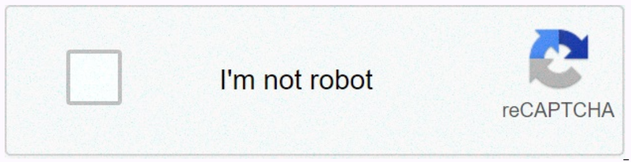

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All dimensions are given in inches. The Woodruff Key numbers indicate normal key dimensions. The last two figures give the nominal diaper B in eighth of an inch and the figures preceding the last two give the nominal width W in thirty seconds of an inch. Related Resources: Hardware Keyseat Dimensions for Woodruff Keys per. ANSI B17.2 ANSI Hardware Design and Guide ANSI Shaft and Hub Keyseat Dimensions for Woodruff Keys per. ANSI B17.2 Related: ANSI Key No. Nominal Size Keyseat Shaft Key Above Shaft Keyseat Hub Width A* Depth B Diameter F Height C Width D Depth E Key Min. Max. +0.005 −0.000 Min. Max. +0.005 −0.005 +0.002 −0.000 +0.005 −0.000 0.0 202 16 × 1.4 0.0615 0.0630 0.0728 0.250 0.268 0.0312 0.0635 0.0372 202.5 1⁄16 × 5⁄16 0.0615 0.0630 0.1038 0.312 0.330 0.0312 0.0635 0.0372 302.5 3⁄32 × 5⁄16 0.0928 0.0943 0.0882 0.312 0.330 0.0469 0.0948 0.0529 203 1⁄16 × 3⁄8 0.0615 0.0630 0.1358 0.375 0.393 0.0312 0.0635 0.0372 303 3⁄32 × 3⁄8 0.0928 0.0943 0.1202 0.375 0.393 0.0469 0.0948 0.0529 403 1⁄8 × 3⁄8 0.1240 0.1255 0.1045 0.375 0.393 0.0625 0.1260 0.0685 204 1⁄16 × 1⁄2 0.0615 0.0630 0.1668 0.500 0.518 0.0312 0.0635 0.0372 304 3⁄32 × 1⁄2 0.0928 0.0943 0.1511 0.500 0.518 0.0469 0.0948 0.0529 404 1⁄8 × 1⁄2 0.1240 0.1255 0.1355 0.500 0.518 0.0625 0.1260 0.0685 305 3⁄32 × 5⁄8 0.0928 0.0943 0.1981 0.625 0.643 0.0469 0.0948 0.0529 405 1⁄8 × 5⁄8 0.1240 0.1255 0.1825 0.625 0.643 0.0625 0.1260 0.0685 505 5⁄32 × 5⁄8 0.1553 0.1568 0.1669 0.625 0.643 0.0781 0.1573 0.0841 605 3⁄16 × 5⁄8 0.1863 0.1880 0.1513 0.625 0.643 0.0937 0.1885 0.0997 406 1⁄8 × 3⁄4 0.1240 0.1255 0.2455 0.750 0.768 0.0625 0.1260 0.0685 506 5⁄32 × 3⁄4 0.1553 0.1568 0.2299 0.750 0.768 0.0781 0.1573 0.0841 606 3⁄16 × 3⁄4 0.1863 0.1880 0.2143 0.750 0.768 0.0937 0.1885 0.0997 806 1⁄4 × 3⁄4 0.2487 0.2505 0.1830 0.750 0.768 0.1250 0.2510 0.1310 507 5⁄32 × 7⁄8 0.1553 0.1568 0.2919 0.875 0.895 0.0781 0.1573 0.0841 607 3⁄16 × 7⁄8 0.1863 0.1880 0.2763 0.875 0.895 0.0937 0.1885 0.0997 707 7⁄32 × 7⁄8 0.2175 0.2193 0.2607 0.875 0.895 0.1093 0.2198 0.1153 807 1⁄4 × 7⁄8 0.2487 0.2505 0.2450 0.875 0.895 0.1250 0.2510 0.1310 608 3⁄16 × 1 0.1863 0.1880 0.3393 1.000 1.020 0.0937 0.1885 0.0997 708 7⁄32 × 1 0.2175 0.2193 0.3237 1.000 1.020 0.1093 0.2198 0.1153 808 1⁄4 × 1 0.2487 0.2505 0.3080 1.000 1.020 0.1250 0.2510 0.1310 1008 5⁄16 × 1 0.3111 0.3130 0.2768 1.000 1.020 0.1562 0.3135 0.1622 1208 3⁄8 × 1 0.3735 0.3755 0.2455 1.000 1.020 0.1875 0.3760 0.1935 609 3.16 × 11.1863 0.1880 0.3853 1.125 1.145 0.0937 0.1885 0.0997 709 7.32 × <2> 0.2175 0.2193 0.3697 1.125 1.145 0.1093 0.2198 0.1153 809 1.4 × 11.8 8 0.80.2487 0.2505 0.3540 1.125 1.145 0.1250 0.2510 0.1310 1009 5209 522 × 11.8 0.3111 0.3130 0.3228 1.125 1.145 0.1562 0.3135 0.1622 610 320 × 11 0.1863 0.1880 1.250 1.273 0.0937 0.1885 0.0997 710 7⁄32 × 11⁄4 0.2175 0.2193 0.4327 1.250 1.273 0.1093 0.2198 0.1153 810 1⁄4 × 11⁄4 0.2487 0.2505 0.4170 1.250 1.273 0.1250 0.2510 0.1310 1010 5⁄16 × 11⁄4 0.3111 0.3130 0.3858 1.250 1.273 0.1562 0.3135 0.1622 1210 3⁄8 × 11⁄4 0.3735 0.3755 0.3545 1.250 1.273 0.1875 0.3760 0.1935 811 1⁄4 × 13⁄8 0.2487 0.2505 0.4640 1.375 1.398 0.1250 0.2510 0.1310 1011 5⁄16 × 13⁄8 0.3111 0.3130 0.4328 1.375 1.398 0.1562 0.3135 0.1622 NSI Skag en Hub Keyseat Dimensies vir Woodruff Keys per. ANSI B17.2 voortgesette Sleutel Nr. Nominal Size Key Keyseat Shaft Key Above Shaft Keyseat Hub Width A* Depth B Diameter F Height C Width D Depth E Min. Max. +0.005 −0.000 Min. Max. +0.005 −0.005 +0.002 −0.000 +0.005 −0.000 1211 3⁄8 × 13⁄8 0.3735 0.3755 0.4015 1.375 1.398 0.1875 0.3760 0.1935 812 1⁄4 × 11⁄2 0.2487 0.2505 0.5110 1.500 1.523 0.1250 0.2510 0.1310 1012 5⁄ 16 × 11⁄2 0.3111 0.3130 0.4798 1.500 1.523 0.1562 0.3135 0.1622 1212 3⁄8 × 11⁄2 0.3735 0.3755 0.4485 1.500 1.523 0.1875 0.3760 0.1935 617-1 3⁄16 × 21⁄8 0.1863 0.1880 0.3073 2.125 2.160 0.0937 0.1885 0.0997 817-1 1⁄4 × 21⁄8 0.2487 0.2505 0.2760 2.125 2.160 0.1250 0.2510 0.1310 1017-1 5⁄16 × 21⁄8 0.3111 0.3130 0.2448 2.125 2.160 0.1562 0.3135 0.1622 1217-1 3⁄8 × 21⁄8 0.3735 0.3755 0.2135 2.125 2.160 0.1875 0.3760 0.1935 617 3⁄16 × 21⁄ 8 0.1863 0.1880 0.4323 2.125 2.160 0.0937 0.1885 0.0997 817 1⁄4 × 21⁄8 0.2487 0.2505 0.4010 2.125 2.160 0.1250 0.2510 0.1310 1017 5⁄16 × 21⁄8 0.3111 0.3130 0.3698 2.125 2.160 0.1562 0.3135 0.1622 1217 3⁄8 × 21⁄8 0.3735 0.3755 0.3385 2.125 2.160 0.1875 0.3760 0.1935 822-1 1⁄4 × 23⁄4 0.2487 0.2505 0.4640 2.750 2.785 0.1250 0.2510 0.1310 1022-1 5⁄16 × 23⁄4 0.3111 0.3130 0.4328 2.750 2.785 0.1562 0.3135 0.1622 1222-1 3⁄8 × 23⁄4 0.3735 0.3755 0.4015 2.750 2.785 0.1875 0.3760 0.1935 1422-1 7⁄16 × 23⁄4 0.4360 0.4380 0.3703 2.750 2.785 0.2187 0.4385 0.2247 1622-1 1⁄2 × 23⁄4 0.4985 0.5005 0.3390 2.750 2.785 0.2500 0.5010 0.2560 822 1⁄4 × 23⁄4 0.2487 0.2505 0.6200 2.750 2.785 0.1250 0.2510 0.1310 1022 5⁄16 × 23⁄4 0.3111 0.3130 0.5888 2.750 2.785 0.1562 0.3135 0.1622 1222 3⁄8 × 23⁄4 0.3735 0.3755 0.5575 2.750 2.785 0.1875 0.3760 0.1935 1422 7⁄16 × 23⁄4 0.4360 0.4380 0.5263 2.750 2.785 0.2187 0.4385 0.2247 1622 1⁄2 × 23⁄4 0.4985 0.5005 0.4950 2.750 2.785 0.2500 0.5010 0.2560 1228 3⁄8 × 31⁄2 0.3735 0.3755 0.7455 3.500 3.535 0.1875 0.3760 0.1935 1428 7⁄16 × 31⁄2 0.4360 0.4380 0.7143 3.500 3.535 0.2187 0.4385 0.2247 1628 1⁄2 × 31⁄2 0.4985 0.5005 0.6830 3.500 3.535 0.2500 0.5010 0.2560 1828 9⁄16 × 31⁄2 0.5610 0.5630 0.6518 3.500 3.535 0.2812 0.5635 0.2872 2028 5⁄8 × 31⁄2 0.6235 0.6255 0.6205 3.500 3.535 0.3125 0.6260 0.3185 2228 11⁄16 × 31⁄2 0.6860 0.6880 0.5893 3.500 3.535 0.3437 0.6885 0.3497 2428 × 3.535 0.7485 0.7505 0.5580 3.500 3.535 0.3750 0.7510 0.0. 0.0.0.0.0.3750 0.7510 0.500 3.535 0.3750 0.7510 0.500 3.535 0.3750 0.7510 0.0.535 0.3750 0.7510 0.500 3.535 0.3753810 * These Width A values are set with the maximum key seat (shaft) width as that figure that will receive a key with the largest amount of detachment in accordance with the key's ensuring stick in the key seat (shaft). Minimum key seat width is that the figure allows the largest shaft distortion acceptable when meeting maximum key in the minimum key seat. Dimensions A, B, C, D are taken at the intersection. All dimensions are given in inches. © Copyright 2000 - 2020, by Engineers Edge, LLC www.engineersedge.com All Rights Reserved Indemnity | Feedback | Advertise | Contact Date/Time: © 1996-2014, Amazon.com, Inc. or its affiliates When we need to make a part in a shaft, such as a gear or pulley, key paths, keys, and key seat work come in the game. So, let's start by getting our terminology straight. A keyway is a slot of some kind used to align the part on a shaft and prevent the part sliding as the shaft turns. A key goes into the Keyway to close things. Another name for a Keyway is a Keyseat, since the key is put in the Keyseat. When a specialized cutter is used to cut the Keyseat, it is a Keyseat Cutter. A Woodruff Cutter is a Keyseat Cutter. There are several types of keys in common use. Parallel Keyways & Keys Parallel keys are the simplest, and involve a lock that goes all the way through at least sharing with the shortest axial pairing length (i.e. the gear or the pulley. Cutting a parallel key is simply—just use an endmill and treat it as cutting any other slot. Alternatively, you can use a Keyseat Cutter like a Woodruff Cutter. Key stock is available pre-cut in standard inches and metric sizes, and the points can be either square or rounded. Parallel Inch Key Sizes Shaft Diameter Width Keyway (Shaft Keyway (Hub) Radius r Height Width Height Width height Over To/Inc W & T Min Max Max Min Min Max Min Max 1/4 1/2 1/8 0.124 0.125 0.072 0.078 0.125 0.126 0.06 0.066 0.01 1/2 3/4 3/16 0.187 0.188 0.107 0.113 0.188 0.189 0.088 0.094 0.01 3/4 1 1/4 0.249 0.25 0.142 0.148 0.25 0.251 0.115 0.121 0.01 1 1 1/4 5/16 0.311 0.312 0.177 0.183 0.312 0.313 0.142 0.148 0.01 1 1/4 1 1/2 3/8 0.374 0.375 0.213 0.219 0.375 0.376 0.169 0.175 0.01 1 1/2 1 3/4 7/16 0.437 0.438 0.248 0.254 0.438 0.439 0.197 0.203 0.02 1 3/4 2 1/2 0.499 0.5 0.283 0.289 0.5 0.501 0.224 0.23 0.02 2 2 1/2 5/8 0.624 0.625 0.354 0.36 0.625 0.626 0.278 0.284 0.02 2 1/2 3 3/4 0.749 0.75 0.424 0.43 0.75 0.751 0.333 0.339 0.02 3 3 1/2 7/8 0.874 0.875 0.495 0.501 0.875 0.876 0.387 0.393 0.062 3 1/2 4 1 0.999 1 0.566 1 1.001 0.442 0.448 0 062 4 5 1 1/4 1.248 1.25 0.707 0.713 1.25 1.252 0 551 0.557 0.062 5 6 1 1/2 1.498 1.5 0.848 0.854 1.2.498 1.5 0.848 0.854 1.498 1.5 0.848 0.854 1.2.498 1.5 0.848 0.854 1.2.498 1.5 0.848 0.854 1.498 1. 5 1.502 0.661 0.667 0.062 Per BS 46 Part 1 : 1958 Keys and keys and tapered pins. Specification. Keys and keyways. Parallel Metric Key Key Nominal Diameter Key KeyWay d b x h width x thck Width b Depth Radius r Nom Tolerance Class Shaft t1 Hub t2 Over Incl Free Normal Close/Int – – – – Shaft Hub Shaft Hub Shaft/Hub Nom Tol Nom Tol Max min H9 D10 N9 Js9 P9 6 8 2×2 2 +0,025 +0,06 -0,004 +0,012 -0,006 1,2 +0,1 1,0 +0,1 0,16 0,08 8 10 3×3 3 0 +0,02 -0,029 -0,012 -0,031 1,8 0 1,4 0 0,16 0,08 10 12 4×4 4 +0,03 +0,078 0 +0,015 -0,012 2,5 1,8 0,16 0,08 12 17 5×5 5 0 +0,030 -0,030 -0,015 -0,042 3,0 2,3 0,25 0,16 17 22 6×6 6 3,5 2,8 0,25 0,16 22 30 8×7 8 +0,036 +0,098 0 +0,018 -0,015 4,0 +0,2 3,3 +0,2 0,25 0,16 30 38 10×8 10 0 +0,040 -0,036 -0,018 -0,051 5,0 0 3,3 0 0,40 0,25 38 44 12×8 12 +0,043 +0,12 0 +0,021 -0,018 5,0 +0,2 3,3 + 0,2 0,40 0,25 44 50 14×9 14 0 +0,050 -0,043 -0,021 -0,061 5,5 0 3,8 0 0,40 0,25 50 58 16×10 16 6,0 4,3 0,40 0,25 58 65 18×11 18 7,0 4,4 0,40 0,25 65 75 20×12 20 +0,052 +0,149 0 +0,026 -0,022 7,5 4,9 0,60 0,40 75 85 22×14 22 0 +0,065 -0,052 -0,026 -0,074 9,0 5,4 0,60 0,40 85 95 25×14 25 9,0 5,4 0,60 0,40 95 110 28×16 28 10,0 6,4 0,60 0,40 110 130 32×18 32 +0,062 +0,18 0 +0,031 -0,026 11,0 7,4 0,6 0,4 130 150 36×20 36 0 +0,080 -0,062 -0,031 -0,088 12,0 +0,3 8,4 +0,3 1,0 0,7 150 170 40×22 40 13,0 0 9,4 0 1,0 0,7 170 200 45×25 45 15,0 10,4 1,0 0,7 200 230 50×28 50 17,0 11,4 1,0 0,7 230 260 56×32 56 +0,074 +0,220 0 +0,037 -0,032 20,0 12,4 1,6 1,2 260 290 63×32 63 0,100 -0,074 -0,037 -0,106 20,0 12,4 1,6 1,2 290 330 70×36 70 22,0 0 14,4 1,6 1,2 330 380 80×40 80 25,0 15,4 2,5 2,0 380 440 90×45 90 +0,... 087 +0,260 0 +0,043 -0,037 28,0 17,4 2,5 2,0 440 500 100×50 100 0,120 -0 0,087 -0,043 -0,124 31,0 20 2,5 2,0 Per BS 4235-1:1972: Specification for metric keys and keys – Parallel and tapered keys. Woodruff Keyways & Keys Woodruff Keys is an alternative to Parallel Keys. They are semi-circular, and fit in a Keyway formed as a circular segment in the shaft and a rectangular slot in the pairing part. The semi-circular lock is cut by a Woodruff Cutter (the correct Keyseat Cutter for this Style Keyway) to plink into the workpiece. The benefits of Woodruff Keys over Parallel Keys are: They switch the grind near shaft shoulders that reduce stress concentrations and make it easier to maintain circular restrictions. They are therefore better suited to higher speed operation of the rotating shaft. The key usually has a more precise pass that reduces game and improves the reliability of the key. A Woodruff key can be easier to remove with a hammer blow since the circular profile will push the key out of the lock. A parallel key requires the key aksaal 'n langer afstand. Woodruff Keys is ontwikkel in 1888 deur W.N. Woodruff of Connecticut, VSA. Woodruff sleutels kan volle radius of plat onderkant wees, maar die sleutelseat sal altyd deur die Keyseat Cutter / Woodruff Cutter geradik word. A flat bottom Woodruff Key has part of the radius shaved right at the bottom: Woodruff Key Dimensions (Inch) Like Parallel Keys, Woodruff Keys come in standard sizes: KEY NUMBER KEY DIMENSIONS SHAFT DIAMETER HEIGHT OF KEY ABOVE SHAFT DEPTH OF KEYWAY DIAMETER WIDTH MINIMUM MAXIMUM 204 1/2 1/16 5/16 3/8 0.0312 0.1718 304 1/2 3/32 5/16 1/2 0.0469 0.1 561 404 1/2 1/8 9/16 3/4 0.0625 0.1405 405 5/8 1/8 9/16 3/4 0.0625 0.1875 505 5/8 5/32 13/16 15/16 0.0781 0.1719 406 3/4 1/8 11/16 3/4 0.0625 0.2505 606 3/4 3/16 1 1 1/8 0.0937 0.2193 507 7/8 5/32 1 1/8 15/16 0.0781 0.2969 807 7/8 1/4 1 5/16 1 1/8 0.125 0.25 608 1 5/16 1 1 7/16 0.0937 0.3443 1008 1 5/16 1 1/16 1 5/8 0.1562 0.2818 609 1 1/8 5/16 1 1/16 1 7/16 0.0937 0.3903 810 1 1/4 1/4 1 1/4 1 3/4 0.125 0.422 1210 1 1/4 3/8 1 1/2 1 7/8 0.1875 0.3595 1011 1 3/8 1/2 1 13/16 2 0.1562 0.4378 Woodruff Sleutel Dimensies (Metrieke) w x h1 x D ..... Width b Depth Radius R Nom Tolerance Class Shaft t1 Hub t2 Normal Close Shaft Hub Shaft & Hub P6 Nom Tol Nom Tol Max min N9 Js9 1,0 x 1,4 x 4 1 -0,004 +0,012 -0,006 1,0 +0,1 0,6 +0,1 0,16 0,08 1,5 x 2,6 x 7 1,5 -0,029 -0,012 -0,0031 2,0 0 0,8 0 0,16 0,08 2,0 x 2,6 x 7 2,0 1,8 1,0 0,16 0,08 2,0 x 3,7 x 10 2,0 2,9 1,0 0,16 0,08 2,5 x 3,7 x 10 2,5 2,7 1,2 0,16 0,08 3,0 x 5,0 x 13 3,0 3,8 +0,2 1,4 0,16 0,08 3,0 x 6,5 x 16 3,0 5,3 0 1,4 0,16 0,08 4,0 x 6,5 x 16 4,0 0 +0,015 -0,012 5,0 1,8 0,25 0,16 4,0 x 7,5 x 19 4,0 -0,030 -0,015 -0,042 6,0 1,8 0,25 0,16 5,0 x 6,5 x 16 5,0 4,5 2,3 0,25 0,16 5,0 x 7,5 x 19 5,0 5,5 2,3 0,25 0,16 5,0 x 9.0 x 22 5,0 7,0 +0,3 2,3 0,25 0,16 6,0 x 9,0 x 22 6,0 6,5 0 2,8 0,25 0,1 6,0 x 11,0 x 28 6,0 7,5 2,8 +0,2 0,25 0,16 8,0 x 11,0 x 28 8,0 0 +00,018 +0,015 8,0 3,3 0 0,40 0,25 10,0 x 13,0 x 32 10,0 -0.036 -0.018 -0.051 10,0 3,3 0,4 0,25 Keyseat Cutters (aka Woodruff Cutters of Woodruff Sleutel Cutters) Woodruff Keys neem 'n spesiale Keyseat Cutter genoem 'n Woodruff Cutter. Dit is basies 'n klein saag. Hulle lyk soos volg: Woodruff Cutter & Keyseat Cutter Feeds en Speeds Sakrekenaar Ons G-Wizard Feeds en Speeds Sakrekenaar het spesiale ondersteuning vir Woodruff Cutters & Keyseat Cutters. Om die Woodruff Cutter in die Sakrekenaar op te stel, gaan ons links na regs, bo na onder: 1. Kies die masjien 2. Kies die Materiaal 3. Kies die Woodruff Cutter uit die instrument spyskaart, óf HSS of Carbide: 4. Voer jou snyer se deursnee en aantal tande 5. Tik jou snyer se dikte 6. the depth of cutting. This is the total depth of the keyseat. Here's the final result: Typical setup to find feeds and speed for a sliding saw... If you're not a registered Wizard user and you want to try our free 30-day trial, check it on this page. Join 100,000 + CNCs! Get our latest blog posts delivered straight to your email inbox once a week for free. Plus, we will give you access to some great CNC referral material, including: Our Large List of Over 200 CNC Tips and Techniques Our Free GCode Programming Basics Course and more! Just enter your name and email address below: 100% Privacy: We will never spam you! You!

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