

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

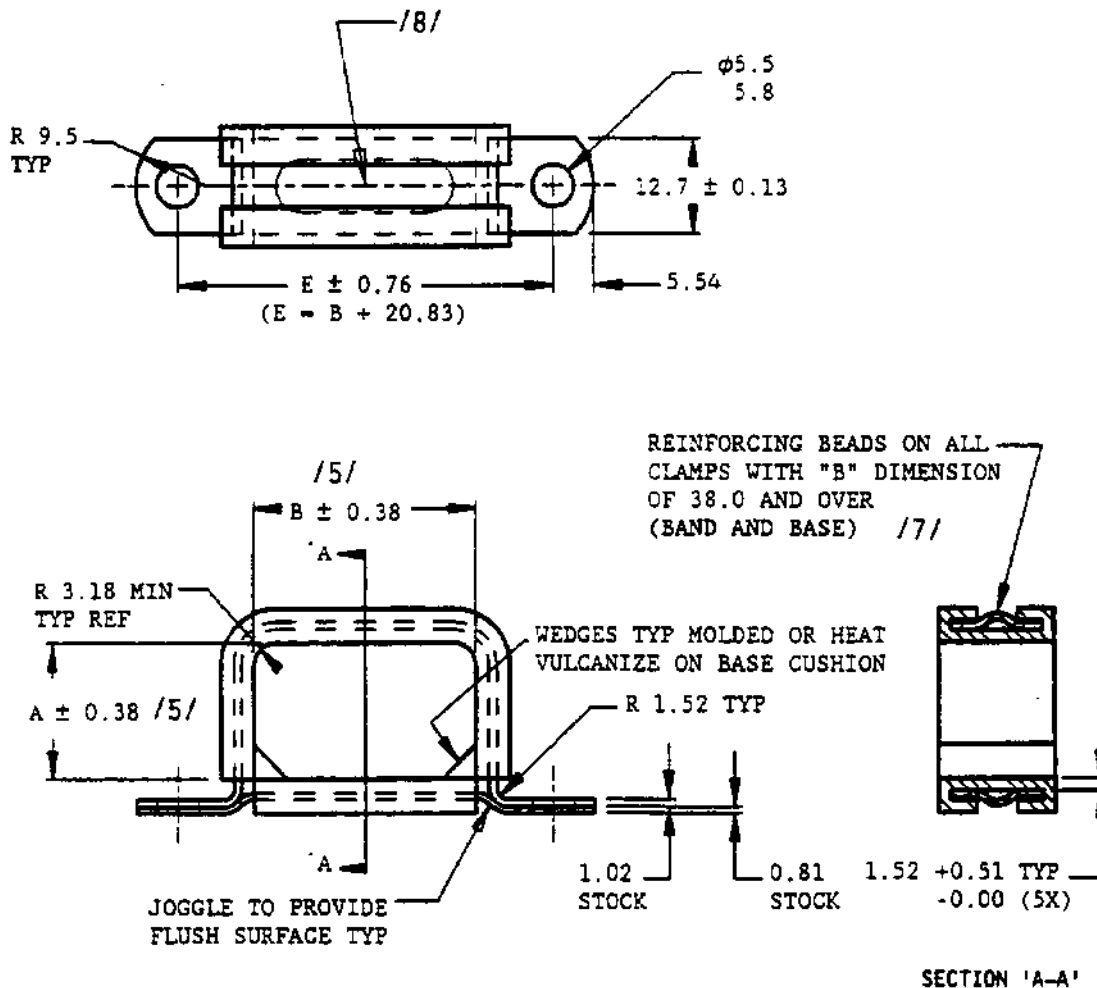
SAE reviews each technical report at least every five years at which time it may be revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

MA2154/2

FEDERAL SUPPLY CLASS
5340

RATIONALE

MA2154/2 HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

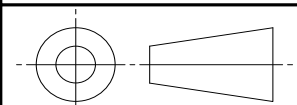


NOTE: GEOMETRIC DIMENSIONING AND TOLERANCING ARE SUBJECT TO INTERPRETATION OF ANSI 14.5M-1982.

FIGURE 1

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/MA2154/2>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3E

PROCUREMENT SPECIFICATION: MA2151



AEROSPACE STANDARD

CLAMP, RECTANGULAR, 2 PIECE, CUSHIONED, WITH WEDGES, PHOSPHATE ESTER FLUID RESISTANT, METRIC

MA2154/2
SHEET 1 OF 3

Documents

Copyright 2015 SAE International

All rights reserved. No part of this publication may be reproduced, stored in a retrieval system or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording, or otherwise, without the prior written permission of SAE.

TO PLACE A DOCUMENT ORDER: Tel: 877-606-7323 (inside USA and Canada)
Fax: 724-776-0790

Tel: +1 724-776-4970 (outside USA)
Email: CustomerService@sae.org

SAE WEB ADDRESS: <http://www.sae.org>

GENERAL NOTES:

1. MATERIALS: BAND AND BASE - 321 CORROSION RESISTANT STEEL, ANNEALED, PER AMS-5510

CUSHION - ETHYLENE PROPYLENE RUBBER, 65-75 DUROMETER, COLOR PURPLE, PER MA2151 WITH ADDITIONAL REQUIREMENTS SHOWN BELOW

CUSHION REQUIREMENTS: 1. PHYSICAL PROPERTIES - AS SPECIFIED IN TABLE 1. UNLESS OTHERWISE SPECIFIED RESULTS ARE AN AVERAGE OF 5 SPECIMENS AND TOLERANCE ON TEMPERATURE IS ($\pm 2.8^{\circ}\text{C}$). UNLESS OTHERWISE SPECIFIED PROPERTY MEASUREMENTS SHALL BE PERFORMED IMMEDIATELY AFTER REMOVAL FROM THE IMMERSION BATHS.

2. COMPRESSION SET - SEE MA2151
- AIR AGE AT 100°C
- NOT TO EXCEED 30% AVERAGE OF 3 SPECIMENS

3. FLAMMABILITY - SEE MA2151
- SPECIMENS - STANDARD ASTM TEST SLABS
- HORIZONTAL BURN TEST

2. HEAT TREATMENT: NONE

3. BAND AND BASE HARDNESS: 90 HRB

4. FINISH: BAND AND BASE - PASSIVATE PER QQ-P-35

CUSHION - NONE

- /5/ STANDARD SIZE LIMITATIONS: A DIMENSION -06 (6 mm) MINIMUM, -25 (25 mm) MAXIMUM
B DIMENSION -13 (13 mm) MINIMUM, -51 (51 mm) MAXIMUM

(MINIMUM 'A' AND 'B' DIMENSIONS CAN BE REVERSED)

6. PROCUREMENT SPECIFICATION: MA2151 (EXCEPT VIBRATION TEST)

- /7/ REINFORCING BEAD REQUIRED ON ALL CLAMPS WITH 'B' DIMENSION OF 38 and OVER. ALL RADII ON THE STIFFENING BEAD SHALL BE SMOOTH AND BLENDED. NO SHARP TOOL MARKS ARE ALLOWED.

- /8/ IDENTIFICATION: MARK THE COMPLETE STANDARD PART NUMBER AND MANUFACTURER'S NAME, TRADEMARK OR CAGE NUMBER ON THE BAND ABOVE THE THEORETICAL CENTERLINE IN AN AREA NOT COVERED BY CUSHION PER AS478 (2A1)

9. SURFACE TEXTURE (SEE MA2151)

10. METAL BANDS SHALL HAVE ALL BURRS AND SHARP EDGES REMOVED

11. DIMENSIONS IN MILLIMETERS. UNLESS OTHERWISE SPECIFIED TOLERANCES: LINEAR DIMENSIONS
 $X.XX \pm 0.25$, $X.X \pm 0.76$, ANGLES ± 0.035 RADIANS

	AEROSPACE STANDARD	MA2154/2 SHEET 2 OF 3	 Documents
	CLAMP, RECTANGULAR, 2 PIECE, CUSHIONED, WITH WEDGES, PHOSPHATE ESTER FLUID RESISTANT, METRIC		

