

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

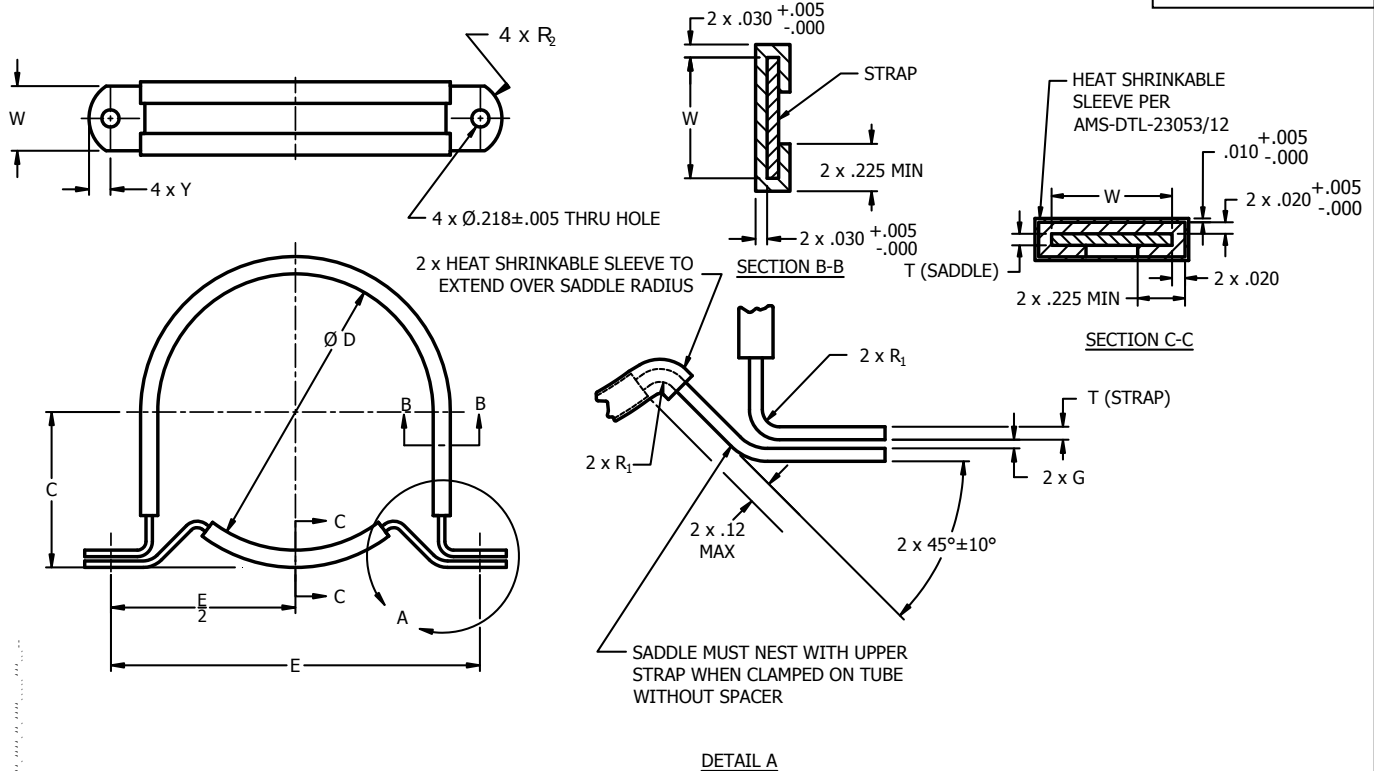


TABLE I – CLAMP DIMENSIONS

DASH NUMBER	TUBE SIZE	C ±.020	Ø D /5/	E /5/	G ±.001 /7/	R ₁	R ₂	T /6/	W +.015 -.000	Y	WEIGHT POUNDS MAX
10	5/8	.433	.625	1.525	.020	.090	.375	.040	.500	.218	
12	3/4	.495	.750	1.650							
14	7/8	.558	.875	1.775							
16	1	.640	1.000	1.958	.030	.109		.050	.625	.250	
18	1 1/8	.703	1.125	2.083							
20	1 1/4	.765	1.250	2.208							
24	1 1/2	.890	1.500	2.458							
28	1 3/4	1.015	1.750	2.708							
32	2	1.153	2.000	3.016		.125	.500	.063	.750		
36	2 1/4	1.278	2.250	3.266							
40	2 1/2	1.403	2.500	3.516							
44	2 3/4	1.528	2.750	3.766							
48	3	1.653	3.000	4.016							

② COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MIL-C-85449/4A PART NUMBERS REMAIN M85449/4.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION NASM85449	TITLE CLAMP ASSEMBLY, SADDLE-TYPE, CUSHIONED, PTFE, 321 CRES, -320 °F TO 450 °F, GENERAL PURPOSE	CLASSIFICATION PART STANDARD NASM85449/4

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 - STRAP AND SADDLE, TEFLON SHEET STRIP PER ASTM D 4894, TYPE I, EXTRUDED AND HEAT FORMED TO SHAPE, COLOR-WHITE. SADDLE COVERED WITH HEAT-SHRINKABLE SLEEVE PER AMS-DTL-23053/12 (SEE SECTION C-C).

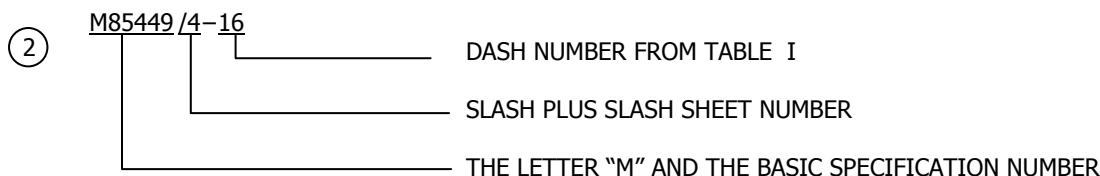
FINISH:

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

PART NUMBER EXAMPLE:



NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (2) METAL PARTS SHALL BE FREE OF BURRS, SHARP EDGES, TOOL MARKS, AND DIE MARKS.
- (3) WITH CLAMP ASSEMBLED ON TUBE, NO GAP IS PERMITTED BETWEEN CUSHION AND TUBE FOR UPPER HALF OF STRAP AND CUSHIONED LENGTH OF SADDLE.
- (4) WITH CUSHION PUSHED TO EITHER END OF STRAP, SUFFICIENT CUSHION SHALL BE AVAILABLE TO PREVENT STRAP CONTACTING TUBE.
- /5/ THE "ØD" & "E" DIMENSIONS WILL BE MEASURED WITH MANDREL CLAMPED AND A "G" THICKNESS SPACER BETWEEN THE CLAMP FEET.
- /6/ TOLERANCES PER AMS2242.
- /7/ "G" DIMENSION IS FOR THICKNESS OF SHIM REQUIRED TO INSPECT ASSEMBLED CLAMP.
- (8) IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS SPECIFICATION SHEET AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS SPECIFICATION SHEET SHALL TAKE PRECEDENCE.

REVISION

2

NAS85449/4
SHEET 2

(2) COMPLETELY REVISED