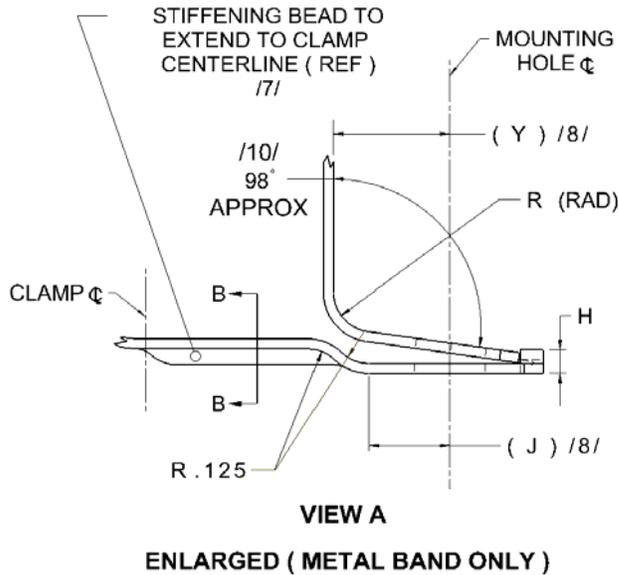


RATIONALE

THIS CLAMP STANDARD IS DEVELOPED TO ADD A LOCKING DEVICE SIMILAR TO THE AS4149 STANDARD WITH CUSHION MATERIAL PER AS85052/1, /2, AND /3. THE CLAMP IS SIMILAR TO AS85052/1, /2, AND /3 BUT WITH LOCKING DEVICE.

SAE AS6264

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VIEW A
ENLARGED (METAL BAND ONLY)

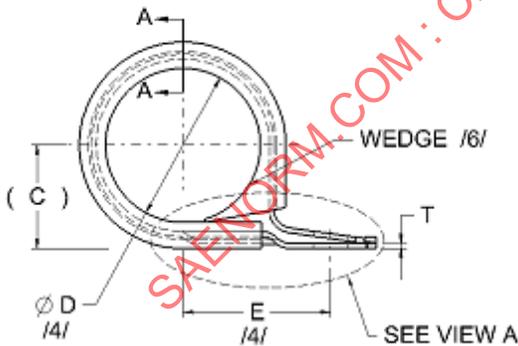
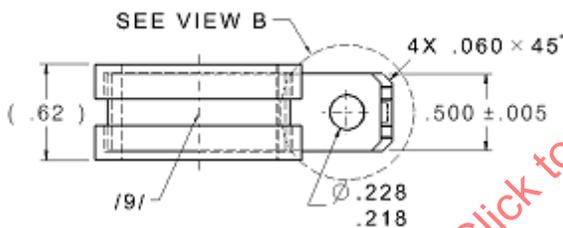
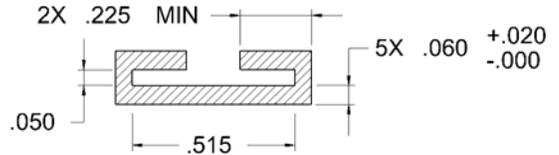
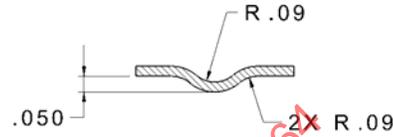


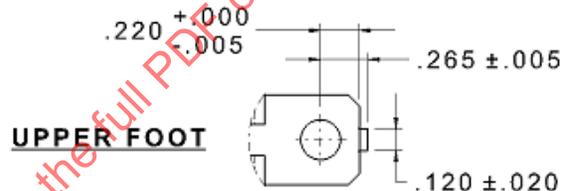
FIGURE 1 - CLAMP DESIGN
AND CONSTRUCTION



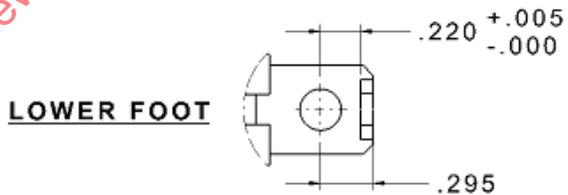
ENLARGED SECTION A-A
(CUSHION ONLY)



ENLARGED SECTION B-B



UPPER FOOT



LOWER FOOT

ENLARGED VIEW B - LOCKING DEVICE

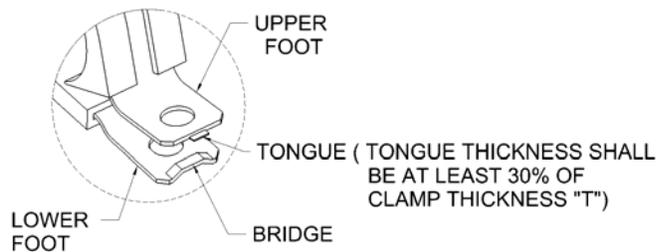
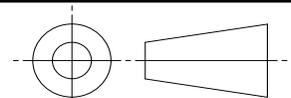


FIGURE 2 - NOMENCLATURE

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS6264>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3E

PROCUREMENT SPECIFICATION: AS85052 /5/

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

CLAMP, LOOP, TUBE 17-7PH
CUSHION, SELF-LOCKING

SAE AS6264
SHEET 1 OF 4

TABLE 1 - DIMENSIONS

BASIC NO. AS6264 SIZE CODE	TUBE SIZE	(C)	D	E ±.032	(J)	R	T TOLERANCE PER AMS2242	(Y)	H MAX /18/
-02	.125	.192	.125	.468	---	.090	.020	.325	.048
-03	.188	.224	.188	.499	---	.090	.020	.325	.048
-04	.250	.255	.250	.530	.235	.090	.020	.325	.048
-05	.312	.286	.312	.561	.235	.090	.020	.325	.048
-06	.375	.318	.375	.592	.235	.090	.020	.325	.048
-07	.438	.349	.438	.624	.235	.090	.020	.325	.048
-08	.500	.380	.500	.655	.235	.090	.020	.325	.048
-09	.562	.423	.562	.741	.256	.125	.032	.368	.076
-10	.625	.454	.625	.772	.256	.125	.032	.368	.076
-11	.688	.486	.688	.804	.256	.125	.032	.368	.076
-12	.750	.517	.750	.835	.256	.125	.032	.368	.076
-13	.812	.548	.812	.866	.256	.125	.032	.368	.076
-14	.875	.580	.875	.898	.256	.125	.032	.368	.076
-15	.938	.611	.938	.929	.256	.125	.032	.368	.076
-16	1.000	.642	1.000	.960	.256	.125	.032	.368	.076
-17	1.062	.681	1.062	1.001	.262	.125	.040	.370	.096
-18	1.125	.712	1.125	1.032	.262	.125	.040	.370	.096
-19	1.188	.744	1.188	1.064	.262	.125	.040	.370	.096
-20	1.250	.775	1.250	1.095	.262	.125	.040	.370	.096
-21	1.312	.806	1.312	1.126	.262	.125	.040	.370	.096
-22	1.375	.838	1.375	1.158	.262	.125	.040	.370	.096
-23	1.438	.869	1.438	1.189	.262	.125	.040	.370	.096
-24	1.500	.900	1.500	1.220	.262	.125	.040	.370	.096

NOTES:

1. MATERIALS:

BAND: 17-7PH, CORROSION RESISTANT STEEL PER AMS5528 OR AMS5529, ANNEALED.

CUSHION:

- a. N - NITRILE BUTADIENE RUBBER, 65-75 DUROMETER, COLOR YELLOW, PER AMS3224.
- b. S - FABRIC REINFORCED SILICONE RUBBER, 65-75 DUROMETER (ON REINFORCED MATERIAL), COLOR LIGHT BLUE, PER AMS3316. THE FABRIC REINFORCING MATERIAL SHALL BE MOLDED INTO THE BAND SIDE OF THE CLAMP CUSHION AT (45°) ANGLE (SEE FIGURE 3).
- c. E - ETHYLENE PROPYLENE RUBBER, 65-75 DUROMETER, COLOR PURPLE, PER AMS3253.

 An SAE International Group	AEROSPACE STANDARD	SAE AS6264 SHEET 2 OF 4	REV.
	CLAMP, LOOP, TUBE, 17-7PH CUSHION, SELF-LOCKING		

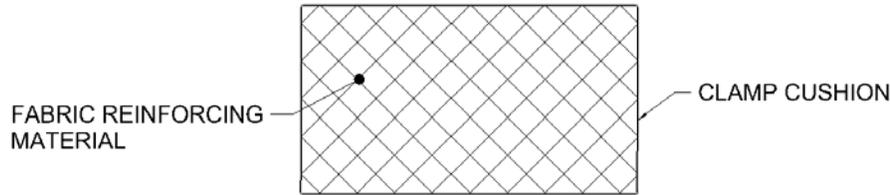


FIGURE 3 - CUSHION REINFORCEMENT

2. HEAT TREATMENT:

BAND: STRESS RELIEVE AND HEAT TREAT TO CONDITION TH1100 PER AMS2759/3 AFTER FORMING.

CUSHION: NONE

3. FINISH:

BAND: REMOVE SCALE, PASSIVATE PER AMS2700 TYPE 2 OR 8.

- /4/ DIAMETER "D" IS THE NOMINAL DIAMETER FOR WHICH A CLAMP SIZE IS INTENDED FOR USE. DIAMETER "D" SHALL BE VERIFIED BY THE "DIAMETER RETENTION" TEST OF THE PROCUREMENT SPECIFICATION. DIMENSION "E" SHALL BE MEASURED WITH THE CLAMP INSTALLED ON A MANDREL OF "D" DIAMETER ± 0.001 AND A 0.063 ± 0.001 SPACER BETWEEN UPPER AND LOWER FOOT.
- /5/ PROCUREMENT SPECIFICATION: AS85052 AS SPECIFIED ON THIS STANDARD. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST (QPL) PRI-QPL-AS85052 FOR THIS STANDARD. SEE www.eAuditNet.com FOR CURRENT QPL ON-LINE. THIS QPL REQUIREMENT SHALL BE IN EFFECT FOR PURCHASE ORDERS PLACED ON OR AFTER (PRI-QPL EFFECTIVE DATE). SUPPLIERS SEEKING LISTING ON THE INITIAL QPL MUST APPLY TO PRI FOR APPROVAL NO LATER THAN (TBD PRIOR TO QPL EFFECTIVE DATE). UNTIL THE QPL IS IN EFFECT, USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVALS. TRANSITION TO PRI-QPL SHALL BE COMPLETED BY (PRI-QPL EFFECTIVE DATE).
- /6/ WEDGE SHALL BE REQUIRED ON SIZE -06 AND LARGER. THE WEDGE SHALL BE MOLDED AS AN INTEGRAL PART OF THE CUSHION. WEDGE MUST TOUCH CUSHION ON LOWER FOOT WITH CLAMP INSTALLED ON A MANDREL WITHOUT SPACER. CUSHION ENDS FOR -05 AND SMALLER CLAMPS SHALL MEET WHEN INSTALLED ON MANDREL WITHOUT SPACER.
- /7/ STIFFENING BEAD SHALL BE REQUIRED ON SIZE -04 AND LARGER. ALL RADII ON THE STIFFENING BEAD SHALL BE SMOOTH AND BLENDED. NO SHARP TOOL MARKS ARE ALLOWED.
- /8/ REFERENCE DIMENSIONS "J" AND "Y" ARE PROVIDED TO GAIN MAXIMUM SUPPORT FOR THE LOWER FOOT BY CLOSELY FITTING THE UPPER FOOT BEND RADIUS TO THE STIFFENING BEAD BLEND RADIUS WHEN CLOSED AGAINST EACH OTHER.
- /9/ 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 METHOD 2A1. CLAMP BANDS OF -02, -03, AND -04 SIZES MAY BE MARKED WITH THE MANUFACTURERS IDENTIFICATION, THE SIZE AND THE SPECIFICATION SHEET NUMBER DUE TO SPACE LIMITATIONS.
- /10/ CLAMP SHALL BE FORMED WITH AN ANGLE APPROACHING 98° DURING BLANKING OPERATION. REFERENCE ONLY FOR FINISHED CLAMPS.
- /11/ FREE STATE CLOSURE: CLAMPS SHALL BE CLOSED AND LOCKED. MOUNTING HOLES SHALL ALIGN SUCH THAT A NO. 10 FASTENER WILL BE ACCEPTED THROUGH BOTH HOLES. UPPER AND LOWER FOOT SHALL REMAIN POSITIVELY LOCKED AND DISENGAGE ONLY WHEN FRONT OF CLAMP IS DEPRESSED TO ALLOW UPPER FOOT TO CLEAR LOWER FOOT.
- /12/ CLOSURE OVER MANDREL: CLAMP SHALL BE INSTALLED OVER A MANDREL OF "D" ± 0.001 DIAMETER AND CLOSED AND LOCKED USING HAND PRESSURE OR SIMPLE MANIPULATION USING A PLIER TYPE INSTALLATION TOOL. CLAMP SHALL MEET ALL REQUIREMENTS SPECIFIED FOR FREE STATE CLOSURE PER /11/.

 An SAE International Group	AEROSPACE STANDARD	SAE AS6264 SHEET 3 OF 4	REV.
	CLAMP, LOOP, TUBE, 17-7PH CUSHION, SELF-LOCKING		