



**STANDARD KEYWAY**

**and SET SCREW DIMENSIONS - INCHES**

SHAFT DIAMETER	KEYWAY WIDTH X DEPTH	SET SCREW DIAMETER	SHAFT DIAMETER	KEYWAY WIDTH X DEPTH	SET SCREW DIAMETER
1/2 - 9/16	1/8 X 1/16	1/4	3 5/16 - 3 3/4	7/8 X 7/16	3/4
5/8 - 7/8	3/16 X 3/32	1/4	3 13/16 - 4 1/2	1 X 1/2	3/4
15/16 - 1 1/4	1/4 X 1/8	5/16	4 9/16 - 5 1/2	1 1/4 X 5/8	3/4
1 5/16 - 1 3/8	5/16 X 5/32	5/16	5 9/16 - 6 1/2	1 1/2 X 3/4	1
1 7/16 - 1 3/4	3/8 X 3/16	3/8	6 9/16 - 7 1/2	1 3/4 X 7/8	1
1 13/16 - 2 1/4	1/2 X 1/4	1/2	7 9/16 - 8 15/16	2 X 1	1
2 5/16 - 2 3/4	5/8 X 5/16	5/8	9 - 10 15/16	2 1/2 X 1 1/4	1
2 13/16 - 3 1/4	3/4 X 3/8	3/4			

**WHEN KEYWAYS AND/OR SETSCREWS ARE ORDERED, BUT EXACT SPECIFICATIONS NOT INDICATED, THE FOLLOWING PRACTICES WILL BE FOLLOWED.**

Keyways are not located in line with sprocket or gear teeth unless requested. There is no additional charge for cutting in line but it should be understood that perfect alignment cannot be accomplished by normal shop methods. Because of variations in shafting, keystock and bore dimensions and the placement of keyways in shaft and bore, shaft misalignment or eccentricity or a combination of all of these, tooth alignment closer than + or - 0° 45' should not be anticipated from this method. Variations exceeding this amount are possible even when care is taken in all areas. For applications requiring particularly close alignment, we can supply adjustable hubs that allow one sprocket or gear to be rotated to match the other after installation on the shaft.

Keyways will be cut to the dimensions in the above table. Tapered keyways will be tapered 1/8" per foot - standard depth at deep end. Tapered keyways will be furnished with deep end on hub side of sprockets or gears with hub on one side only. If thickness of hub remaining over standard depth keyway is deemed inadequate, keyways will be cut shallow. Keys are not furnished except on order and at additional cost.

When one set screw is ordered, it is normally over the keyway. However, if the hub thickness remaining over the keyway is less than the diameter of a standard set screw it will be placed at 90°. When 2 set screws are ordered they are normally placed 1 over the key and 1 at 90°. If hub thickness over a standard depth keyway is less than the diameter of a standard set screw, they will be placed at 90° and 180° to the keyway. Set screws are furnished.

All alteration charges are for standard bore sizes in increments of 1/16" with standard tolerances. Non-standard bore, keyway or set screw sizes, tapered bores, splines, multiple keyways or specific location of keyways, pin holes or other variations from normal practice may be subject to extra charge.

**BORE AND KEYWAY TOLERANCES**

The standard tolerances listed below have proved satisfactory in use throughout the industry for many years and will be maintained on all standard commercial sprockets and gears. Should specific applications require closer tolerances, they can be supplied at reasonable extra cost. However, care should be taken not to specify tolerances which are less than the standard listed, when not actually required, in order to avoid unnecessary extra charges.

**BORE TOLERANCE**

Bores up to 2" Diameter .....	+ .002" - .000"
Over 2" to 3" Diameter .....	+ .003" - .000"
Over 3" to 4" Diameter .....	+ .004" - .000"
Bores over 4" Diameter .....	+ .005" - .000"

**KEYWAY TOLERANCE**

Width of Keyway - Straight or Tapered .....	+ .002" - .002"
Depth of Keyway - Straight .....	+ .010" - .000"
Depth of Keyway - Tapered .....	+ .000" - .010"