

RATIONALE

AS85052/1A HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

REV.
A

AS85052/1

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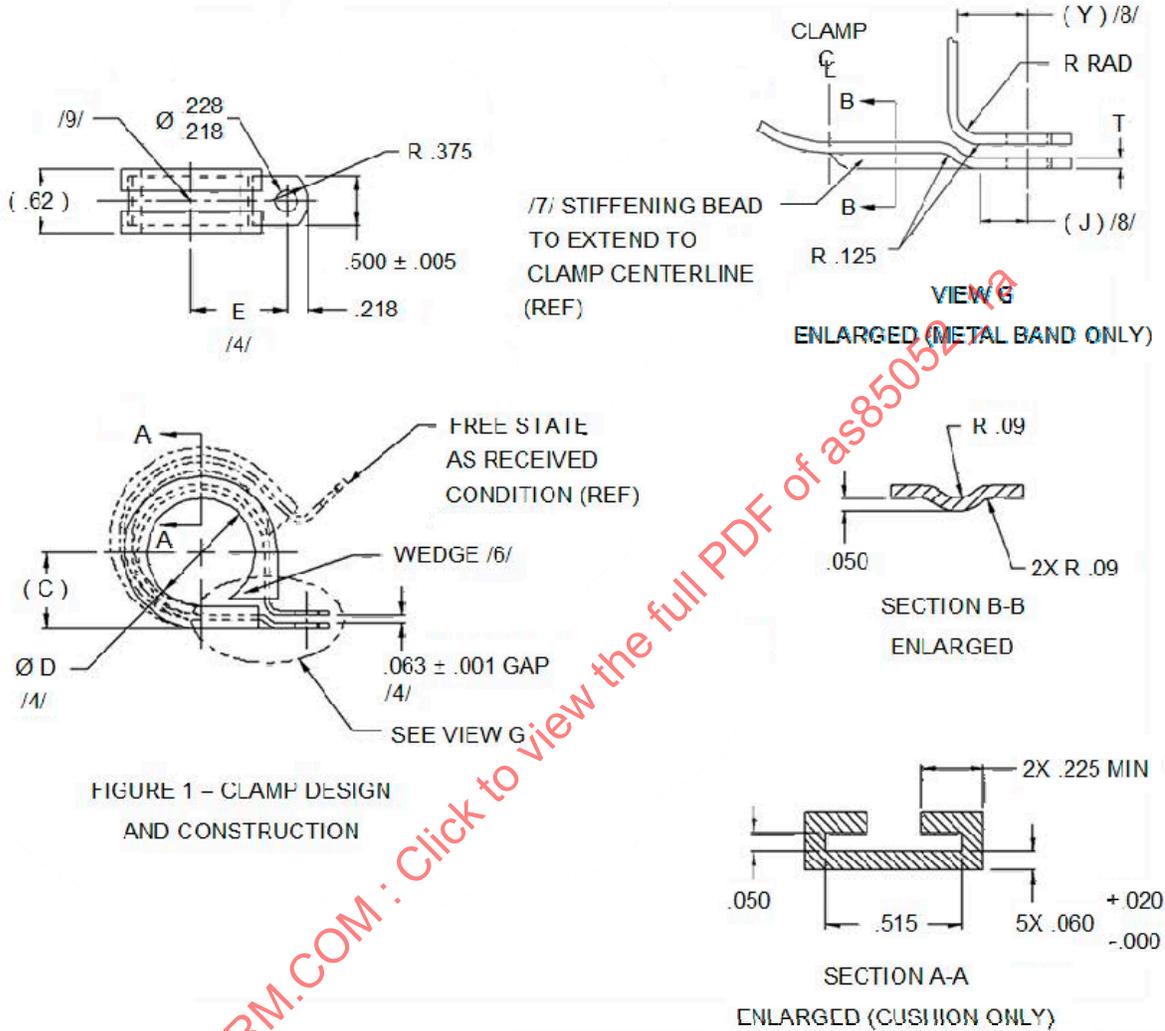
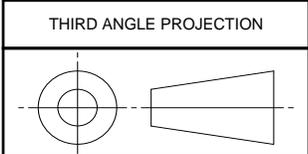


FIGURE 1 - CLAMP DESIGN AND CONSTRUCTION

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CUSTODIAN: G-3/G-3E		PROCUREMENT SPECIFICATION: AS85052 /5/	
	AEROSPACE STANDARD		AS85052/1 SHEET 1 OF 3
	(R) CLAMP, LOOP, TUBE, 17-7PH, 275 °F, FUEL AND PETROLEUM BASED HYDRAULIC FLUID RESISTANT		

ISSUED 2001-03 REVISED 2008-07 REAFFIRMED 2015-04

TABLE 1 - CLAMP DIMENSIONS

BASIC NO. AS85052/1 SIZE CODE /13/	TUBE SIZE	(C)	ØD	E ±.032	(J)	R RAD ±.010	T TOLERANCE PER AMS2242	(Y)
-02	.125	.192	.125	.468	-	.090	.020	.325
-03	.188	.224	.188	.499	-	.090	.020	.325
-04	.250	.255	.250	.530	.235	.090	.020	.325
-05	.312	.286	.312	.561	.235	.090	.020	.325
-06	.375	.318	.375	.592	.235	.090	.020	.325
-07	.438	.349	.438	.624	.235	.090	.020	.325
-08	.500	.380	.500	.655	.235	.090	.020	.325
-09	.562	.423	.562	.741	.256	.125	.032	.368
-10	.625	.454	.625	.772	.256	.125	.032	.368
-11	.688	.486	.688	.804	.256	.125	.032	.368
-12	.750	.517	.750	.835	.256	.125	.032	.368
-13	.812	.548	.812	.866	.256	.125	.032	.368
-14	.875	.580	.875	.898	.256	.125	.032	.368
-15	.938	.611	.938	.929	.256	.125	.032	.368
-16	1.000	.642	1.000	.960	.256	.125	.032	.368
-17	1.062	.681	1.062	1.001	.262	.125	.040	.370
-18	1.125	.712	1.125	1.032	.262	.125	.040	.370
-19	1.188	.744	1.188	1.064	.262	.125	.040	.370
-20	1.250	.775	1.250	1.095	.262	.125	.040	.370
-21	1.312	.806	1.312	1.126	.262	.125	.040	.370
-22	1.375	.838	1.375	1.158	.262	.125	.040	.370
-23	1.438	.869	1.438	1.189	.262	.125	.040	.370
-24	1.500	.900	1.500	1.220	.262	.125	.040	.370

NOTES:

1. MATERIALS:
 - BAND - 17-7PH, CORROSION RESISTANT STEEL PER AMS5528 OR AMS5529, ANNEALED
 - CUSHION - NITRILE BUTADIENE RUBBER, 65-75 DUROMETER, COLOR YELLOW, PER AMS3224
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
 - CUSHION - NONE
- /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 ±.001 AND A .063±.001 GAP SPACER BETWEEN UPPER AND LOWER FOOT AS SHOWN.
- /5/ PROCUREMENT SPECIFICATION: AS85052 EXCEPT 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.
- /6/ WEDGE SHALL BE REQUIRED ON SIZE -06 AND LARGER. THE WEDGE SHALL BE MOLDED AS AN INTEGRAL PART OF THE CUSHION AND CONTOURED TO FIT "D" DIAMETER. WEDGE MUST TOUCH CUSHION ON LOWER FOOT WITH CLAMP INSTALLED ON A MANDREL WITHOUT SPACER.

	AEROSPACE STANDARD		AS85052/1 SHEET 2 OF 3	REV. A
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