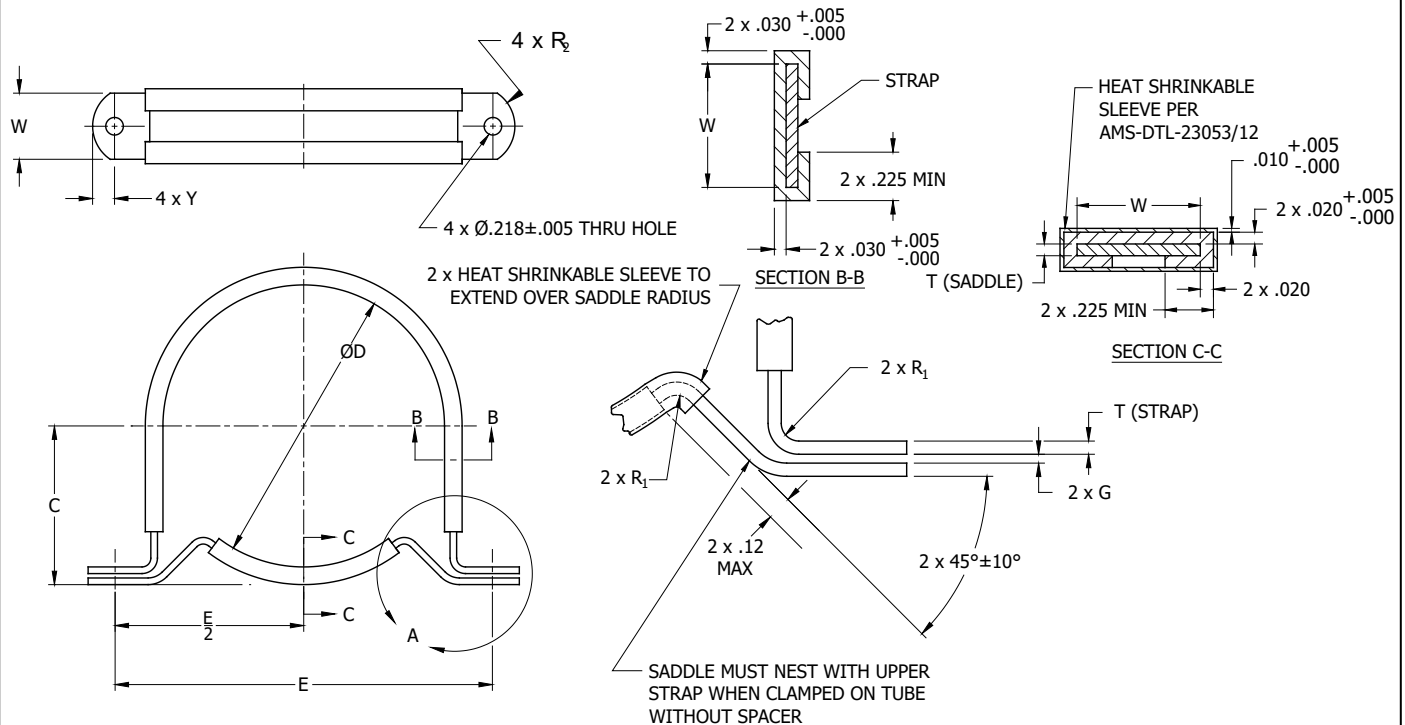


THE COMPLETE REQUIREMENTS FOR ACQUIRING THE CLAMPS DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE LATEST ISSUE OF NASM85449.

FED. SUPPLY CLASS

5340



DETAIL A

TABLE I – CLAMP DIMENSIONS

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

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 3
PROCUREMENT SPECIFICATION NASM85449	TITLE CLAMP ASSEMBLY, SADDLE-TYPE, CUSHIONED, PTFE, 321 CRES, -320 °F TO 450 °F, GENERAL PURPOSE		CLASSIFICATION PART STANDARD NASM85449/4 SHEET 1 OF 3

USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD IS ENTIRELY VOLUNTARY. AIA DOES NOT QUALIFY SUPPLIERS OR CERTIFY CONFORMANCE OF ITEMS PRODUCED UNDER NATIONAL AEROSPACE STANDARDS. AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF ITEMS FOR ANY PARTICULAR APPLICATION OR (2) THE EXISTENCE OF OR APPLICABILITY THERETO OF PATENT OR TRADEMARKS RIGHTS.

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 D4894, 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:

M85449 /4-16

_____ DASH NUMBER FROM TABLE I

_____ SLASH PLUS SLASH SHEET NUMBER

_____ THE LETTER "M" AND THE BASIC SPECIFICATION NUMBER

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 AND SADDLE CUSHION SHALL CONTACT BOTH ENDS OF SADDLE AT RADIUS "R₁".
- /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

3

NASM85449/4
SHEET 2