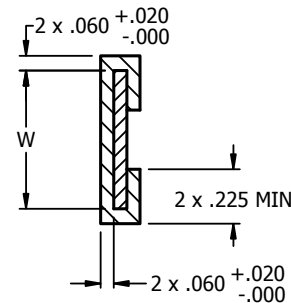
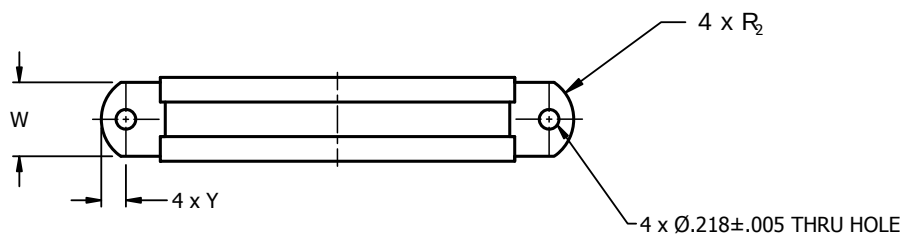


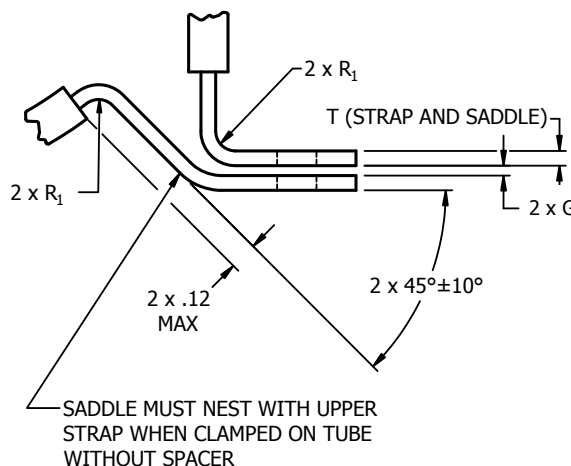
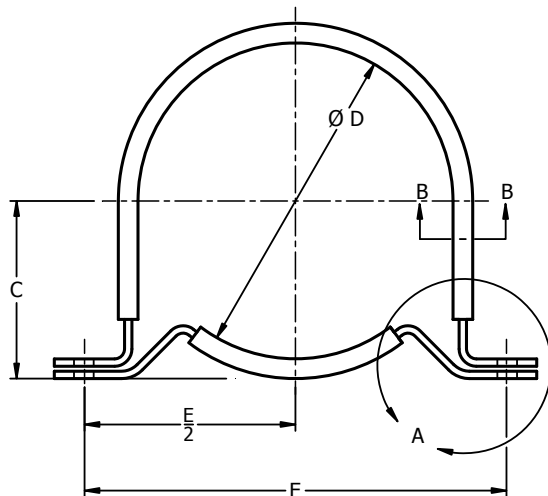
THE COMPLETE REQUIREMENTS FOR ACQUIRING THE CLAMPS DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE LATEST ISSUE OF NASM85449.

FED. SUPPLY CLASS

5340



SECTION B-B



② COMPLETELY REVISED

DETAIL A

TABLE I – CLAMP DIMENSIONS

DASH NUMBER	TUBE SIZE	C ±.020	Ø D /5/	E ±.015 /5/	G ±.001 /7/	R ₁	R ₂	T /6/	W +.015 - .000	Y	WEIGHT POUNDS MAX
10	5/8	.493	.625	1.525	.020	.090	.37	.040	.500	.218	.0443
12	3/4	.555	.750	1.650							.0490
14	7/8	.618	.875	1.775							.0537
16	1	.690	1.000	1.958	.030	.109		.050	.625	.250	.0856
18	1 1/8	.753	1.125	2.083							.0923
20	1 1/4	.815	1.250	2.208							.0989
24	1 1/2	.940	1.500	2.458							.1120
28	1 3/4	1.065	1.750	2.708							.1252
32	2	1.203	2.000	3.016							.1961
36	2 1/4	1.328	2.250	3.266		.125		.063	.750		.2143
40	2 1/2	1.453	2.500	3.516							.2324
44	2 3/4	1.578	2.750	3.766							.2505
48	3	1.703	3.000	4.016							.2687

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MIL-C-85449/3B PART NUMBERS REMAIN M85449/3.



CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

2

PROCUREMENT
SPECIFICATION

NASM85449

TITLE

**CLAMP ASSEMBLY, SADDLE-TYPE, CUSHIONED, SILICONE
RUBBER, FABRIC REINFORCED, 321 CRES, 500 °F,
GENERAL PURPOSE**

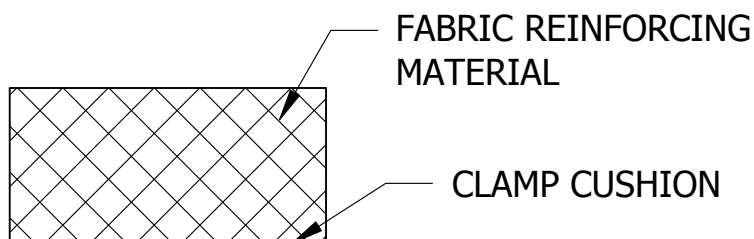
CLASSIFICATION
PART STANDARD

NASM85449/3
SHEET 1 OF 4

MATERIALS:

STRAP AND SADDLE - 321 CRES SHEET (UNS S32100) PER AMS5510, EXCEPT THAT A TENSILE STRENGTH OF 100-120 KSI SHALL BE REQUIRED. STRIP TO HAVE EDGES ROLLED TO A RADIUS OF T/4.

CUSHION – FABRIC REINFORCED SILICONE RUBBER, 65-75 DUROMETER, COLOR-LIGHT BLUE, PER THE GENERAL SPECIFICATION PLUS THE REQUIREMENTS LISTED IN TABLE II. THE FABRIC REINFORCING MATERIAL SHALL BE MOLDED INTO THE BAND SIDE OF THE CLAMP CUSHION AT A 45° ANGLE (SEE FIGURE BELOW:



1. PHYSICAL PROPERTIES - AS SPECIFIED IN TABLE II BELOW. UNLESS OTHERWISE SPECIFIED, RESULTS ARE AN AVERAGE OF 5 SPECIMENS AND TOLERANCE OF TEMPERATURE IS $\pm 5^\circ\text{F}$.

TABLE II – CUSHION MATERIAL PHYSICAL PROPERTIES

TEST	TEST METHOD	REQUIRED ORIGINAL PROPERTIES	ALLOWABLE CHANGE FROM ACTUAL ORIGINAL PROPERTIES AFTER:		
			HEATING AGING 70 HOURS AT +500 °F	OIL IMMERSION IN MIL-PRF-7808 70 HRS AT +302 °F	DIP TEST IN MIL-PRF-680 SOLVENT /14/
HARDNESS, DUROMETER "A"	ASTM D2240	65 – 75	+10 PTS MAX	-30 PTS MAX	+5 PTS
TENSILE STRENGTH - PSI	ASTM D412/15/	1200 MIN	1000 MIN	300 MIN	300 MIN
ELONGATION - %	ASTM D412/15/	30 MIN	30 MIN	30 MIN	30 MIN
TEAR STRENGTH - PPI	ASTM D624 DIE "B"	300 MIN	300 MIN	300 MIN	300 MIN
VOLUME CHANGE - %	ASTM D471	-----	-----	+45% MAX	$\pm 5\%$ MAX
WEIGHT CHANGE - %	ASTM D471	REPORT	-5% MAX	-----	-----
SPECIFIC GRAVITY	ASTM D471	REPORT	-----	-----	-----

2. COMPRESSION SET: SEE NASM85449
AIR AGE AT 302 °F. NOT TO EXCEED 30%. AVERAGE OF 3 SPECIMENS.
3. FLAMMABILITY: SEE NASM85449
SPECIMENS: "-16" SIZE CLAMP ASSEMBLIES UNBENT UNTIL STRAIGHT.
VERTICAL BURN TEST.

FINISH:

STRAP AND SADDLE - BALL BURNISH TO ROUND EDGES TO A .010 RADIUS, AND PASSIVATED PER AMS2700, METHOD 1, CLASS 4.

CODE:

PART NUMBERS SHALL CONSIST OF THE FOLLOWING: (IN SEQUENCE)
THE LETTER "M"
THE BASIC SPECIFICATION NUMBER
A SLASH AND SLASH NUMBER OF THIS SPECIFICATION SHEET
A DASH AND THE APPROPRIATE SIZE DASH NUMBERS FROM TABLE I.

② COMPLETELY REVISED

REVISION
2
NASM85449-3
SHEET 2