

MAK-A-KEY®

PRECISION MIL-SPEC KEY STOCK

Cut & Fit™

CARBON STEEL ★ ALLOY STEEL ★ STAINLESS STEEL



DFARS COMPLIANT ★ TIGHT TOLERANCES
MIL-SPEC COMPLIANT FOR NASM20066/20067/20068

**SIZE & LOT NO.
 MARKED ON
 EVERY PIECE**

Grade C Carbon Steel Plain Finish		
Size	12" Bars	36" Bars
1/8" Square	MS34-01250125-12	MS34-01250125-36
3/16" Square	MS34-01870187-12	MS34-01870187-36
1/4" Square	MS34-02500250-12	MS34-02500250-36
5/16" Square	MS34-03120312-12	MS34-03120312-36
3/8" Square	MS34-03750375-12	MS34-03750375-36
7/16" Square	MS34-04370437-12	—
1/2" Square	MS34-05000500-12	—
9/16" Square	MS34-05620562-12	—
5/8" Square	MS34-06250625-12	—
3/4" Square	MS34-07500750-12	—
7/8" Square	MS34-08750875-12	—
1" Square	MS34-10001000-12	—

Shear Strength: 60,000 psi min.

Grade B Alloy Steel Heat Treated to RC 40-50 / Plain Finish	
Size	12" Bars
3/32" Square	MS60-00930093-12
1/8" Square	MS60-01250125-12
3/16" Square	MS60-01870187-12
1/4" Square	MS60-02500250-12
5/16" Square	MS60-03120312-12
3/8" Square	MS60-03750375-12
7/16" Square	MS60-04370437-12
1/2" Square	MS60-05000500-12
9/16" Square	MS60-05620562-12
5/8" Square	MS60-06250625-12
3/4" Square	MS60-07500750-12
7/8" Square	MS60-08750875-12
1" Square	MS60-10001000-12

Hardness: HRC 40-50. Shear Strength: 90,000 psi min.

Grade A Stainless Steel (CRES) Passivated Finish	
Size	12" Bars
3/16" Square	MS85-01870187-12
1/4" Square	MS85-02500250-12
5/16" Square	MS85-03120312-12
3/8" Square	MS85-03750375-12
7/16" Square	MS85-04370437-12
1/2" Square	MS85-05000500-12

Shear Strength: 75,000 psi min.

OVERSIZE TOLERANCES	
Size	Squares
.0937 – 1.000"	+.0010/- .0000"
LENGTH TOLERANCE FOR 12 - 36" MIL-SPEC KEY STOCK: +0/- .125"	

Additional sizes up to 12 feet in length are available as special order. Lengths over 3 feet may be subject to a packing charge. Contact our sales team today for more details.

All key stock is manufactured in accordance with federal specifications: 00-K-220, ASTM A108, ASTM A322, ASTM A493, and ASTM A582.

Get full traceability! Every MIL-SPEC key stock order includes full compliance certs: CofC, Material Cert, Shear Test Results, and Heat Treat Cert (where applicable).



All MIL-SPEC parts are RoHS and DFARS compliant.

Visit huyett.com/keystock to learn more about the benefits and uses of MIL-SPEC Key Stock.

For detailed specifications and tolerances, visit huyett.com. Prices, materials, dimensions, tolerances, designs, and grades subject to change without notice.
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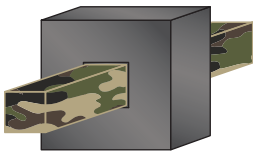
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PRECISION MIL-SPEC KEY STOCK

Cut & Fit™

Production Quality

Key stock, or "bright steel," refers to square and rectangle bars that are drawn to exacting tolerances with sharp corners, perpendicular and parallel sides, and smooth, bright surface finishes.



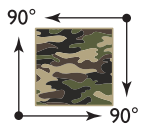
Cold Drawn
Bright Steel

Manufacturing true key stock to tight tolerances is challenging as tolerances for square and rectangle key stock tend to be more precise than for rounds or other forms because of the desired interference fit into the key way.



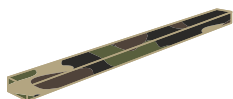
Sharp Corners

During production, as material passes through a die, stresses from cold working are introduced that may cause twisting. To produce superior finished results, Huyett has supported the development of cold drawing technologies while working in concert with U.S. and international steel mills.

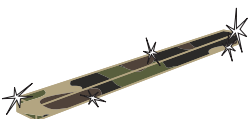


Perpendicular
Planes

Though harder to draw and more difficult to install, key stock with sharp corners is desired so that the interference fit of the key into the corners of the key way is optimized to reduce bearing stresses.



Straight



Bright

Key stock is more costly and difficult to produce, but it is near-finished when drawn compared to conventional steel bars. To produce a bright finish, key stock can be treated to produce a surface finish that is more uniform and precise compared to rounds and other forms.

MIL-SPEC Key Stock vs. Machine Keys

The terms machine key and key stock are used interchangeably to the point of creating confusion. Technically, the term key stock refers to a stock of material that is one foot or greater in length from which shaft/machine keys are made. Generally, longer lengths are preferred by high quantity users because machine setup time is significantly reduced. Custom lengths are available upon request.



MIL-SPEC Machine Keys
12" and Under
Length Tolerance: +/- .010"

MIL-SPEC Key Stock
12" and Up
Length Tolerance: +0/- .125"

Key stock is available in any length from 1' to 12'

Cut & Fit™ Precision MIL-SPEC Key Stock

A key may be cut from stock in the field and fit into a key way for aftermarket repairs, or in contract shops that use short production runs.



Cut to Length



Fit into Key Way

Key Way Fit

Also known as a transition fit, the key width and the key way can have a slight clearance or interference fit sufficient to hold mating parts together while still allowing for disassembly.



Visit www.huyett.com/MyAccount/OrderHistory to download
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