

INCH-POUND

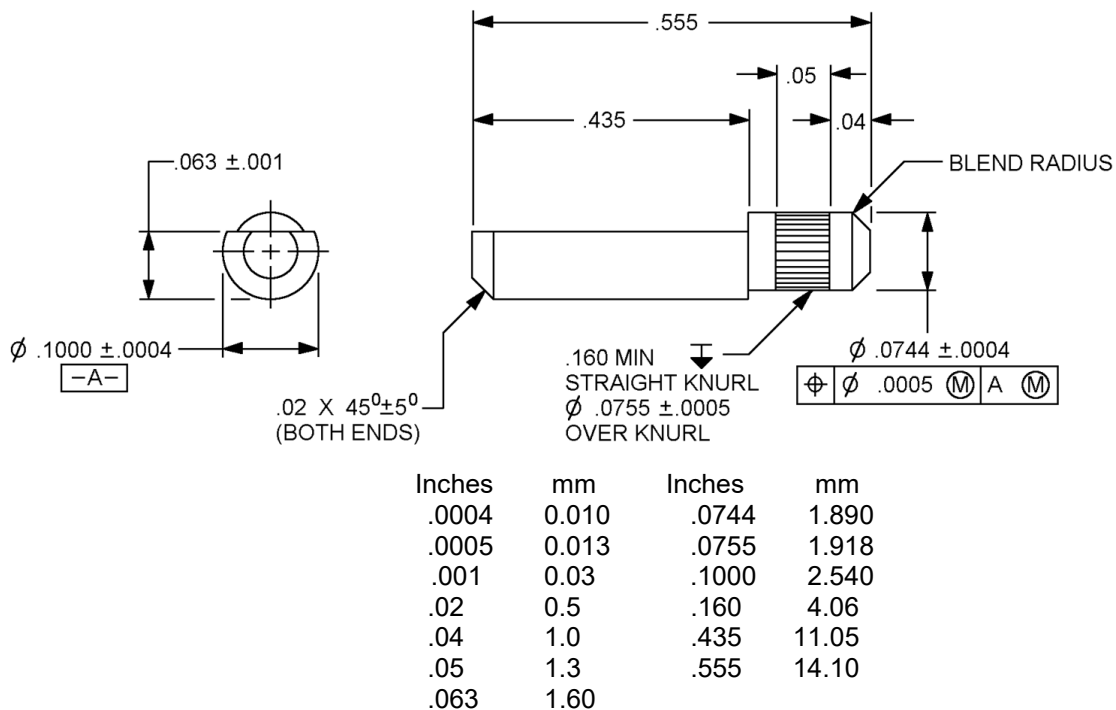
MIL-DTL-32234/9
w/AMENDMENT 1
14 May 2020
SUPERSEDING
MIL-DTL-32234/9
16 January 2007

DETAIL SPECIFICATION SHEET

CONNECTOR, ELECTRICAL, ULTRA HIGH DENSITY, MODULAR, KEYING PINS AND BUSHINGS

This specification is approved for use by all Departments and Agencies of the Department of Defense.

The requirements for acquiring the product described herein shall consist of this specification sheet and MIL-DTL-32234.



NOTES:

1. Dimensions are in inches.
2. Metric equivalents are given for information only.
3. Unless otherwise specified, tolerances for 2 place decimals are $\pm .01$ inch (0.3 mm), 3 place decimals are $\pm .005$ inch (0.13 mm); angular tolerance is $\pm 0^\circ 30'$.

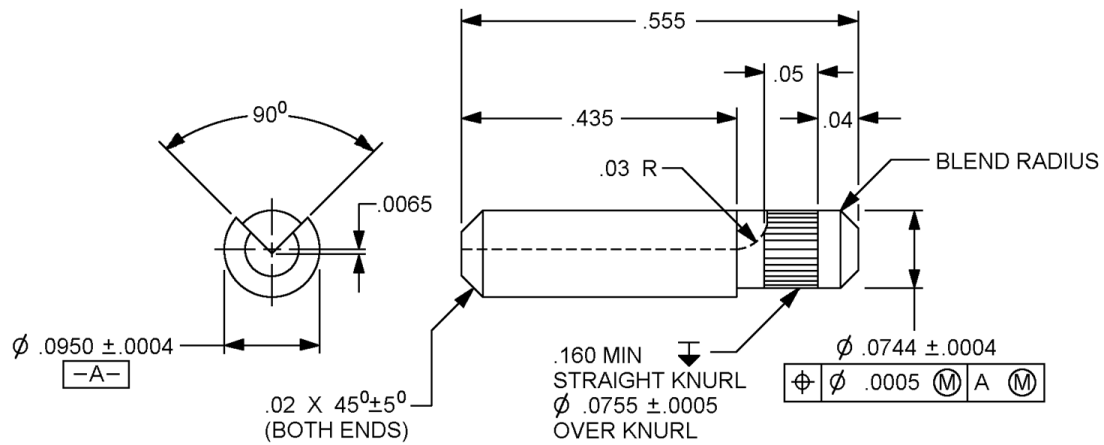
FIGURE 1. Polarizing key "D" pin.

AMSC N/A

FSC 5935



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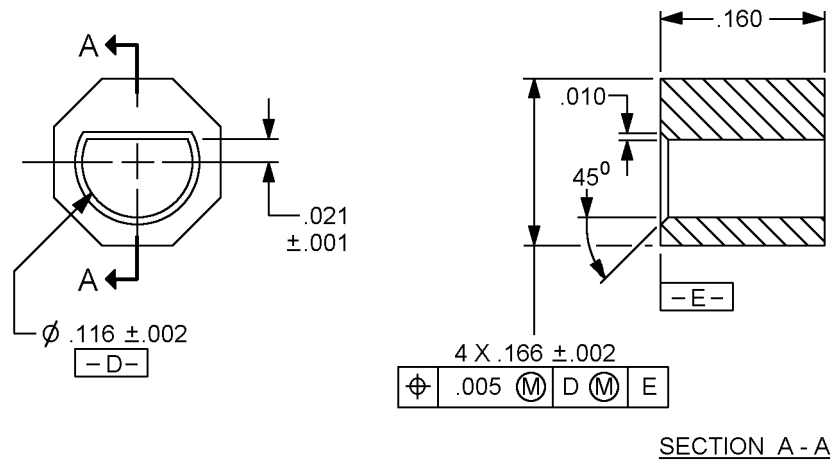
Inches	mm
.0004	0.010
.0005	0.013
.0055	0.140
.0065	0.165
.02	0.5
.03	0.8
.04	1.0
.05	1.3
.0744	1.890
.0755	1.918
.0950	2.413
.160	4.06
.435	11.05
.555	14.10

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FIGURE 2. Polarizing key "V" pin.

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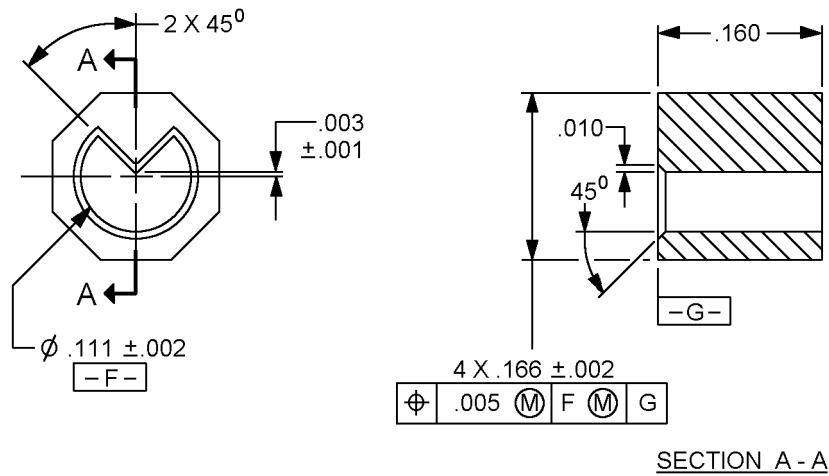
Inches	mm
.001	0.03
.002	0.05
.005	0.13
.010	0.25
.021	0.53
.116	2.95
.160	4.06
.166	4.22

NOTES:

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FIGURE 3. "D" keying bushing.

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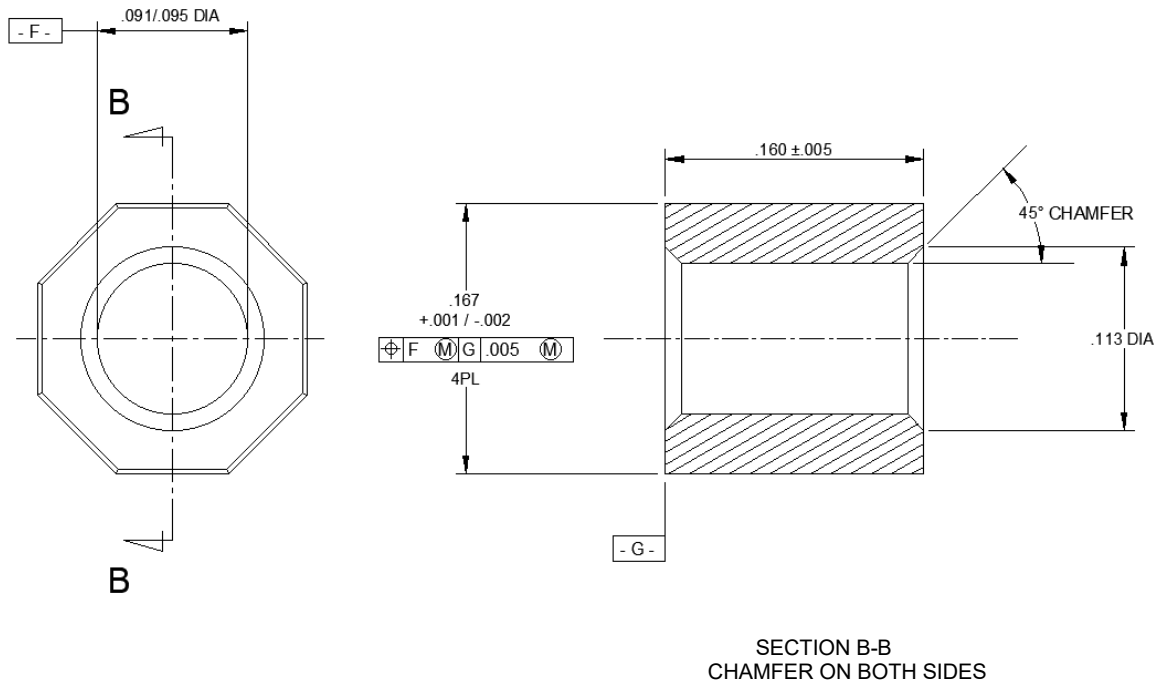
Inches	mm
.001	0.03
.002	0.05
.003	0.08
.005	0.13
.010	0.25
.111	2.82
.160	4.06
.166	4.22

NOTES:

1. Dimensions are in inches.
2. Metric equivalents are given for information only.
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FIGURE 4. "PIE" keying bushing.

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Inches	mm
.001	0.03
.002	0.05
.003	0.08
.005	0.13
.010	0.25
.111	2.82
.160	4.06
.166	4.22

NOTES:

1. Dimensions are in inches.
2. Metric equivalents are given for information only.
3. Unless otherwise specified, tolerances for 2 place decimals are ± 0.01 inch (0.3 mm), 3 place decimals are ± 0.005 inch (0.13 mm); angular tolerance is $\pm 0^\circ 30'$.

FIGURE 5. "O" polarizing keying bushing.

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REQUIREMENTS:

Dimensions and configurations: The design, construction, and physical dimensions shall be as specified on figures 1, 2, 3, 4, 5, and MIL-DTL-32234. In case of conflict between this drawing and MIL-DTL-32234, this drawing shall govern.

Interface: These keying pins and bushings are used with connectors specified in MIL-DTL-32234/1 through /8.

Part or Identifying Number (PIN) example:

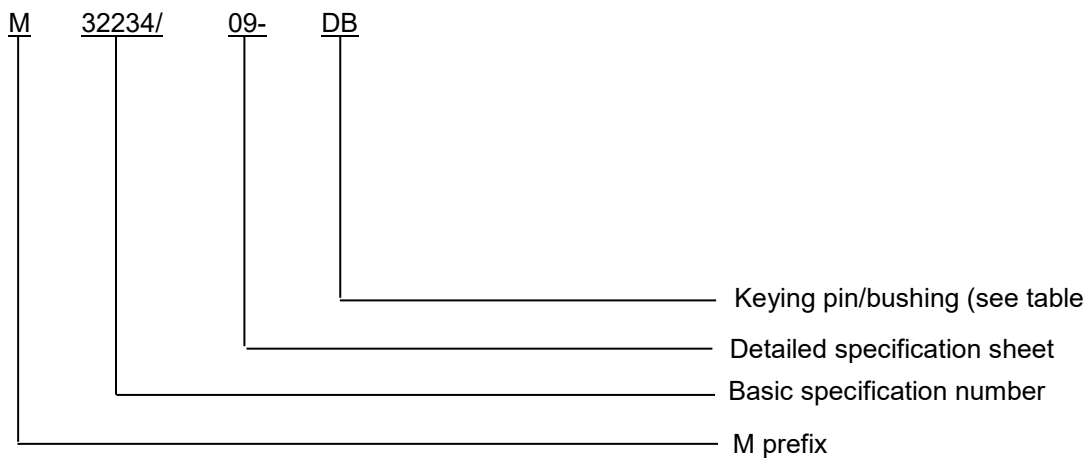


TABLE I. Type designation.

Designator	Key or bushing type
DK	"D" keying pin
PK	"PIE" keying pin
DB	"D" keying bushing
PB	"PIE" keying bushing
OB	"O" polarizing keying bushing

Material:

Keying pins shall be stainless steel 303Se (UNS designation 30323) condition A, in accordance with ASTM A582/A582M.

Keying bushings shall be sintered metal in accordance with Metal Powder Industries Federation (MPIF) SS-316 NI-25, or stainless steel in accordance with ASTM A582/A582M.

Finish: Keying pins and keying bushings shall be passivated in accordance with SAE-AMS2700.

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Amendment notations. The margins of this specification are marked with vertical lines to indicate modifications generated by this amendment. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations.

Referenced documents. In addition to MIL-DTL-32234, this document references the following:

MIL-DTL-32234/1	MIL-DTL-32234/6
MIL-DTL-32234/2	MIL-DTL-32234/7
MIL-DTL-32234/3	MIL-DTL-32234/8
MIL-DTL-32234/4	ASTM A582/A582M
MIL-DTL-32234/5	SAE-AMS2700

CONCLUDING MATERIAL

Custodians:

Army - CR
Navy - EC
Air Force - 85
DLA - CC

Preparing activity:
DLA - CC

(Project 5935-2020-059)

NOTE: The activities listed above were interested in this document as of the date of this document. Since organizations and responsibilities can change, you should verify the currency of the information above using the ASSIST Online database at <https://assist.dla.mil>.