

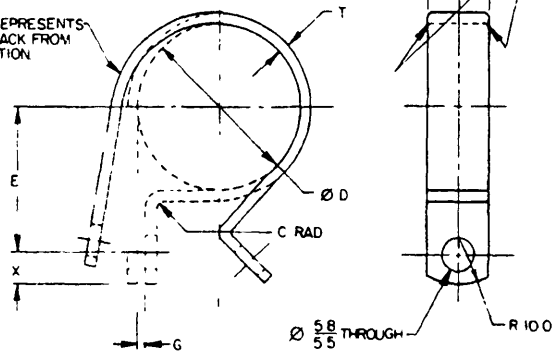
FED. SUP CLASS
5340SHAPE IN SOLID LINES REPRESENTS
CLAMP AFTER SPRING BACK FROM
THE 270° FORMED POSITION

TABLE 1. DIMENSIONS AND DASH NUMBERS

| DASH NO | RIGID NOM TUBE SIZE | Ø D ±0.4 | E | | G | C ±0.4 | T (SEE REQ'T 5) | | | W | | X | |
|---------|---------------------|-------------|------------|--------|-------------------------|-----------|-----------------|--------------|------------|------------|------------|------|-----|
| | | | ALUM ALLOY | STEELS | | | ALUM ALLOY | CARBON STEEL | CRES STEEL | ALUM ALLOY | ALL STEELS | | |
| 004 | 4.0 | 4.0 | 9.0 | 9.0 | 1.6 +0.4 -0.0 | 1.6 | 0.8 | | 0.5 | 12.7 | 9.5 | 4.8 | |
| 005 | 5.0 | 5.0 | 10.7 | 10.7 | | | | | | | | | |
| 006 | 6.0 | 6.0 | 11.6 | 11.6 | | | | | | | | | |
| 008 | 8.0 | 8.0 | 12.6 | 12.6 | | | | | | | | | |
| 010 | 10.0 | 10.0 | 13.4 | 13.4 | | | | | | | | | |
| 012 | 12.0 | 12.0 | 15.0 | 15.0 | | | | | | | | | |
| 014 | 14.0 | 14.0 | 15.8 | 15.8 | | 2.8 | 1.2 | 0.8 | 0.8 | | 12.7 | 12.7 | 5.5 |
| 016 | 16.0 | 16.0 | 16.6 | 16.6 | | | | | | | | | |
| 018 | 18.0 | 18.0 | 19.0 | 19.0 | | | | | | | | | |
| 020 | 20.0 | 20.0 | 20.6 | 20.6 | | | | | | | | | |
| 022 | 22.0 | 22.0 | 21.5 | 21.5 | | | | | | | | | |
| 025 | 25.0 | 25.0 | 23.0 | 22.6 | | | | | | | | | |
| 028 | 28.0 | 28.0 | 24.6 | 24.2 | 2.4 +0.8 -0.0 | 3.2 | 1.6 | | 1.0 | 1.0 | | | |
| 032 | 32.0 | 32.0 | 27.0 | 26.0 | | | | | | | | | |
| 040 | 40.0 | 40.0 | 31.0 | 30.0 | | | | | | | | | |
| 045 | 45.0 | 45.0 | 33.3 | 32.5 | | | | | | | | | |
| 050 | 50.0 | 50.0 | 36.5 | 35.7 | | | | | | | | | |
| 056 | 56.0 | 56.0 | 39.7 | 39.0 | | | | | | | | | |
| 063 | 63.0 | 63.0 | 43.0 | 42.2 | | | | | | | | | |
| 070 | 70.0 | 70.0 | 46.0 | 45.4 | | | | | | | | | |
| 080 | 80.0 | 80.0 | 52.4 | 51.8 | 3.2 +0.8 -0.0 | | | | | | | | |
| 090 | 90.0 | 90.0 | 55.5 | 55.0 | | | | | | | | | |
| 100 | 100.0 | 100.0 | 62.0 | 61.3 | | | | | | | | | |

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|---|---------------------------|--|------------------------------|
| P A NAVY-AS Other Cust ARMY-AR AIR FORCE-99 | INTERNATIONAL INTEREST | TITLE CLAMP, LOOP, METAL, PLAIN, SUPPORT, AIRCRAFT, METRIC | MILITARY STANDARD DS14489 |
| PROCUREMENT SPECIFICATION MIL-C-8603 | SUPERSEDES: | PAGE 1 OF 2 | |

DD FORM 672-1 (COORDINATED)
1 MAY 73

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5340-1620

APPROVED 2 APR 82 REVISED

REQUIREMENTS:

1. MATERIAL THE CLAMPS SHALL BE FABRICATED OF THE FOLLOWING MATERIALS AS SPECIFIED. SEE PROCUREMENT DOCUMENT.

ALUMINUM ALLOY, ALCLAD 2024-0 IN ACCORDANCE WITH QQ-A-250/5.
STEEL, AISI 1010, COLD ROLLED, TEMPER NO. 4 IN ACCORDANCE WITH ASTM A109.
CORROSION RESISTANT STEEL, TYPE 302 IN ACCORDANCE WITH MIL-S-5059 OR TYPE 321 IN ACCORDANCE WITH AMS 5510.

2. PROTECTIVE COATING AND SURFACE TREATMENT

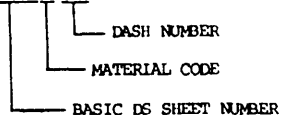
ALUMINUM ALLOY - CHEMICAL FILM PER MIL-C-5541, CLASS 1A.
STEEL - CADMIUM PLATED PER QQ-P-416, TYPE II, CLASS 2 (7.6 μ m).
CRES - CLEANED, DESCALED, AND PASSIVATED PER ASTM A-380.

3. UNLESS OTHERWISE SPECIFIED TOLERANCE SHALL BE ± 0.4 FOR DECIMAL DIMENSIONS AND $\pm 5^\circ$ FOR ANGULAR DIMENSIONS.
4. CLAMPS SHALL BE FREE OF BURRS AND SHARP EDGES.
5. TOLERANCE ON THICKNESS OF BAND MATERIAL SHALL BE AS FOLLOWS:
CRES AND STEEL - IN ACCORDANCE WITH ANSI/ASTM A109M.
ALUMINUM ALLOY - IN ACCORDANCE WITH ANSI H35.2M.
6. DIMENSION ϕD SHALL CHECK TO DIMENSION INDICATED IN TABLE I WITH ENDS HELD IN POSITION SHOWN (DIMENSION G).
7. CLAMPS SHALL BE FURNISHED IN THE OPEN POSITION. CLAMPS SHALL BE FORMED THROUGH A MINIMUM OF 270 DEGREES OF MANDREL CIRCUMFERENCE. NORMAL SPRING BACK OF THE CLAMP FROM THIS FINISHED CONDITION WILL BE ACCEPTABLE.
8. THE MATERIAL SHALL BE FLAT WITHIN 0.15mm ACROSS THE WIDTH OF THE CLAMP.
9. EACH CLAMP SHALL BE PERMANENTLY AND LEGIBLY MARKED WITH THE MANUFACTURER'S NAME, FSCM NUMBER, OR TRADEMARK AND THE COMPLETE DS PART NUMBER.
10. MATERIAL CODES: CODE INDICATES BAND MATERIAL. DO NOT SPECIFY BAND MATERIAL NOT LISTED.

A - ALUMINUM
S - STEEL
C - CORROSION RESISTANT STEEL (CRES).

11. PART NUMBER: THE PART NUMBER SHALL CONSIST OF THE BASIC DS SHEET NUMBER FOLLOWED BY THE MATERIAL CODE AND A DASH NUMBER TAKEN FROM TABLE I.

EXAMPLE: DS14489A-008



DS14489A-008 INDICATES CLAMP, PLAIN, SUPPORT, LOOP TYPE, AIRCRAFT, METRIC, ALUMINUM BAND, NOMINAL CLAMPING DIAMETER OF 8mm.

NOTES:

- ALL DIMENSIONS ARE IN MILLIMETERS.
- THIS CLAMP IS NOT FOR AIRCRAFT ELECTRICAL INTERCONNECTION WIRING AND CABLE USE. FOR ELECTRICAL APPLICATIONS, SEE MIL-S-23190.
- IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE.
- REFERENCED GOVERNMENT (OR NONGOVERNMENT) DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DoDISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN.

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|--|---------------------------|--|-------------------|
| P. A. NAVY-AS Other Cust ARMY-AR AIR FORCE-99 | INTERNATIONAL INTEREST | TITLE CLAMP, LOOP, METAL, PLAIN, SUPPORT, AIRCRAFT, METRIC | MILITARY STANDARD |
| | | | DS14489 |
| PROCUREMENT SPECIFICATION MIL-C-8603 | SUPERSEDES: | PAGE 2 OF 2 | |