

INCH-POUND

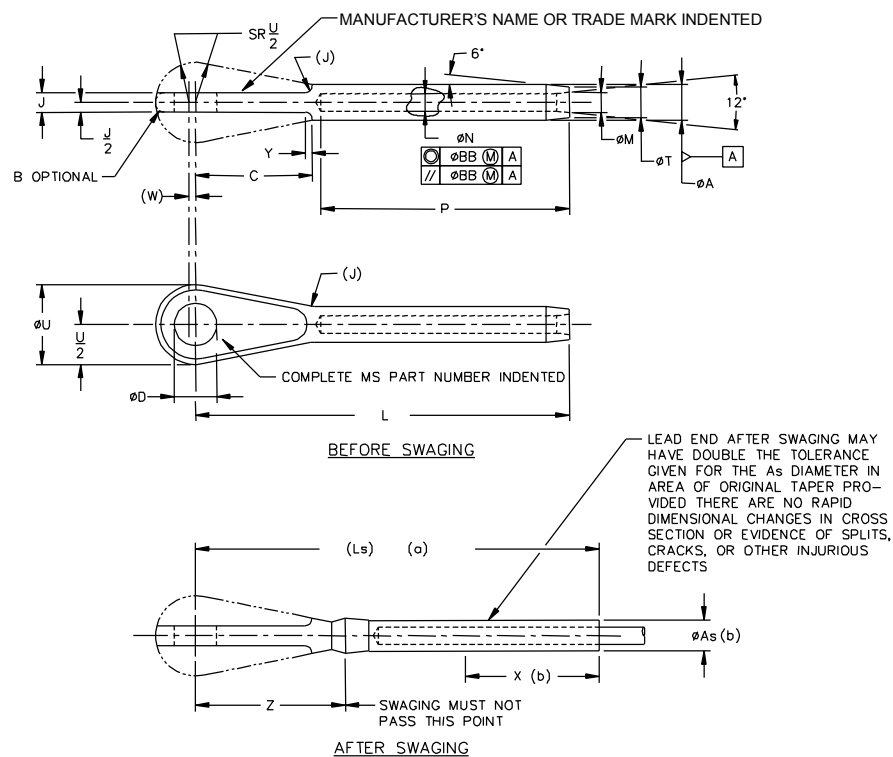
MS20668E
 30 October 1999
 Superseding
 MS20668D
 22 FEBRUARY 1999

MILITARY SPECIFICATION SHEET

TERMINAL, WIRE ROPE, SWAGING, EYE END

This specification sheet 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.



- Reference dimensions are for design purposes only and are not an inspection requirement.
- Swaged terminals shall conform to ϕAs for length X .
- To achieve the minimum breaking strength, for the terminal test only, a galvanized carbon steel wire rope shall be used.

(E) Entire document revised

AMSC N/A

1 of 3

FSC 1560

DISTRIBUTION STATEMENT A. Approved for public release; distribution is limited.

MS20668E

MS PART NUMBERS	CABLE DIA.		MIN. BREAKING STRENGTH LB (a)	ØA	ØB		C	ØD	J (REF)	L	L ₅ REF
	NOM. REF.	MIN.									
CORROSION RESISTANT STEEL											
MS20668-2	1/16	.062	480	.160	.138	.062	.523		.089	1.631	1.809
MS20668-3	3/32	.093	920	.218	.190	.078	.707	.190	.103	2.043	2.160
MS20668-4	1/8	.125	2000	.250	.219	.125	.738		.190	2.337	2.593
MS20668-5	5/32	.156	2800	.297	.250	.140	.831	.250	.197	2.684	3.029
MS20668-6	3/16	.187	4200	.359	.313	.171	.903	.313	.255	3.019	3.187
MS20668-7	7/32	.218	5600	.427	.375	.187	1.007	.375	.291	3.382	3.678
MS20668-8	1/4	.250	7000	.494	.438	.203	1.133	.375	.307	3.763	4.062
MS20668-9	9/32	.281	8000	.563	.500	.218	1.257	.438	.322	4.153	4.512
MS20668-10	5/16	.312	9800	.635	.563	.218	1.373		.343	4.546	4.969
MS20668-12	3/8	.375	14400	.703	.625	.255	1.688	.500	.375	5.562	5.968
MS20668-14	7/16	.437	17600	.781	.688	.275	1.968	.562	.469	6.398	6.867
MS20668-16	1/2	.500	22800	.844	.750	.295	2.115	.625	.562	7.323	7.886
MS20668-18	9/16	.562	28500	.984	.875	.310	2.625	.750	.562	8.185	8.773
MS20668-20	5/8	.625	35000	1.109	1.000	.321	3.062	.875	.657	9.167	9.854
MS20668-24	3/4	.750	49600	1.359	1.250	.345	3.093			10.328	10.900
MS20668-28	7/8	.875	66500	1.593	1.437	.360	3.515	1.000	.750	11.530	12.290
MS20668-32	1	1.000	85400	1.812	1.625	.375	3.937	1.125	.844	13.156	14.062

MS PART NUMBERS	ØA	ØB	P	ØT	ØU	W (REF)	X MIN	Y	Z MIN	ØBB (FIN)
CORROSION RESISTANT STEEL										
MS20668-2	.090	.078	1.042	.136	.359	.031	.70	.072	.662	
MS20668-3	.119	.109	1.261	.190	.438		.80	.092	.856	
MS20668-4	.154	.141	1.511	.219	.500	.031	1.05	.103	.900	
MS20668-5	.188	.172	1.761	.250	.640		1.29	.131	.997	
MS20668-6	.223	.203	2.011	.313	.781		1.31	.155	1.082	
MS20668-7	.257	.234	2.261	.375	.968	.047	1.55	.187	1.195	.016
MS20668-8	.291	.265	2.511	.438	.968		1.70	.221	1.326	
MS20668-9	.326	.297	2.761	.500	1.109		1.99	.251	1.465	
MS20668-10	.360	.328	3.011	.563	1.218		2.06	.281	1.609	
MS20668-12	.430	.390	3.511	.625	1.500		3.12	.320	2.124	
MS20668-14	.514	.468	4.011	.688	1.750	.063	3.57	.350	2.460	.020
MS20668-16	.584	.531	4.698	.750	1.875		4.31	.406	2.698	
MS20668-18	.653	.594	5.011	.875	2.340		4.51	.450	3.247	
MS20668-20	.722	.656	5.511	1.000	2.730		5.04	.515	3.729	.030
MS20668-24	.850	.781	6.511	1.250	3.000		5.80	.600	3.890	
MS20668-28	1.013	.921	7.166	1.437	3.125	.093	6.31	.675	4.437	.040
MS20668-32	1.151	1.046	8.229	1.625	3.510		7.26	.775	5.000	

(a) TO ACHIEVE THE MINIMUM BREAKING STRENGTH, FOR THE TERMINAL TEST ONLY, A GALVANIZED CARBON STEEL WIRE ROPE SHALL BE USED.

MS20668E

REQUIREMENTS:

1. Material: In accordance with MIL-DTL-781.
2. Finish: In accordance with MIL-DTL-781.
3. Swage: In accordance with specification MIL-DTL-6117
4. Tolerance: Unless otherwise specified, tolerances: decimals $\pm .010$, angles $\pm 3^\circ$.

NOTES:

1. Dimension in inches.
2. Remove all burrs and sharp edges (see procurement specification for definition).
3. Interpret drawing in accordance with ASME Y14.5M.
4. In the event of a conflict between the text of this document and the references cited herein the text of this document takes precedence.
5. Unless otherwise specified, issues of referenced documents are those in effect at the time of solicitation.
6. Corrosion resistant steel parts can universally replace carbon and alloy steel parts as shown in the substitution table. Carbon and alloy steel parts are inactive for new design and cannot be substituted for corrosion resistant steel parts.

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SUBSTITUTION TABLE

MS PART NUMBERS	
CORROSION RESISTANT STEEL	CARBON STEEL CADMIUM PLATED
MS20668-2	MS20668F2
MS20668-3	MS20668F3
MS20668-4	MS20668F4
MS20668-5	MS20668F5
MS20668-6	MS20668F6
MS20668-7	MS20668F7
MS20668-8	MS20668F8
MS20668-9	MS20668F9
MS20668-10	MS20668F10
MS20668-12	MS20668F12
MS20668-14	MS20668F14
MS20668-16	MS20668F16
MS20668-18	MS20668F18
MS20668-20	MS20668F20
MS20668-24	MS20668F24
MS20668-28	MS20668F28
MS20668-32	MS20668F32

MILITARY INTEREST

Custodians:

Army – CR4
Navy – AS
Air Force – 99

Preparing Activity:

DLA-GS
(Project 1560-0260)

Review:

Air Force – 82

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