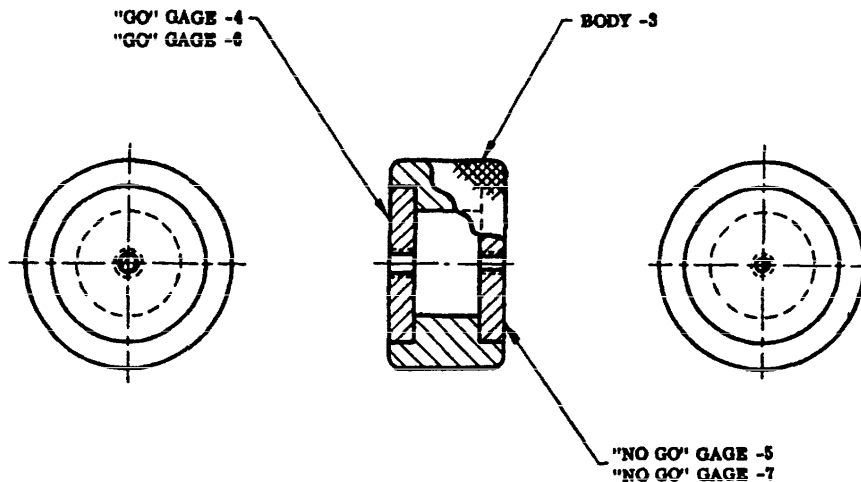


USER SYMBOLS:
ARMY - AV
NAVY - AS, CG, MC
AF - 17

REVIEWER SYMBOLS:
ARMY - MU, EL, MI
NAVY - AS, SE
AF - 11, 08

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This military standard is approved by the Department of Defense
and is mandatory for use by all Departments & Agencies of the
Department of Defense. Selection for all new engineering and
design applications and for repetitive use shall be made
from this document.



DASH NO.	"GO" GAGE	"NO GO" GAGE
-1	-4	-5
-2	-6	-7

NOTES:

- MATERIAL: (A) BODY -3; STEEL, QQ-S-637, COMP B1112, CONDITION CDSR.
(B) "GO" RING GAGE -4, -6 AND "NO GO" RING GAGE -5 AND -7; STEEL, HIGH SPEED, QQ-T-599.
- SURFACE ROUGHNESS: (A) BODY; $125/\sqrt{\text{ALL OVER}}$, PRIOR TO KNURLING.
(B) "GO" RING GAGE -4, -6 AND "NO GO" RING GAGE -5 AND -7, $16/\sqrt{\text{ALL OVER}}$. FINISH IN ACCORDANCE WITH ASA B46.1.
- HEAT TREATMENT: "GO" RING GAGE -4, -6 AND "NO GO" RING GAGE -5 AND -7; OIL HARDEN TO ROCKWELL C60 -63.
- REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
- THE MARKING ON GAGE -4, -5, -6 AND -7 SHALL INCLUDE THE MS PART NO. AND LATEST REVISION LETTER, THE WORDS "GO" OR "NO GO" AS APPLICABLE, THE NO. OF TEETH, THE DIAMETRAL PITCH AND THE PRESSURE ANGLE.
- DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED TOLERANCES; DECIMALS $\pm .005$ ANGLES, $\pm 1^\circ$. INTERPRET DIMENSIONING AND TOLERANCING IN ACCORDANCE WITH MIL-STD-8.

FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.

REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.

P.A. NAVY - AS Other Cast ARMY - MU NAVY - AS AF - 11	TITLE GAGE, RING, SPLINE (GO-NO GO)	MILITARY STANDARD MS90406
PROCUREMENT SPECIFICATION	SUPERSEDES: BUORD SA-2412603 AND SA-2412604	SHEET 1 OF 2

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE. W73

PLATE NO. 15320

APPROVED 6 JUNE 1967 REVISED

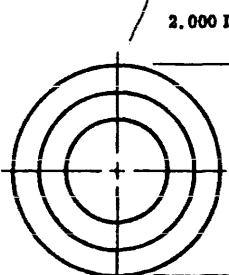
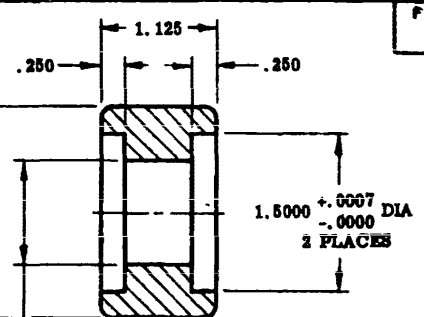
USER SYMBOLS:
ARMY - AV
NAVY - AS, CG, MC
AF - 17

REVIEWER SYMBOLS:
ARMY - MU, EL, MI
NAVY - AS, SH
AF - 11, 85

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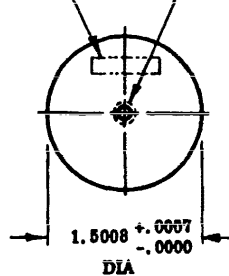
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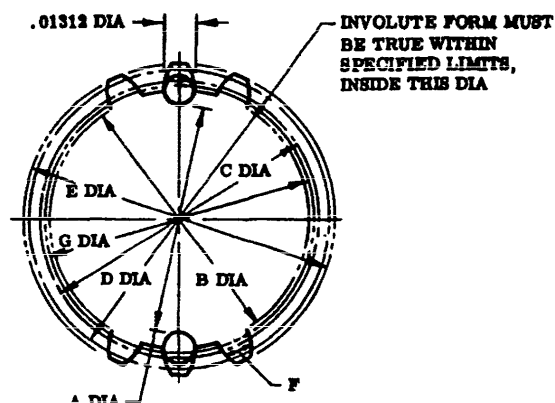



BODY -3

IDENTIFICATION AND MARKING
(SEE NOTE 5)



SEE ENLARGED SPLINE
VIEW AND TABLE I.



ENLARGED SPLINE VIEW

"GO" RING GAGE -4 AND -6
"NO GO" RING GAGE -5 AND -7

TABLE I - SPLINE DATA

DATA	DASH NO.			
	-4	-5	-6	-7
GAGE TYPE	"GO"	"NO GO"	"GO"	"NO GO"
TOOTH FORM (a)	FULL DEPTH TRUE INVOLUTE	FULL DEPTH TRUE INVOLUTE	FULL DEPTH TRUE INVOLUTE	FULL DEPTH TRUE INVOLUTE
PRESSURE ANGLE	20°	20°	20°	20°
NO. OF TEETH	21	21	13	13
DIAMETRAL PITCH	120	120	120	120
A DIA (REF)	.1589 +.0000 -.0001	.1581 +.0001 -.0000	.0918 +.0000 -.0001	.0909 +.0001 -.0000
B -.0000 (INSIDE DIA)	.1644	.1644	.1018	.1018
C (PITCH DIA) (REF)	.175	.175	.1083	.1083
D (TRUE INVOLUTE FORM DIA)	.1872	.1872	.1247	.1247
E (MIN ROOT DIA)	.189	.189	.126	.126
F (CIRCULAR SPACE WIDTH) (REF)	.01309	.01286	.01309	.01285
G (BASE CIRCLE DIA)				

(a) ALLOWABLE ERRORS: SPACING ±.0002, INVOLUTE PROFILE ±.0002.

P.A. NAVY - AS

Other Cust
ARMY - MU
NAVY - AS
AF - 11

PROCUREMENT SPECIFICATION

TITLE

GAGE, RING, SPLINE (GO-NO GO)

SUPERSEDES:

BUORD SA-2412503 AND SA-2412504

MILITARY STANDARD

MS90406

SHEET 2

APPROVED 6 JUNE 1967 REVISED