INCH-POUND

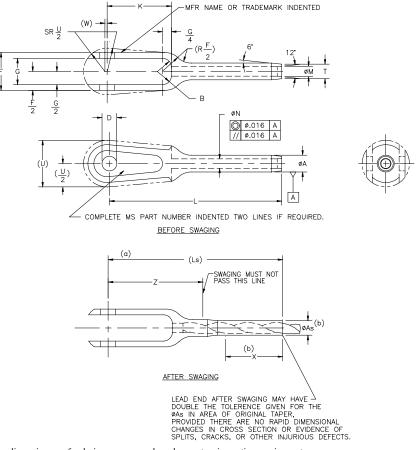
MS20658F 10 January 2001 SUPERSEDING MS20658E 30 October 1999

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, QPL-781.



NOTES: (a) Reference dimensions are for design purposes only and are not an inspection requirement.

(b) Swaged terminals shall conform to 'ØAs' for length X.

FIGURE 1. Terminal, wire rope, swaging, fork end.

MS20658F

TABLE I. Part numbers and dimensions.

MS part number Applicable bearing Corrosion part number		Wire rope diameter		Minimum breaking strength	ØA +.000 005	ØAs +.000 005	B ±.016	D +.002 000	F +.010 005	G ±.005	K
resistant steel	reference			lb <u>1</u> /							
		Nominal	Minimum								
MS20658-3	AN200KP3	3/32	.093	920	.218	.190	.156	.190	.500	.302	1.062
MS20658-4		1/8	.125	2,000	.250	.219					
MS20658-5	AN200KP4	5/32	.156	2,800	.297	.250	.188	.250	.750	.489	1.188
MS20658-6		3/16	.187	4.200	.359	.313	.100				
MS20658-7	AN200KP5	3/16	.187	4,200	.559	.515		.313	.813	.563	1.313

^{1/} To achieve the minimum breaking strength, for the terminal test only, a galvanized carbon steel wire rope shall be used.

TABLE I. Part numbers and dimensions - Continued.

MS part number	L	Ls	ØM	ØN	T	U	W	X	Z	
Corrosion resistant steel	+.020 000	reference	+.010 000	+.005 000	+.000 005	reference	reference	Minimum		
MS20658-3	2.531	2.65	.119	.109	.190	.750	.031	.80	1.344	
MS20658-4	3.062	3.32	.154	.141	.219			1.05		
MS20658-5	3.313	3.66	.188	.172	.250	.875	.047	1.29	1.625	
MS20658-6	3.562	3.73	.223	.023	.313		.047	1.31		
MS20658-7	3.687	3.86	.223	.023	.515	1.000		1.31	1.750	

REQUIREMENTS:

- 1. Material: Material shall be in accordance with MIL-DTL-781.
- 2. Finish: Finish shall be in accordance with MIL-DTL-781.
- 3. Swage: Swage shall be in accordance with MIL-DTL-6117.
- 4. Tolerances: Unless otherwise specified, tolerances: decimals \pm .010, angles \pm 3°.

NOTES:

- 1. Dimensions are in inches.
- 2. Interpret drawing in accordance with ASME Y14.5M.
- 3. Remove all burrs and sharp edges. (See procurement specification for definition.)
- 4. Interchangeability relationship: MS20658 and AN658 parts identified by the same dash number are universally, functionally and dimensionally interchangeable.
- 5. In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence.
- 6. Unless otherwise specified, issues of reference documents are those in effect at the time of solicitation.
 - 7. MS20658 supersedes AN658.

MS20658F

8. Corrosion resistant steel parts can be universally substituted for carbon and alloy steel parts in accordance with table II. Carbon and alloy steel parts cannot be substituted for corrosion resistant steel parts.

TABLE II. Substitution table.

MS PART NUMBER					
Corrosion	Carbon steel,				
resistant steel	cadmium plated				
MS20658-3	MS20658F3				
MS20658-4	MS20658F4				
MS20658-5	MS20658F5				
MS20658-6	MS20658F6				
MS20658-7	MS20658F7				

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

CHANGES FROM PREVIOUS ISSUE: Marginal notations are not used in this revision to identify changes with respect to the previous issue due to the extent of the changes.

Custodians: Preparing activity:

Army - CR4 DLA - GS5 Navy - AS

Air Force - 99 (Project 1560-0287)

Reviewers:

Army - AR, MD

Navy - MC

Air Force - 82