

INCH-POUND

MIL-PRF-6855/5A

15 June 2009

SUPERSEDING

MIL-R-6855/5

16 February 1987

PERFORMANCE SPECIFICATION SHEET
RUBBER, SYNTHETIC, CHANNEL, EXTRUDED

This specification is approved for use by all Departments and Agencies of the Department of Defense.

The requirement for acquiring the product described herein shall consist of this specification sheet and MIL-PRF-6855.

REQUIREMENTS:

Part numbers:

Part numbers for channel described herein shall consist of the prefix M, specification number, specification sheet number, and a six-digit dash number assigned using [tables IA, IB, IC, ID, II, and III](#) herein, as show in the following example:

<u>M</u>	<u>6855</u>	/	<u>5</u>	=	<u>XXX</u>	<u>XX</u>	<u>X</u>
Prefix for Military Specification	Specification Number		Specification Sheet Number		Three-Digit Configuration Number (table IA , IB , IC , or ID , as applicable).	Two-Digit Classification Number (table II).	One-Digit Length Letter (table III).

Example: M6855/5-XXXXXX

Dimensional tolerances:

Tolerances for channel dimensions shall in accordance with [table IV](#) herein. All corner and fillet radii shall be 0.015 inch except as otherwise specified. Tolerance for channel length shall be -0 percent, and +3 percent of the specified length.

Surface finish:

All synthetic rubber channel surfaces shall be smooth and free from pin holes, flash, or any other imperfections which may impair serviceability.

VERIFICATION:

Inspection and test of synthetic rubber channel shall be in accordance with MIL-PRF-6855, Section 4, VERIFICATION.

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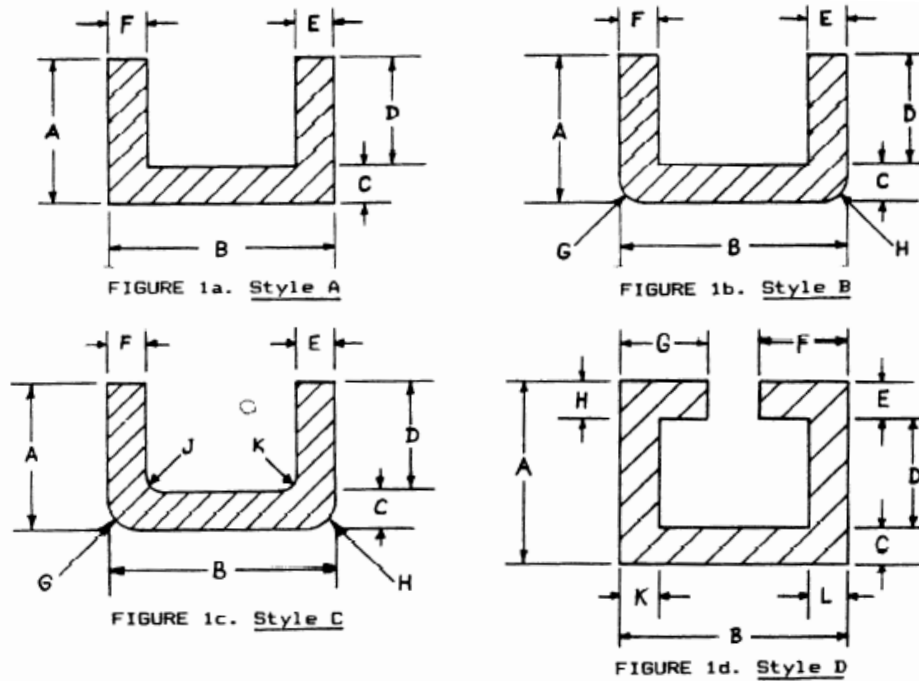


FIGURE 1. Channel Styles A, B, C & D.

TABLE IA. Channel dimensions – Style A.

Config. Number	A (Inches)	B (Inches)	C (Inches)	D (Inches)	E (Inches)	F (Inches)	Notes
A02	0.250	0.188	0.125	0.125	0.062	0.062	See Note 4
A04	0.250	0.250	0.125	0.125	0.062	0.062	See Note 4
A06	0.250	0.500	0.125	0.125	0.125	0.125	
A08	0.250	0.875	0.125	0.125	0.125	0.125	
A10	0.312	0.156	0.062	0.250	0.062	0.062	See Note 4
A12	0.312	0.240	0.062	0.250	0.062	0.062	See Note 4
A14	0.312	0.300	0.062	0.250	0.062	0.062	See Note 4
A16	0.312	0.500	0.187	0.125	0.125	0.125	
A18	0.312	0.875	0.125	0.187	0.125	0.125	
A20	0.312	1.000	0.125	0.187	0.125	0.125	
A22	0.375	0.875	0.125	0.250	0.125	0.125	
A24	0.375	1.000	0.125	0.250	0.125	0.125	
A26	0.438	0.375	0.063	0.375	0.063	0.063	See Note 4
A28	0.438	0.500	0.125	0.313	0.125	0.125	
A32	0.500	0.156	0.063	0.437	0.063	0.063	See Note 4
A34	0.500	0.500	0.125	0.375	0.125	0.125	
A36	0.500	1.000	0.125	0.375	0.125	0.125	
A38	0.500	1.000	0.250	0.250	0.250	0.250	
A40	0.875	0.875	0.125	0.750	0.125	0.125	
A42	1.000	1.000	0.250	0.750	0.250	0.250	

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TABLE IB. Channel dimensions – Style B.

Config. Number	A (Inches)	B (Inches)	C (Inches)	D (Inches)	E (Inches)	F (Inches)	G (Inches)	H (Inches)	Notes
B02	0.188	0.188	0.063	0.125	0.063	0.063	0.031	0.031	See Note 4
B04	0.250	0.250	0.125	0.125	0.062	0.062	0.060	0.060	See Note 4
B08	0.312	0.500	0.187	0.125	0.125	0.125	0.120	0.120	See Note 4
B10	0.400	0.160	0.125	0.275	0.060	0.060	0.080	0.080	
B12	0.500	0.500	0.125	0.375	0.125	0.125	0.188	0.188	
B14	1.000	1.000	0.250	0.750	0.250	0.250	0.188	0.188	

TABLE IC. Channel dimensions – Style C.

Config. Number	A (Inches)	B (Inches)	C (Inches)	D (Inches)	E (Inches)	F (Inches)	G (Inches)	H (Inches)	J (Inches)	K (Inches)	Notes
C02	0.188	0.188	0.063	0.125	0.063	0.063	0.031	0.031	0.016	0.016	See Note 4
C04	0.250	0.250	0.064	0.186	0.102	0.102	0.064	0.064	0.023	0.023	See Note 4
C06	0.250	0.250	0.125	0.125	0.062	0.062	0.060	0.060	0.031	0.031	See Note 4
C10	0.312	0.500	0.187	0.125	0.125	0.125	0.120	0.120	0.060	0.060	See Note 4
C12	0.500	0.187	0.125	0.375	0.047	0.047	0.094	0.094	0.047	0.047	
C14	0.500	0.500	0.125	0.375	0.125	0.125	0.188	0.188	0.080	0.080	See Note 4
C16	0.563	0.156	0.125	0.438	0.063	0.063	0.031	0.031	0.031	0.031	
C18	0.938	0.250	0.063	0.875	0.063	0.063	0.125	0.125	0.063	0.063	See Note 4
C20	1.000	1.000	0.250	0.750	0.250	0.250	0.188	0.188	0.120	0.120	See Note 4
C22	1.250	0.875	0.250	1.000	0.250	0.250	0.188	0.188	0.062	0.062	

TABLE ID. Channel dimensions – Style D.

Config. Number	A (Inches)	B (Inches)	C (Inches)	D (Inches)	E (Inches)	F (Inches)	G (Inches)	H (Inches)	K (Inches)	L (Inches)	Notes
D02	0.165	0.600	0.062	0.041	0.062	0.188	0.188	0.062	0.050	0.050	See Note 4
D04	0.249	0.624	0.125	0.062	0.062	0.219	0.219	0.062	0.062	0.062	See Note 4
D06	0.281	1.000	0.125	0.062	0.094	0.312	0.312	0.094	0.125	0.125	
D08	0.281	1.250	0.125	0.062	0.094	0.312	0.312	0.094	0.125	0.125	
D10	0.437	1.375	0.250	0.062	0.125	0.312	0.312	0.125	0.125	0.125	
D12	0.344	1.500	0.188	0.062	0.094	0.312	0.312	0.094	0.125	0.125	
D14	0.344	1.750	0.188	0.062	0.094	0.312	0.312	0.094	0.125	0.125	
D16	0.281	2.000	0.125	0.062	0.094	0.312	0.312	0.094	0.125	0.125	
D18	0.344	2.000	0.188	0.062	0.094	0.312	0.312	0.094	0.125	0.125	
D20	0.406	2.125	0.250	0.062	0.094	0.312	0.312	0.094	0.125	0.125	
D22	0.344	2.250	0.188	0.062	0.094	0.312	0.312	0.094	0.125	0.125	
D24	0.438	2.625	0.250	0.094	0.094	0.312	0.312	0.094	0.125	0.125	
D26	0.469	3.062	0.250	0.094	0.125	0.375	0.375	0.125	0.156	0.156	

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TABLE II. Channel type, class, and grade.

Classification Number	Classification of Requirements		
01		Class 1	Grade 30
02		Class 1	Grade 40
03		Class 1	Grade 50
04		Class 1	Grade 60
05		Class 1	Grade 70
06		Class 1	Grade 80
07	Type A	Class 2	Grade 30
08	Type A	Class 2	Grade 40
09	Type A	Class 2	Grade 50
10	Type A	Class 2	Grade 60
11	Type A	Class 2	Grade 70
12	Type A	Class 2	Grade 80
13	Type B	Class 2	Grade 30
14	Type B	Class 2	Grade 40
15	Type B	Class 2	Grade 50
16	Type B	Class 2	Grade 60
17	Type B	Class 2	Grade 70
18	Type B	Class 2	Grade 80
19		Class 3	Grade 30
20		Class 3	Grade 40
21		Class 3	Grade 50
22		Class 3	Grade 60
23		Class 3	Grade 70
24		Class 3	Grade 80
25	Type A	Class 4	Grade 30
26	Type A	Class 4	Grade 40
27	Type A	Class 4	Grade 50
28	Type A	Class 4	Grade 60
29	Type A	Class 4	Grade 70
30	Type A	Class 4	Grade 80
31	Type B	Class 4	Grade 30
32	Type B	Class 4	Grade 40
33	Type B	Class 4	Grade 50
34	Type B	Class 4	Grade 60
35	Type B	Class 4	Grade 70
36	Type B	Class 4	Grade 80
37		Class 5	Grade 30
38		Class 5	Grade 40
39		Class 5	Grade 50
40		Class 5	Grade 60
41		Class 5	Grade 70
42		Class 5	Grade 80

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TABLE III. Channel length – L.

Length Letter	L (Inches)
D	48.000
H	168.000

TABLE IV. Dimensional tolerances for channel.

Dimensional Range (Inches)	Tolerance
0.015 to 0.040 inclusive	±0.005 inches
Over 0.041 to 0.062 inclusive	±0.012 inches
Over 0.062 to 0.125 inclusive	±0.016 inches
Over 0.125 to 0.187 inclusive	±0.020 inches
Over 0.187 to 0.375 inclusive	±0.031 inches
Over 0.375 to 0.562 inclusive	±0.047 inches
Over 0.562 to 0.750 inclusive	±0.063 inches
Over 0.750 to 1.000	±0.093 inches
1.000 and over	±10% dim.

Metric Conversion Chart ^{1/}										
Inch	mm		Inch	mm		Inch	mm		Inch	mm
0.015	0.380		0.120	3.05		0.300	7.62		0.750	19.05
0.016	0.41		0.125	3.18		0.312	7.92		0.875	22.23
0.023	0.58		0.140	3.56		0.313	7.95		0.938	23.83
0.031	0.79		0.156	3.96		0.343	8.71		1.000	25.40
0.041	1.04		0.160	4.06		0.344	8.74		1.250	31.75
0.047	1.19		0.165	4.19		0.375	9.53		1.375	34.93
0.050	1.27		0.186	4.72		0.400	10.16		1.500	38.10
0.060	1.52		0.187	4.75		0.406	10.31		1.750	44.45
0.062	1.57		0.188	4.78		0.437	11.10		2.000	50.80
0.063	1.60		0.219	5.56		0.438	11.13		2.125	53.98
0.064	1.63		0.234	5.94		0.469	11.91		2.250	57.15
0.078	1.98		0.240	6.10		0.500	12.70		2.625	66.68
0.080	2.03		0.249	6.32		0.531	13.49		3.062	77.77
0.094	2.39		0.250	6.35		0.563	14.30		48.000	1219.20
0.102	2.59		0.275	6.99		0.600	15.24		168.000	4267.20
0.109	2.77		0.281	7.14		0.624	15.85			

NOTE:
^{1/} See general note 2.

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GENERAL NOTES TO TABLES:

1. Dimensions are in inches.
2. Metric equivalents are given for general information only.
3. Use of this specification sheet for US Army Communications-Electronics Command is restricted to Class 4 and Class 5 synthetic rubber.
4. These channel configurations shall apply only for synthetic rubber grades 50, 60, 70, and 80 of MIL-PRF-6855.

CHANGES FROM PREVIOUS ISSUE: Marginal notations are not used in this revision to identify changes with respect to the previous issue due to the extent of the changes.

Custodians:

Army – MR
Navy – SH
Air Force – 11
DLA – CC

Preparing Activity:

Navy – SH
(Project 4720-2008-021)

Review Activities:

Army – AR, AT, AV, CE, CR, MI
Navy – AS, OS, YD
Air Force – 71, 99

NOTE: The activities listed above were interested in this document as of the date of this document. Since organizations and responsibilities can change, you should verify the currency of the information above using the ASSIST Online database at <http://assist.daps.dla.mil>.