

RATIONALE

FEDERAL SUPPLY CLASS
5340

AS85449/1 HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

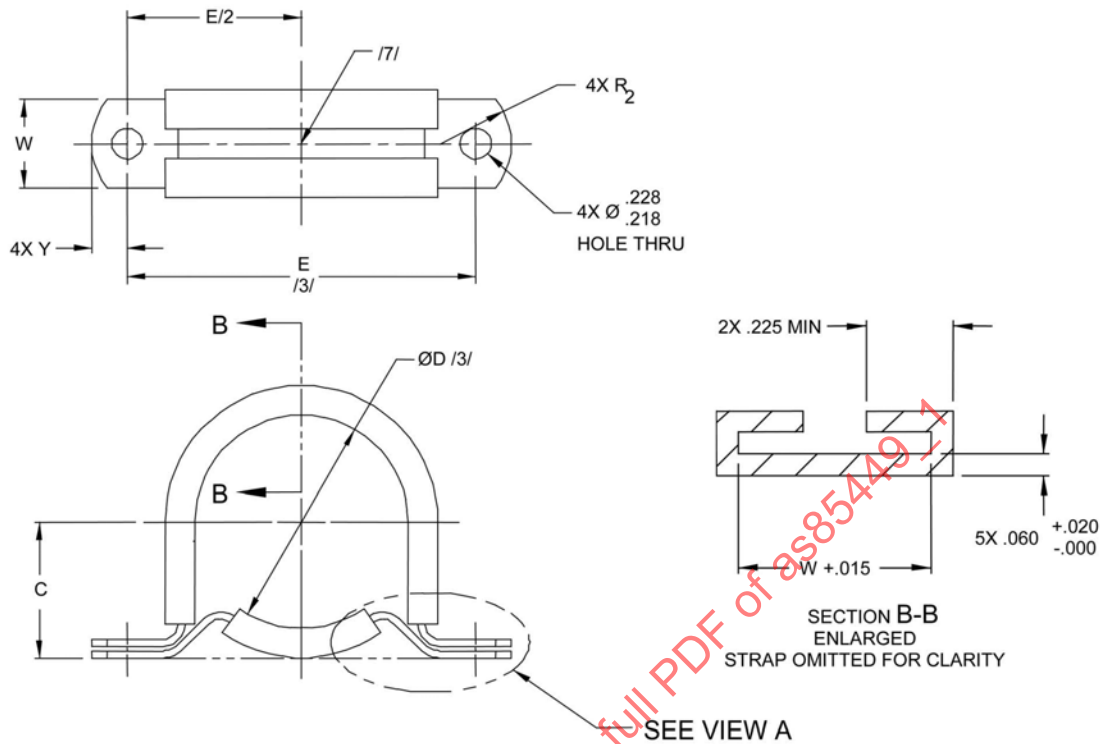
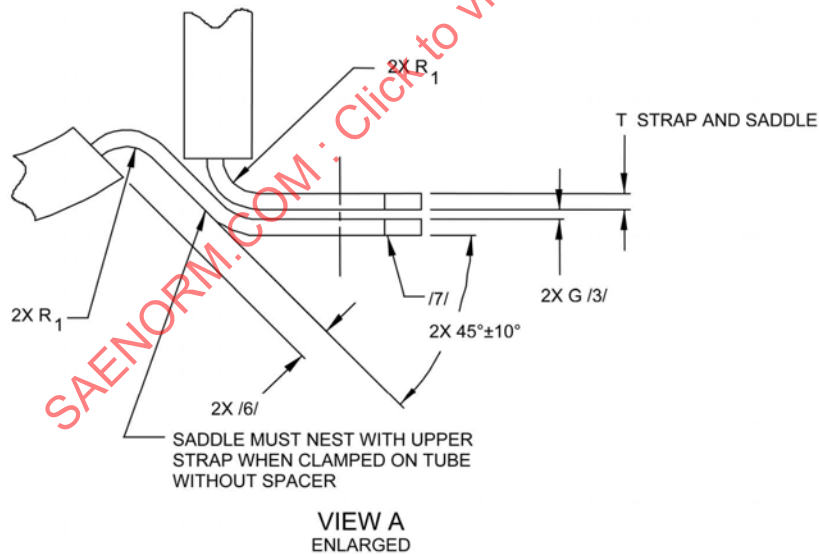
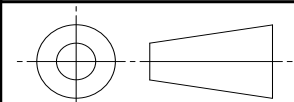


FIGURE 1 CLAMP



SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS85449/1>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3E

PROCUREMENT SPECIFICATION: AS85449 /4/

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

CLAMP ASSEMBLY, SADDLE TYPE,
CUSHIONED, FUEL AND PETROLEUM
BASED HYDRAULIC FLUID

SAE AS85449/1
SHEET 1 OF 3

TABLE 1 - CLAMP DIMENSIONS

BASIC NO. AS85449/1	TUBE	C	D	E	G	R ₁	R ₂	T	W	Y
SIZE CODE /11/	SIZE	± .030		± .015	± .001		± .03	TOLERANCE PER AMS 2242	± .005	
-10	.625	.493	.625	1.525	.020	.090	.37	.040	.500	.218
-12	.750	.555	.750	1.650	.020	.090	.37	.040	.500	.218
-14	.875	.618	.875	1.775	.020	.090	.37	.040	.500	.218
-16	1.000	.690	1.000	1.958	.030	.109	.50	.050	.625	.250
-18	1.125	.753	1.125	2.083	.030	.109	.50	.050	.625	.250
-20	1.250	.815	1.250	2.208	.030	.109	.50	.050	.625	.250
-24	1.500	.940	1.500	2.458	.030	.109	.50	.050	.625	.250
-28	1.750	1.065	1.750	2.708	.030	.109	.50	.050	.625	.250
-32	2.000	1.203	2.000	3.016	.030	.125	.50	.063	.750	.250
-36	2.250	1.328	2.250	3.266	.030	.125	.50	.063	.750	.250
-40	2.500	1.453	2.500	3.516	.030	.125	.50	.063	.750	.250
-44	2.750	1.578	2.750	3.766	.030	.125	.50	.063	.750	.250
-48	3.000	1.703	3.000	4.016	.030	.125	.50	.063	.750	.250

NOTES:

1. MATERIALS: STRAP AND BASE - CRES 321 SHEET PER AMS 5510, EXCEPT THAT A MINIMUM TENSILE STRENGTH OF 100 KSI SHALL BE REQUIRED.
CUSHION - NITRILE BUTADIENE RUBBER, 65-75 DUROMETER, COLOR YELLOW, PER AMS 3224 AND WITH OZONE RESISTANCE REQUIREMENT PER AS85449.
2. FINISH: STRAP AND BASE - PASSIVATE PER AMS-QQ-P-35.
CUSHION - NONE.
- /3/ THE "D" AND "E" DIMENSION WILL BE MEASURED WITH MANDREL CLAMPED AND A "G" DIMENSION THICKNESS SPACER BETWEEN THE CLAMP FEET. "G" DIMENSION IS FOR THICKNESS OF SHIM REQUIRED TO INSPECT ASSEMBLED CLAMP.
- /4/ THIS PRODUCT SHALL BE QUALIFIED IN ACCORDANCE WITH PROCUREMENT SPECIFICATION AS85449. USERS OF THIS STANDARD SHALL PROCURE THIS PRODUCT FROM ACCREDITED MANUFACTURER(S) OR THEIR ACCREDITED DISTRIBUTOR(S) AS LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST PRI-QPL-AS85449 FOR THE STANDARD.
5. WITH CLAMP ASSEMBLED ON TUBE, NO GAP IS PERMITTED BETWEEN CUSHION AND TUBE FOR UPPER HALF OF STRAP AND CUSHIONED LENGTH OF SADDLE BASE.
- /6/ WITH CUSHION PUSHED TO EITHER END OF STRAP, SUFFICIENT CUSHION SHALL BE AVAILABLE TO PREVENT STRAP FROM CONTACTING TUBE.
- /7/ IDENTIFICATION: MARK THE COMPLETE STANDARD PART NUMBER AND MANUFACTURER'S NAME, TRADEMARK OR CAGE CODE ON STRAP, IN AN AREA NOT COVERED BY THE CUSHION AND SHALL BE VISIBLE PER AS478, METHOD 2A1. THE SADDLE SHALL HAVE THE DASH SIZE IMPRESSION STAMPED IN THE VICINITY OF THE MOUNTING HOLE AWAY FROM ANY BEND RADII.
8. REMOVE ALL BURRS AND SHARP EDGES.
9. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS ± .010, ANGULAR DIMENSIONS ±0° 30'.
10. DIMENSIONING AND TOLERANCING: ASME Y14.5M-1994.