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Technical Resources

**ANSI/AGMA 9002-C14**  
(Revision of ANSI/AGMA 9002-B04)

## American National Standard

# Bores and Keyways for Flexible Couplings (Inch Series)

ANSI/AGMA 9002-C14

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**American  
National  
Standard*****Bores and Keyways for Flexible Couplings (Inch Series)***

ANSI/AGMA 9002-C14

[Revision of ANSI/AGMA 9002-B04]

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Approved February 4, 2015.

**ABSTRACT**

This standard describes sizes and tolerances for straight and tapered bores and the associated keys and keyways, as furnished in flexible couplings. The data in the standard considers commercially standard coupling bores and keyways, not special coupling bores and keyways that may require special tolerances.

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**Contents**

Foreword .....	v
1 Scope .....	1
1.1 Application .....	1
1.2 Exceptions .....	1
2 Normative references .....	1
3 Symbols and definitions .....	1
3.1 Symbols .....	1
4 Bore measurement and surface finish .....	2
4.1 Bore measurement .....	2
4.2 Bore surface finish .....	2
5 Straight (finished) bored hubs .....	2
5.1 Standard bores .....	2
5.1.1 Standard shaft-to-hub fits .....	2
5.1.2 Unspecified hub-to-shaft fits .....	4
5.2 Non-standard bores .....	4
5.3 Set screws .....	4
6 Tapered bore hubs .....	5
6.1 Typical tapered bores .....	5
6.2 Keyways .....	5
6.3 Tapered bore dimensional control requirements .....	5
6.4 Dimensioning of tapered bores .....	5
7 Keys .....	6
7.1 Key sizes .....	6
7.1.1 Commercial .....	6
7.1.2 Precision .....	6
7.1.3 Fitted .....	6
8 Hub keyways .....	6
8.1 Classes of key-to-keyway fit .....	6
8.1.1 Commercial class .....	7
8.1.2 Precision class .....	7
8.1.3 Fitted class .....	7
8.2 Keyway sizes .....	7
8.3 Keyway dimensions and tolerances .....	7
8.3.1 Keyway width for square, rectangular and tapered keys, $w_{kw}$ .....	7
8.3.2 Chord height, $C_h$ .....	8
8.3.3 Nominal keyway depth, $h_{kw}$ .....	8
8.3.4 Dimension from top of keyway to opposite side of bore, $T$ .....	8
8.3.5 Maximum keyway offset tolerance, $N$ .....	8
8.3.6 Maximum keyway lead, $L_{kw}$ .....	9
8.3.7 Keyway parallelism .....	9
8.3.8 Multiple keyway index tolerance, $I_{kw}$ .....	9
8.4 Methods of measurement .....	10
8.5 Finish of keyways .....	10
8.6 Fillet radii in keyways .....	10
Bibliography .....	28

**Annexes**

Annex A Straight bore inspection methods .....	12
Annex B Tapered bore inspection procedure and plug gauge accuracy requirements.....	13
Annex C Recommended design practice for tapered shafts used with flexible couplings .....	16
Annex D Keyway measurement.....	18
Annex E Coupling hub bores required to obtain ANSI B4.1, <i>Preferred limits and fits for cylindrical parts</i> , FN2 class interference fits with ANSI/AGMA 9002-C14 recommended shaft tolerances .....	24
Annex F Class 2 clearance fit .....	26
Annex G Transitional fits .....	27

**Tables**

Table 1 - Symbols .....	2
Table 2 - Hub bore to shaft fits for cylindrical shaft in straight bore hub (inches).....	3
Table 3 - Standard tolerances of finished straight bores over 18 inch diameter for interference fit .....	4
Table 4 - Key size and tolerance, inch.....	6
Table 5 - Recommended hub keyway, inch.....	7
Table 6 - Maximum keyway lead values .....	9
Table 7 - Multiple keyway index tolerances .....	10
Table 8 - Values for keyway fillet radius and suggested key chamfer .....	11

**Figures**

Figure 1 - Tapered bore requirements .....	5
Figure 2 - Tapered bore drawing dimensions .....	5
Figure 3 - Keyway dimensions .....	8
Figure 4 - Keyway offset .....	9
Figure 5 - Keyway lead .....	9
Figure 6 - Keyway parallelism .....	10
Figure 7 - Multiple keyway index.....	10
Figure 8 - Keyway fillet radius and key chamfer detail .....	11

## Foreword

[The foreword, footnotes and annexes, if any, in this document are provided for informational purposes only and are not to be construed as a part of ANSI/AGMA 9002-C14, *Cylindrical Bores and Keyways for Flexible Couplings (Inch Series)*.]

ANSI/AGMA 9002-A86 consolidated and superseded the information found in AGMA 511.02, *Bore and Keyway Sizes for Flexible Couplings*, AGMA 512.03, *Keyways for Flexible Couplings*, and AGMA 513.01, *Taper Bores for Flexible Couplings*.

The intent of ANSI/AGMA 9002-A86 was to offer designers and users standard dimensions and tolerances for inch bores, keys and keyways for flexible couplings. In general, the dimensions contained in ANSI/AGMA 9002-A86 represented the dimensions and tolerances used within the industry for pre-engineered couplings. It proved useful in establishing dimensions and tolerances for custom engineered coupling products.

ANSI/AGMA 9002-A86 was developed after intensive study of previously existing standards, literature, design practices and manufacturing procedures for bores and keyways of unmounted flexible coupling hubs and similar components. The study revealed that much of the data contained in previously existing standards and specifications was predicated upon practice and procedures that pertained more to keyways in the shaft members than to keyways in coupling hub bores. The information contained with ANSI/AGMA 9002-A86 did not necessarily agree with some commonly used specifications. ANSI/AGMA 9002-A86 was based upon the design criteria related to bores and keyways in coupling hubs that had evolved over many years of successful industry practice.

ANSI/AGMA 9002-A86 presented pertinent data on dimensions, tolerances, and sizes for straight bores, tapered bores, keys and keyways for unmounted industrial flexible couplings. Decimal equivalents of fractions were shown to a maximum of four decimal places and were not meant to imply tolerances. Inspection methods for tapered bores and keyways were included in the appendices. The appendices also included the recommended design practice for tapered shafts for use with flexible couplings.

ANSI/AGMA 9002-B04 supersedes the information from ANSI/AGMA 9002-A86, *Bores and Keyways for Flexible Couplings (Inch Series)*.

This revised version of the standard includes an extension of the bore sizes (through 18 inches). It has also been rearranged and clarified to make it easier to use. One annex was broken into two annexes to clarify the information presented. Two new annexes were added: "Straight bore inspection methods" and "Coupling hub bores required to obtain ANSI B4.1 "Preferred Limits and Fits for Cylindrical Parts" FN2 class interference fits with AGMA 9002-B04 recommended shaft tolerances".

In ANSI/AGMA 9002-C14, the "measurement of bores" section was moved from an annex to clause 4, now becoming a part of the standard. Bores are to be measured prior to cutting the keyway. A discussion and a new annex G is now included covering transitional fits bridging the gap between clearance and interference fits.

The first draft of ANSI/AGMA 9002-C14 was made in April, 2011. It was approved by the AGMA membership in May 2014. It was approved as an American National Standard on February 4, 2015.

Suggestions for improvement of this standard will be welcome. They may be submitted to [tech@agma.org](mailto:tech@agma.org).