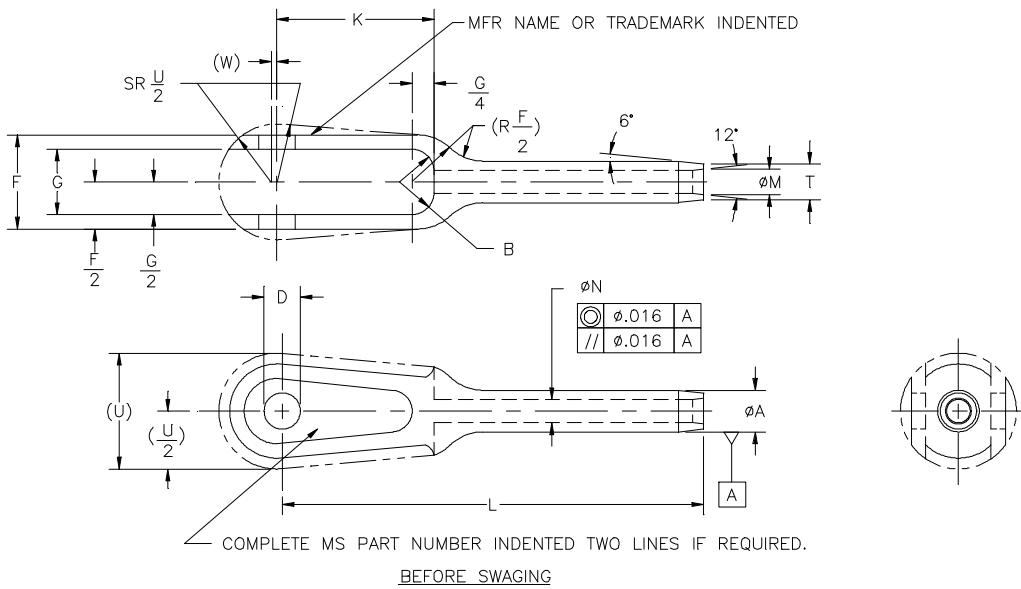
MS20658E  
 30 October 1999  
 Superseding  
 MS20658D  
 22 FEBRUARY 1999

MILITARY SPECIFICATION SHEET

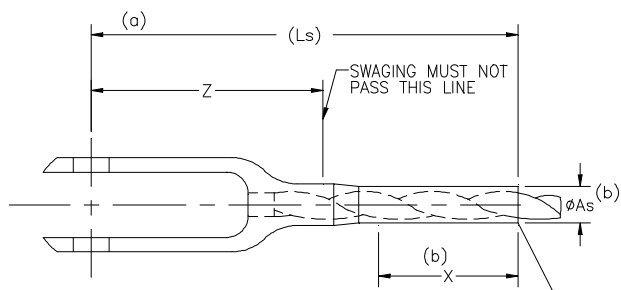
TERMINAL, WIRE ROPE, SWAGING, FORK END

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 specification 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  $\phi_{As}$  IN AREA OF ORIGINAL TAPER, PROVIDED THERE ARE NO RAPID DIMENSIONAL CHANGES IN CROSS SECTION OR EVIDENCE OF SPLITS, CRACKS, OR OTHER INJURIOUS DEFECTS.

**(E)** Denotes Changes

## MS20658E

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TABLE I. Part numbers and dimensions.

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

MS PART NUMBER CORROSION RESISTANT STEEL	L +.020 -.000	Ls REF	ÆM +.010 -.000	ÆN +.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	.023	.313			1.31	
MS20658-7	3.687	3.86				1.000		1.750	

- (a) Reference dimensions are for design purposes only and are not an inspection requirement.
- (b) Swaged terminals shall conform to 'ØAs' 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: In accordance with MIL-DTL-781.
- Finish: In accordance with MIL-DTL-781.
- Swage: Swage in accordance with specification MIL-DTL-6117.
- Tolerances: Unless otherwise specified: decimals ± .010, angles ± 3°.

## NOTES:

- Dimensions in inches,
- Interpret drawing in accordance with ASME Y14.5M.
- Remove all burrs and sharp edges (see procurement specification for definition).
- 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 takes precedence..
- Unless otherwise specified, issues of reference documents are those in effect at the time of solicitation.

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## MS20658E

7. MS20658 supersedes AN658.

8. 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.

9. Carbon and alloy steel parts are inactive for new design.

SUBSTITUTION TABLE

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

## MILITARY INTEREST

## Custodians:

Navy - AS

Army - CR4

Air Force - 99

## Review activities:

Army - AR, MD

Navy - MC

Air Force - 82

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Preparing Activity:

DLA- GS

(PROJECT: 1560-0264)