

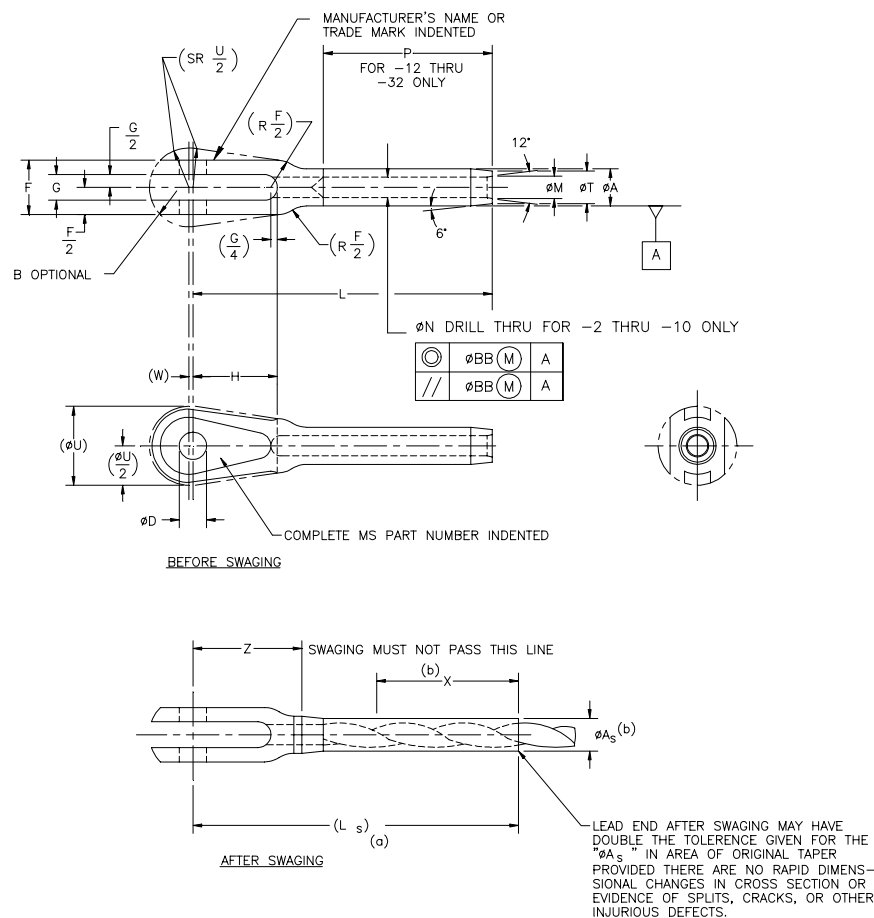
INCH-POUND

MS20667G
 10 January 2001
 SUPERSEDING
 MS20667F
 14 February 2000

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 ' ϕA_s ' for length X.

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

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TABLE I. Part numbers and dimensions.

MS part numbers	Wire rope diameter		Minimum breaking strength lb 1/	ØA		ØAs		B radius	ØD		F +.010 -.005
Corrosion resistant steel	Nominal	Minimum									
MS20667-2	1/16	.062	480	.160	+.000 -.005	.138	+.000 -.005	.130	.190	+.002 -.000	.218
MS20667-3	1/32	.093	920	.218		.190		.150			.254
MS20667-4	1/8	.125	2,000	.250		.219		.220			.383
MS20667-5	5/32	.156	2,800	.297		.250		.240			.406
MS20667-6	3/16	.187	4,200	.359		.313	+.000 -.007	.310	.313		.543
MS20667-7	7/32	.218	5,600	.427		.375		.370			.625
MS20667-8	1/4	.250	7,000	.494		.438	+.000 -.008	.390	.375		.688
MS20667-9	9/32	.281	8,000	.563		.500		.420			.719
MS20667-10	5/16	.312	9,800	.635		.563		.460			.765
MS20667-12	3/8	.375	14,400	.703		.625		.497	.500	+.005 -.000	.830
MS20667-14	7/16	.437	17,600	.781		.688					
MS20667-16	1/2	.500	22,800	.844		.750	+.000 -.009	.620	.625		1.035
MS20667-18	9/16	.562	28,500	.984		.875		.744	.750		1.241
MS20667-20	5/8	.625	35,000	1.109		1.000	+.000 -.010	.810	.875		1.351
MS20667-24	3/4	.750	49,600	1.359		1.250		.870			1.451
MS20667-28	7/8	.875	66,500	1.593	+.000 -.010	1.437	+.000 -.012	.993	1.000		1.656
MS20667-32	1	1.000	85,400	1.812		1.625		1.117	1.125		1.864

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 numbers	G		H	L +.020 -.000
Corrosion resistant steel				
MS20667-2	.093	±.003	.500	1.572
MS20667-3	.108		.670	1.945
MS20667-4	.195		.735	2.352
MS20667-5	.202		.800	2.655
MS20667-6	.260	+.005 -.003	.880	3.071
MS20667-7	.296		.970	3.440
MS20667-8	.313		1.070	3.806
MS20667-9	.327		1.170	4.120
MS20667-10	.348	+.007 -.003	1.268	4.438
MS20667-12	.380		1.525	5.333
MS20667-14			1.776	6.102
MS20667-16	.473		1.903	6.938
MS20667-18	.567	+.009 -.003	2.375	7.750
MS20667-20	.663		2.770	8.673
MS20667-24	.663		2.791	9.740
MS20667-28	.756		3.170	10.802
MS20667-32	.851		3.562	12.312

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TABLE I. Part numbers and dimensions - Continued.

Dash number (size)	Ls reference	\varnothing M		\varnothing N		P		\varnothing T	
-2	1.75	.090	+.010 -.000	.078	+.005 -.000			.138	+.000 -.005
-3	2.06	.119		.109				.190	
-4	2.61	.154		.141				.219	
-5	3.00	.188		.172				.250	
-6	3.24	.223		.203				.313	
-7	3.74	.257		.234				.375	+.000 -.007
-8	4.10	.291		.265				.438	
-9	4.48	.326		.297				.500	+.000 -.008
-10	4.86	.360		.328				.563	
-12	5.74	.430	+.012 -.000	.390	+.008	3.511	+.047 -.000	.625	
-14	6.57	.514		.468	-.000	4.011		.688	+.000 -.009
-16	7.50	.584		.531	+.009	4.698		.750	
-18	8.34	.653		.594	-.000	5.011		.875	+.000 -.010
-20	9.36	.722		.656	+.010 -.000	5.511	+.062 -.000	1.000	
-24	10.31	.860	+.015 -.000	.781	+.012 -.010	6.511		1.250	+.000 -.012
-28	11.56	1.013		.921		7.166		1.437	
-32	13.22	1.151		1.046		8.229		1.625	

TABLE I. Part numbers and dimensions - Continued.

Dash number (size)	\varnothing U reference	W reference	X		\varnothing BB (FIM)
			Minimum	Minimum	
-2	.344	.031	.70	.60	.016
-3	.438		.80	.75	
-4	.547		1.05	.91	
-5	.688		1.29	.96	
-6	.781	.047	1.31	1.13	
-7	.906		1.55	1.25	
-8	.969		1.70	1.36	
-9	1.156		1.89	1.43	
-10	1.265	.063	2.06	1.50	.020
-12	1.500		3.12	1.89	
-14	1.750		3.57	2.16	
-16	1.875		4.31	2.31	
-18	2.340		4.51	2.81	.030
-20	2.730		5.04	3.23	
-24	2.750	.093	5.80	3.30	.040
-28	3.125		6.31	3.70	
-32	3.510		7.26	4.15	

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 $\pm 3^\circ$.

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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: MS20667 and AN667 parts identified by the same dash number are universally, functionally, and dimensionally interchangeable.
5. In the event of a conflict between the test of this document and the references cited herein, the text of this document takes precedence.
6. Unless otherwise specified, issues of referenced documents are those in effect at the time of solicitation.
7. MS20667 supersedes AN667.
8. Corrosion resistant steel parts can be universally substituted carbon and alloy steel parts in accordance with table II. Carbon and alloy steel parts are inactive for new design and cannot be substituted for corrosion resistant steel parts.

TABLE II. Substitution table.

MS PART NUMBERS	
Corrosion resistant steel	Carbon steel, cadmium plated
MS20667-2	MS20667F2
MS20667-3	MS20667F3
MS20667-4	MS20667F4
MS20667-5	MS20667F5
MS20667-6	MS20667F6
MS20667-7	MS20667F7
MS20667-8	MS20667F8
MS20667-9	MS20667F9
MS20667-10	MS20667F10
MS20667-12	MS20667F12
MS20667-14	MS20667F14
MS20667-16	MS20667F16
MS20667-18	MS20667F18
MS20667-20	MS20667F20
MS20667-24	MS20667F24
MS20667-28	MS20667F28
MS20667-32	MS20667F32

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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:

Army - CR4

Navy - AS

Air Force - 99

Preparing activity:

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Reviewers:

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