

MACHINE KEYS

HUYETT.COM • 785-392-3017

BOX 232 • MINNEAPOLIS, KS • 67467
SALES@HUYETT.COM • FAX 785-392-2845

COLD FINISHED STEEL – IMPERIAL

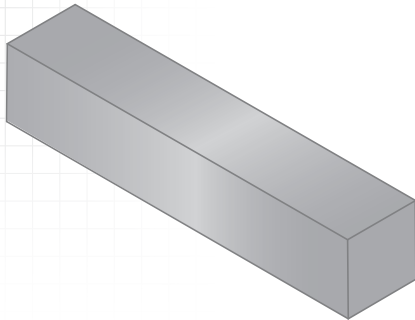
DESCRIPTION

Machine keys are used to transmit torque from a rotating shaft to a gear or sprocket. They can be finished in a variety of shapes, sizes, and materials for just about any application. Standard sizes are ready to use with little or no cutting or filing.

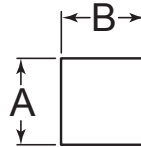
HOW TO IDENTIFY

1. Measure height (A).
2. Measure width (B).
3. Measure length (C).
4. Build the part number from the chart on the next page.

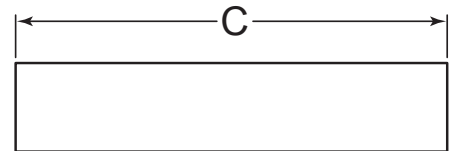
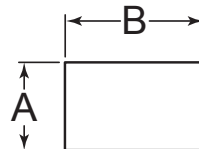
FORM B



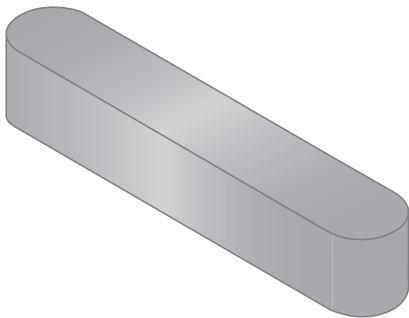
SQUARE



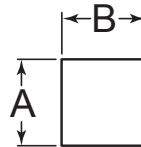
RECTANGLE



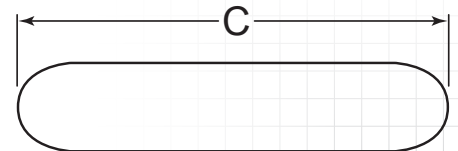
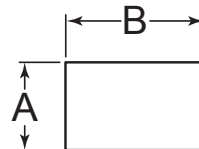
FORM A



SQUARE



RECTANGLE



PREFIX MATERIAL/FINISH

FORM B

UNDERSIZE

30	=	Cold Finished Steel, Plain*
31	=	Cold Finished Steel, Zinc Clear Trivalent
45	=	Cold Finished Steel, Plain* (1045)
46	=	Cold Finished Steel, Zinc Clear Trivalent (1045)
65	=	Cold Finished Alloy Steel, Plain* (4140)
66	=	Cold Finished Alloy Steel, Zinc Clear Trivalent (4140)

OVERSIZE

35	=	Cold Finished Steel, Plain*
36	=	Cold Finished Steel, Zinc Clear Trivalent

FORM A

UNDERSIZE

32	=	Cold Finished Steel, Plain*
32Z	=	Cold Finished Steel, Zinc Clear Trivalent
47	=	Cold Finished Steel, Plain* (1045)
67	=	Cold Finished Alloy Steel, Plain* (4140)

OVERSIZE

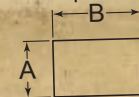
37	=	Cold Finished Steel, Plain*
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Material/finish combinations may not be available in all sizes. Unless specifically stated, our standard machine key stock (30 series) is any one of the following grades, subject to market availability: 1018, 1035, 1045, 1095, 1215, or 8630. Call for precise grade.

SEE PAGE 66 FOR TOLERANCES

MEASURING IMPERIAL KEYS

Imperial machine keys are available in square or rectangle profiles.



Imperial machine keys call out height (A) first, then width (B).

IMPERIAL



COLD FINISHED STEEL – IMPERIAL

ZINC PLATING AND OTHER FINISHES AVAILABLE FOR ALL PARTS
SEE PAGE 16

HOW TO BUILD A PART NUMBER

35 0125 0625 - 0875

LIST THE **SMALLER** DIMENSION OF (A) OR (B) FIRST



ITEM PREFIX

(A)
HEIGHT

(B)
WIDTH

(C)
LENGTH

1/16" to 2-1/2"

1/16" to 2-1/2"

3/16" to <12"

35

0125

0625

-0875

TO ORDER CHOOSE YOUR MATERIAL,

CHOOSE YOUR HEIGHT,

CHOOSE YOUR WIDTH,

CHOOSE YOUR LENGTH.

CODE	MATERIAL
30	Cold Finished Steel, Plain*, Form B, Undersize
31	Cold Finished Steel, Zinc Clear Trivalent, Form B, Undersize
32	Cold Finished Steel, Plain*, Form A, Undersize
32Z	Cold Finished Steel, Zinc Clear Trivalent, Form A, Undersize
35	Cold Finished Steel, Plain*, Form B, Oversize
36	Cold Finished Steel, Zinc Clear Trivalent, Form B, Oversize
37	Cold Finished Steel, Plain*, Form A, Oversize
45	Cold Finished Steel, Plain* (1045), Form B, Undersize
46	Cold Finished Steel, Zinc Clear Trivalent (1045), Form B, Undersize
47	Cold Finished Steel, Plain* (1045), Form A, Undersize
65	Cold Finished Alloy Steel, Plain* (4140), Form B, Undersize
66	Cold Finished Steel, Zinc Clear Trivalent, Form B, Undersize
67	Cold Finished Alloy Steel, Plain* (4140), Form A, Undersize

CODE	HEIGHT & WIDTH SIZE OPTIONS
0062	.0625" (1/16)
0093	.0938" (3/32)
0125	.1250" (1/8)
0156	.1563" (5/32)
0187	.1875" (3/16)
0218	.2188" (7/32)
0250	.2500" (1/4)
0281	.2813" (9/32)
0312	.3125" (5/16)
0375	.3750" (3/8)
0437	.4375" (7/16)
0500	.5000" (1/2)
0562	.5625" (9/16)
0625	.6250" (5/8)
0687	.6875" (11/16)
0750	.7500" (3/4)
0812	.8125" (13/16)
0875	.8750" (7/8)
0937	.9378" (15/16)
1000	1.0000" (1)
1062	1.0625" (1-1/16)
1125	1.1250" (1-1/8)
1187	1.1875" (1-3/16)
1250	1.2500" (1-1/4)
1375	1.3750" (1-3/8)
1500	1.5000" (1-1/2)
1625	1.6250" (1-5/8)
1750	1.7500" (1-3/4)
1875	1.8750" (1-7/8)
2000	2.0000" (2)
2250	2.2500" (2-1/4)
2500	2.5000" (2-1/2)

Nonstandard sizes up to 2-1/2" are available.

CODE	LENGTH
0187	.1875" (3/16)
0250	.2500" (1/4)
0375	.3750" (3/8)
0500	.5000" (1/2)
0625	.6250" (5/8)
0750	.7500" (3/4)
0875	.8750" (7/8)
1000	1.0000" (1)
1500	1.5000" (1-1/2)
2000	2.0000" (2)
4000	4.0000" (4)
6000	6.0000" (6)
8000	8.0000" (8)
10	10.0000" (10)
11	11.0000" (11)
11.5	11.5000" (11-1/2)

Nonstandard lengths less than 12" are available.

**SECONDARY PROCESS:
HEAT TREATING**

OUR STANDARD MATERIALS POSSESS A TYPICAL HARDNESS OF HRB-80

HRB-80

NEED SOMETHING HARDER THAN HRB-80?

CONTACT SALES@HUYETT.COM OR CALL 785-392-3017

FOR DETAILED SPECIFICATIONS AND TOLERANCES, VISIT HUYETT.COM.

Prices, materials, dimensions, tolerances, designs, and grades subject to change without notice. © 2016 G.L. Huyett

*Limited warranty for surface finish: 30 days from date of shipment. See page ## for details.

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IMPERIAL TOLERANCES


MATERIAL		FORM	SQUARE		RECTANGLE		LENGTH	
(Prefix)	(Material/Finish)		(Size Range)	(Tolerance)	(Size Range)	(Tolerance)	(Size Range)	(Tolerance)
Cold Finished Steel								
30	Cold Finished Steel, Plain*, Undersize	Form B	.0625 – .7500"	+0/-.0020"	.0938 – .7500"	+0/-.0030"	All sizes	+0/-.0300"
			>.7500 – 1.5000"	+0/-.0030"	>.7500 – 1.5000"	+0/-.0040"		
			>1.5000 – 2.5000"	+0/-.0040"	>1.5000 – 3.0000"	+0/-.0050"		
			>2.5000" +	+0/-.0060"	>3.0000" +	+0/-.0060"		
31	Cold Finished Steel, Zinc Clear Trivalent, Undersize							
32	Cold Finished Steel, Plain*, Undersize	Form A						
32Z	Cold Finished Steel, Zinc Clear Trivalent, Undersize							
35	Cold Finished Steel, Plain*, Oversize	Form B	.0625 – .7500"	+0.0020/-0"	.1875 – .7500"	+0.0030/-0"	All sizes	+0/-.0300"
			>.7500 – 1.5000"	+0.0030/-0"	>.7500 – 1.5000"	+0.0040/-0"		
			>1.5000 – 2.5000"	+0.0040/-0"	>1.5000 – 3.0000"	+0.0050/-0"		
36	Cold Finished Steel, Zinc Clear Trivalent, Oversize							
37	Cold Finished Steel, Plain*, Oversize	Form A						
45	Cold Finished Steel, Plain* (1045), Undersize	Form B	.0625 – .7500"	+0/-.0040"	.2500 – .7500"	+0/-.0040"	All sizes	+0/-.0300"
			>.7500 – 1.5000"	+0/-.0050"	>.7500 – 1.5000"	+0/-.0050"		
			>1.5000 – 2.5000"	+0/-.0060"	>1.5000 – 3.0000"	+0/-.0060"		
46	Cold Finished Steel, Zinc Clear Trivalent, Undersize							
47	Cold Finished Steel, Plain* (1045), Undersize	Form A						
65	Cold Finished Alloy Steel, Plain* (4140), Undersize	Form B	.0625 – .7500"	+0/-.005"	.0625 – .7500"	+0/-.005"	All sizes	+0/-.0300"
			>.7500 – 1.5000"	+0/-.006"	>.7500 – 1.5000"	+0/-.006"		
			>1.5000 – 3.0000"	+0/-.007"	>1.5000 – 3.0000"	+0/-.007"		
66	Cold Finished Steel, Zinc Clear Trivalent, Undersize							
67	Cold Finished Alloy Steel, Plain* (4140), Undersize	Form A						
Moltrup								
60	Moltrup Quality Steel, Plain* (1045 or 8630)	Form B	.0625 – 1.2500"	+0.0010/-0"	(Width) .0625 – 1.2500"	+0.0010/-0"	All Sizes	+0/-.0300"
			>1.2500 – 3.0000"	+0.0020/-0"	>1.2500 – 3.0000"	+0.0020/-0"		
62	Moltrup Quality Steel, Plain* (1045 or 8630)	Form A			(Height) .0625 – 7.0000"	±.0050"		

Note: Unless specifically stated, our standard machine key stock (30 series) is any one of the following grades, subject to market availability: 1018, 1035, 1045, 1095, 1215, or 8630. Call for precise grade.



IMPERIAL TOLERANCES

MATERIAL		FORM	SQUARE		RECTANGLE		LENGTH	
(Prefix)	(Material/Finish)		(Size Range)	(Tolerance)	(Size Range)	(Tolerance)	(Size Range)	(Tolerance)
Stainless Steel								
70	300 Series Stainless Steel, Plain**	Form B	.0937 – .3120" >.3120 – .5000" >.5000 – 1.0000" >1.0000 – 2.0000"	+0/-.0020" +0/-.0030" +0/-.0040" +0/-.0060"	(Width Size) .0625 – .3750" >.3750 – 1.0000" >1.0010 – 2.0000"	±.0050" ±.0040" ±.0060"	All sizes	+0/-.0300"
72	300 Series Stainless Steel, Plain**	Form A			(Height Size) .03500 – 1.0000" >1.0000 – 2.0000"	±.0020" ±.0030"		
75	300 Series Stainless Steel, Plain, Oversize	Form B	.0625 – .5625" >.5625 – 1.0000" >1.0000 – 2.0000"	+ .0030/-0" + .0050/-0" + .0060/-0"	.0625 – .5625" >.5625 – 1.0000" >1.0000 – 2.0000"	+ .0030/-0" + .0050/-0" + .0060/-0"	All sizes	+0/-.0300"
77	300 Series Stainless Steel, Plain, Oversize	Form A						
80	316 Stainless Steel, Plain**	Form B	.0937 – .3120" >.3120 – .5000" >.5000 – 1.0000" >1.0000 – 2.0000"	+0/-.0020" +0/-.0030" +0/-.0040" +0/-.0060"	(Width Size) .0625 – .3750" >.3750 – 1.0000" >1.0010 – 2.0000"	±.0050" ±.0040" ±.0060"	All sizes	+0/-.0300"
82	316 Stainless Steel, Plain**	Form A			(Height Size) .03500 – 1.0000" >1.0000 – 2.0000"	±.0020" ±.0030"		
85	416 Stainless Steel, Plain**	Form B						
87	416 Stainless Steel, Plain**	Form A						
Nonferrous								
04	Aluminum, Plain**	Form B	.1250 – .3750" >.3750 – .6250" >.6250 – .8750" >.8750 – 1.2500" >1.2500 – 1.7500" >1.7500 – 2.5000"	±.0080" ±.0090" ±.0100" ±.0120" ±.0140" ±.0240"	.1250 – .3750" >.3750 – .6250" >.6250 – .8750" >.8750 – 1.2500" >1.2500 – 1.7500" >1.7500 – 2.5000"	±.0080" ±.0090" ±.0100" ±.0120" ±.0140" ±.0240"	All Sizes	+0/-.0300"
06	Brass, Plain**	Form B	.1250" >.1875 – .5000" >.5000 – 1.0000" >1.0000 – 2.0000"	±.0020" ±.0030" ±.0040" ±.0050"	.1250" >.1250 – .5000" >.5000 – 1.0000" >1.0000 – 2.0000"	±.0020" ±.0030" ±.0040" ±.0050"	All Sizes	+0/-.0300"

 18-8 IS NOT A SPECIFICATION FOR STAINLESS STEEL
G.L. HUYETT CONSIDERS 18-8 TO BE ANY 300 SERIES STAINLESS STEEL

**Depending on profile, size can vary over or under from nominal size.

ENVIRONMENTAL CONCERNS

G.L. Huyett is committed to maintaining the safety of our environment. The processes for plating and coating steels have the potential of introducing harmful chemical substances into the environment and are strictly controlled. G.L. Huyett complies with all environmental regulations and laws which apply to our products and services.

Learn more at huyett.com/quality.



REACH
Registration, Evaluation, Authorization, and Restriction of Chemical Substances



RoHS
Restriction of Hazardous Substances