



LIMITS FOR DIMENSIONS C AND D

REVIEWER: IS, WP, 69, WC, MO
USER: MC, SH, MU, YD, NSA

	NOMINAL SIZE							
	1/16 X 1/16	3/32 X 3/32	1/8 X 1/8	3/16 X 3/16	1/4 X 1/4	5/16 X 5/16	3/8 X 3/8	
MAXIMUM	.0635	.0948	.126	.1885	.251	.3135	.376	
MINIMUM	.0625	.0937	.125	.1875	.250	.3125	.375	

	NOMINAL SIZE							
	7/16 X 7/16	1/2 X 1/2	9/16 X 9/16	5/8 X 5/8	3/4 X 3/4	7/8 X 7/8	1 X 1	
MAXIMUM	.4385	.501	.5635	.626	.751	.876	1.001	
MINIMUM	.4375	.500	.5625	.625	.750	.875	1.000	

- (A) **MATERIAL:** Alloy steel, Grade B, in accordance with procurement specification.
Carbon steel, Grade C, in accordance with procurement specification.
 - (A) **SHEAR STRENGTH (MIN):** Shear strength for grades B and C materials shall conform to the procurement specification.
 - (A) **HARDNESS:** Grade B keys shall be hardened in accordance with procurement specification.
- PROTECTIVE COATING:** Uncoated.
- DIMENSIONS:** All dimensions are in inches unless otherwise specified.
- PART NUMBER:** The MS part number consists of the MS number plus the dash number.
Example: MS20068-1.
- NOTES:**
- (1) Edges and corners shall be rounded (.010-.020 Rad.).
 - (2) The keys covered in this standard correspond to Type II, Style 2 of the procurement specification.
 - (3) For design feature purposes, this standard takes precedence over procurement documents referenced herein.
 - (4) Referenced documents shall be of the issue in effect on date of invitations for bid.

(A) For changes see sheets 1, 2, & 3.

P.A. WC Other Cus. WP 69	TITLE KEY, MACHINE-SQUARE IN CROSS SECTION, BOTH ENDS ROUND	MILITARY STANDARD MS 20068
PROCUREMENT SPECIFICATION 00-K-220	SUPERSEDES:	SHEET 1 OF 3

This military standard is approved by the Department of Defense and is mandatory on all activities. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

FED. SUP CLASS
5315

LENGTH A	DASH NUMBER							
	1/16 X 1/16		3/32 X 3/32		1/8 X 1/8		1/16 X 3/16	
	GRADE B	GRADE C	GRADE B	GRADE C	GRADE B	GRADE C	GRADE B	GRADE C
1/4	1	4	7	28	49	70	91	114
5/16	2	5	8	29	50	71	92	115
3/8	J	6	9	30	51	72	93	116
7/16			10	31	52	73	94	117
1/2			11	32	53	74	95	118
3/4			12	33	54	75	96	119
7/8			13	34	55	76	97	120
1			14	35	56	77	98	121
1-1/8			15	36	57	78	99	122
1-1/4			16	37	58	79	100	123
1-3/8			17	38	59	80	101	124
1-1/2			18	39	60	81	102	125
1-3/4			19	40	61	82	103	126
2			20	41	62	83	104	127
2-1/4			21	42	63	84	105	128
2-1/2			22	43	64	85	106	129
3			23	44	65	86	107	130
3-1/2			24	45	66	87	108	131
4			25	46	67	88	109	132
4-1/2			26	47	68	89	110	133
5			27	48	69	90	111	134
5-1/2							112	135
6							113	136

LENGTH A	DASH NUMBER							
	1/4 X 1/4		5/16 X 5/16		3/8 X 3/8		7/16 X 7/16	
	GRADE B	GRADE C	GRADE B	GRADE C	GRADE B	GRADE C	GRADE B	GRADE C
1/4	137	162	187	212	237	264	291	320
5/16	138	163	188	213	238	265	292	321
3/8	139	164	189	214	239	266	293	322
7/16	140	165	190	215	240	267	294	323
1/2	141	166	191	216	241	268	295	324
3/4	142	167	192	217	242	269	296	325
7/8	143	168	193	218	243	270	297	326
1	144	169	194	219	244	271	298	327
1-1/8	145	170	195	220	245	272	299	328
1-1/4	146	171	196	221	246	273	300	329
1-3/8	147	172	197	222	247	274	301	330
1-1/2	148	173	198	223	248	275	302	331
1-3/4	149	174	199	224	249	276	303	332
2	150	175	200	225	250	277	304	333
2-1/4	151	176	201	226	251	278	305	334
2-1/2	152	177	202	227	252	279	306	335
3	153	178	203	228	253	280	307	336
3-1/2	154	179	204	229	254	281	308	337
4	155	180	205	230	255	282	309	338
4-1/2	156	181	206	231	256	283	310	339
5	157	182	207	232	257	284	311	340
5-1/2	158	183	208	233	258	285	312	341
6	159	184	209	234	259	286	313	342
6-1/2	160	185	210	235	260	287	314	343
7	161	186	211	236	261	288	315	344
7-1/2					262	289	316	345
8					263	290	317	346
9							318	347
10							319	348

NOTE: For material, protective coating and other pertinent data, see sheet 1.

(A) FIIN columns removed.

P.A. Other Coat	WC WP 69	TITLE KEY, MACHINE-SQUARE IN CROSS SECTION BOTH ENDS ROUND	MILITARY STANDARD MS 20068
PROCUREMENT SPECIFICATION OO-K-220	SUPERSEDES:	SHEET 2 OF	

REVIEWER: JS, WP, 69, WC, MO
USER : MC, SH, MU, YD, NSA

This military standard is approved by the Department of Defense and is mandatory on all activities. Substitution for all new engineering and design applications and for replacement use shall be made from this document.

APPROVED 22 SEPT 58 REVISED (A) FOR CHANGES SEE SHEETS 1, 2, AND 3.

FED. SUP CLASS
5315

LENGTH A	DASH NUMBER							
	1/2 X 1/2		9/16 X 9/16		5/8 X 5/8		3/4 X 3/4	
	GRADE B	GRADE C	GRADE B	GRADE C	GRADE B	GRADE C	GRADE B	GRADE C
1/4	349	379						
5/16	350	380						
3/8	351	381						
7/16	352	382						
1/2	353	383						
3/4	354	384						
7/8	355	385						
1	356	386						
1-1/8	357	387						
1-1/4	358	388						
1-3/8	359	389						
1-1/2	360	390	409	429	449	469		
1-3/4	361	391	410	430	450	470		
2	362	392	411	431	451	471	489	507
2-1/4	363	393	412	432	452	472	490	508
2-1/2	364	394	413	433	453	473	491	509
3	365	395	414	434	454	474	492	510
3-1/2	366	396	415	435	455	475	493	511
4	367	397	416	436	456	476	494	512
4-1/2	368	398	417	437	457	477	495	513
5	369	399	418	438	458	478	496	514
5-1/2	370	400	419	439	459	479	497	515
6	371	401	420	440	460	480	498	516
6-1/2	372	402	421	441	461	481	499	517
7	373	403	422	442	462	482	500	518
7-1/2	374	404	423	443	463	483	501	519
8	375	405	424	444	464	484	502	520
9	376	406	425	445	465	485	503	521
10	377	407	426	446	466	486	504	522
11	378	408	427	447	467	487	505	523
12			428	448	468	488	506	524

LENGTH A	DASH NUMBER			
	7/8 X 7/8		1 X 1	
	GRADE B	GRADE C	GRADE B	GRADE C
2-1/2	525	541	557	573
3	526	542	558	574
3-1/2	527	543	559	575
4	528	544	560	576
4-1/2	529	545	561	577
5	530	546	562	578
5-1/2	531	547	563	579
6	532	548	564	580
6-1/2	533	549	565	581
7	534	550	566	582
7-1/2	535	551	567	583
8	536	552	568	584
9	537	553	569	585
10	538	554	570	586
11	539	555	571	587
12	540	556	572	588

NOTE: For material, protective coating and other pertinent data, see sheet 1.

(A) FIIN columns removed.

P.A.	WC	TITLE	MILITARY STANDARD
Other Cust	WP	KEY, MACHINE-SQUARE IN CROSS SECTION,	MS 20068
	69	BOTH ENDS ROUND	
PROCUREMENT SPECIFICATION	SUPERSEDES:	SHEET	J OF
00-K-220			

REVIEWER: JS, WT, 69, VC, MO
USER : MC, SH, MD, YD, NSA

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APPROVED 22 SEPT 58 REVISED (A) FOR CHANGES SEE SHEETS 1, 2, AND 3