

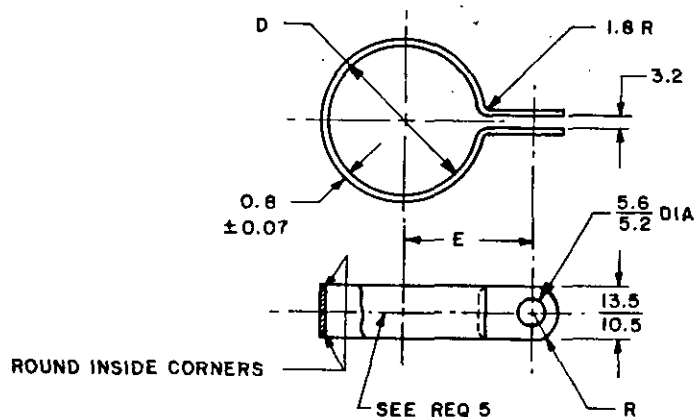
FED. SUP CLASS  
5340

TABLE I. DIMENSIONS AND DASH NUMBERS.

DASH NO.	NOMINAL TUBE OD	INSIDE DIA. D ±0.15	E ±0.4
004	4.0	4.0	9.5
005	5.0	5.0	10.0
006	6.0	6.0	10.5
008	8.0	8.0	11.5
010	10.0	10.0	13.0
012	12.0	12.0	14.0
014	14.0	14.0	15.0
016	16.0	16.0	16.0
018	18.0	18.0	17.0
020	20.0	20.0	18.0
022	22.0	22.0	19.0
025	25.0	25.0	21.5
028	28.0	28.0	23.0
032	32.0	32.0	25.0
040	40.0	40.0	29.0
045	45.0	45.0	31.5
050	50.0	50.0	34.0
056	56.0	56.0	37.0
063	63.0	63.0	40.5
070	70.0	70.0	44.5
080	80.0	80.0	49.0
090	90.0	90.0	54.0
100	100.0	100.0	59.0

METRIC

APPROVED 30 July 1983 REVISED

USER ACTIVITIES:

REVIEWER ACTIVITIES:  
ARMY - AT, AV, CR, ER, ME, MI  
NAVY - YD  
DLA - IS, CS

This military standard is approved for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

P. A. AS Other Cust	INTERNATIONAL INTEREST	TITLE CLAMP, LOOP TYPE, BONDING, METRIC	MILITARY STANDARD DS 14244
PROCUREMENT SPECIFICATION NONE		SUPERSEDES:	PAGE 1 OF 2

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## REQUIREMENTS:

1. MATERIAL.

STEEL - TYPE 1020 OR 1025 IN ACCORDANCE WITH MIL-S-7952.

CORROSION RESISTANT STEEL - TYPE 302 IN ACCORDANCE WITH MIL-S-5059 OR TYPE 321 IN ACCORDANCE WITH AMS 5510-78.

ALUMINUM ALLOY - 2024-O HEAT TREATED TO T42 CONDITION IN ACCORDANCE WITH MIL-H-6068.

2. FORMING.

FORMING OF BOTH FEET ON ALUMINUM CLAMPS SHALL BE PERFORMED IN THE ANNEALED CONDITION. CURLING (SIZING) MAY BE PERFORMED SUBSEQUENT TO HEAT TREATMENT.

3. FINISH.STEEL CLAMPS SHALL BE CADMIUM PLATED IN ACCORDANCE WITH QQ-P-416, TYPE II, CLASS 2 (8  $\mu$ m THICK).

CRCS - NO FINISH

ALUM ALLOY - NO FINISH

4. PART NUMBER. THE BASIC DS SHEET NUMBER IS FOLLOWED BY A DASH NUMBER, FOLLOWED BY A MATERIAL CODE LETTER.

EXAMPLE: DS14244-XXXX

MATERIAL CODE

"D" - ALUMINUM ALLOY

"C" - CRCS

"S" - CARBON STEEL

DASH NUMBER FROM TABLE 1

BASIC DS SHEET NUMBER

DS14244-004S INDICATES - CLAMP, LOOP TYPE, BONDING, METRIC; 4.0 mm INSIDE DIAMETER; CARBON STEEL.

DS14244-100D INDICATES - CLAMP, LOOP TYPE, BONDING, METRIC; 100 mm INSIDE DIAMETER; ALUMINUM ALLOY.

5. EACH CLAMP SHALL BE PERMANENTLY AND LEGIBLY MARKED WITH THE MANUFACTURER'S NAME OR TRADEMARK AND THE COMPLETE DS PART NUMBER.
6. CLAMPS SHALL CHECK TO DIMENSIONS STATED IN TABLE 1 WITH ENDS HELD IN POSITION SHOWN.
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 0.15 mm ACROSS THE WIDTH OF THE CLAMP.

## NOTES:

1. ALL DIMENSIONS ARE IN MILLIMETERS. UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE  $\pm 0.4$  MILLIMETERS.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON THE DATE OF INVITATIONS FOR BIDS, OR REQUEST FOR PROPOSAL, EXCEPT THAT REFERENCED ADOPTED INDUSTRY DOCUMENTS SHALL GIVE THE DATE OF THE ISSUE ADOPTED.
4. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.

P. A. Other Cust.	AS AR	INTERNATIONAL INTEREST	TITLE CLAMP, LOOP TYPE, BONDING, METRIC	MILITARY STANDARD DS14244
PROCUREMENT SPECIFICATION NONE		SUPERSEDES:		PAGE 2 OF 2

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5340-1448

APPROVED 30 July 1983 REVISED

USER ACTIVITIES:

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