DASH NO. RANGE	"D" DIA. RANGE	"E" DIMENSION	"G" GAP	"R" RADIUS	"T" GAUGE
-2L THRU -8L	1/8" TO 1/2"	"D"/2 + .505	.06	.08	.020
-2 THRU -8	1/8" TO 1/2"				.031
-9 THRU -12	9/16" TO 3/4"	"D"/2 + .535			
-13 THRU -23	13/16" TO 1-7/16"		.09		.050
-24 THRU -32	1-1/2" TO 2"	"D"/2 + .530	.13	.11	
-33 THRU -66	2-1/16" TO 4-1/8"				.062
-33L THRU -66L					.050



S520

REV.	CHANGE	DATE	BY	CHK'D	APPR
P	SEE DRAWING CHANGE RECORD ON FILE.	09/25/13	HAD	KWE	HAD

MATERIAL & FINISH CODES:

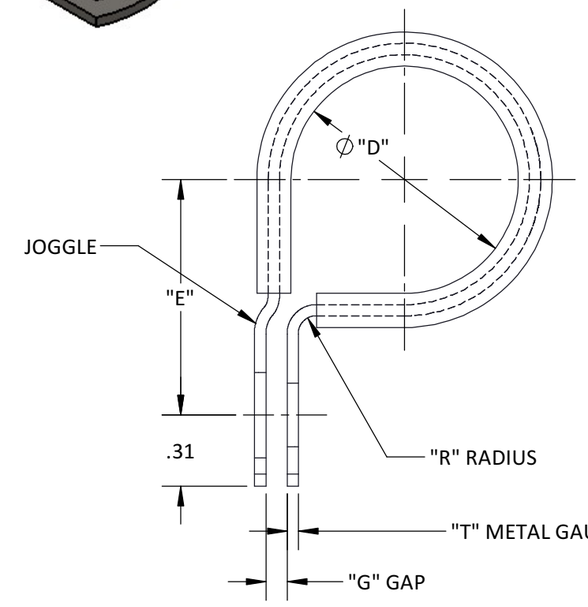
METAL:
- "NO CODE" 1008/1020 LOW CARBON STEEL PER ASTM A 1008, ASTM A 109, QQ-S-698
  FINISH: ZINC PLATE GOLD PER ASTM B 633, Fe/Zn 8, TY. II
- "D" 2024-T42 ALUMINUM ALLOY PER AMS-QQ-A-250/5
  FINISH: NONE
- "DK" 5052-H32 1/4 HARD ALUMINUM PER AMS-QQ-A-250/8
  FINISH: NONE 1
- "SS" 304/321 STAINLESS STEEL PER AMS 5513/AMS 5510
  FINISH: NONE
- "P" 17-7PH CORROSION RESISTANT STEEL PER AMS5528
  HEAT TREAT TO TH1100 CONDITION PER AMS2759/3 AFTER FORMING
  FINISH: PASSIVATE PER AMS2700 & BAKE PER AMS2759/9

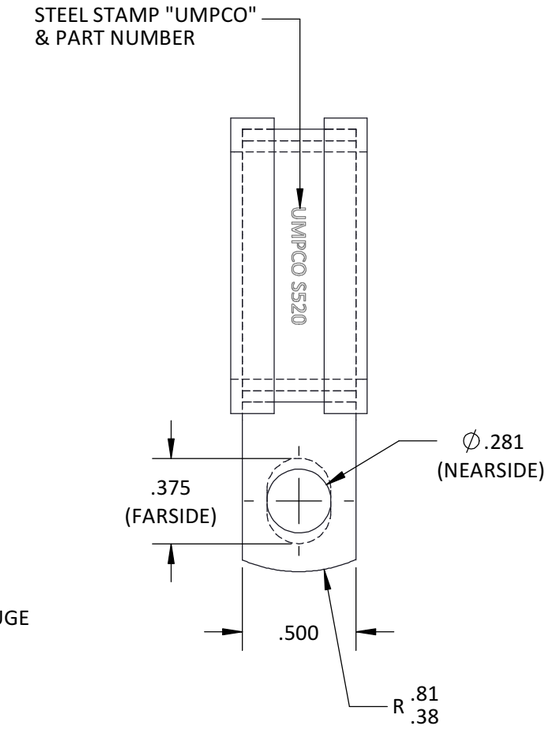
CUSHION:
- "G" GENERAL PURPOSE EPDM PER SAE J200 M3 BA 710 C12
  COLOR: BLACK
- "H" GENERAL PURPOSE SILICONE PER AMS 3303 WITH 100 PSI MIN. TEAR
  COLOR: RED/ORANGE
- "N" GENERAL PURPOSE NEOPRENE PER AMS 3209
  COLOR : BLACK
- "T" TEFLON SKIVED PER AMS 3652
  COLOR: WHITE

EXAMPLE OF PART CALLOUT:

1" DIA., .050 THK., ALUM. CLAMP W/ EPDM CUSHION

S520 D G 16 L
- L — LIGHT WEIGHT METAL OPTION (SEE CHART)
- 16 — DIA "D" IN 1/16" INCREMENTS
- G — CUSHION CODE
- D — METAL CODE (OMIT FOR "NO CODE")
- S520 — BASIC DRAWING NUMBER





SHEET 1 OF 1

NOTES:

1 CAUSTIC ETCH TO CLEAN AS NEEDED.
2) CLAMPS FURNISHED IN THE NORMAL OPEN (SPRINGBACK) CONDITION.
3) INSPECT PER MIL-C-8603 CLOSURE TEST.

REFERENCES:			
LIMITS ON DIMENSIONS UNLESS OTHERWISE SPECIFIED:	ANGULAR: X ± 5°	DECIMAL: .XX ± .03	.XXX ± .015
GENERAL MACHINE FINISHES EXCEPT AS NOTED: INTERPRET GEOMETRIC TOLERANCING PER: ASME-Y14.5M	PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF UMPCO, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF UMPCO, INC IS PROHIBITED.		
REMOVE ALL BURRS AND BREAK SHARP EDGES .010 MAX	ACT. WGHT. -	CALC. WGHT. -	

UMPCO, INC.
7100 LAMPSON AVE.
P.O. BOX 5158
GARDEN GROVE, CA. 92846

FSCM/CAGE CODE No. 18076		
KEL	RPD	LJS
03/12/82	03/02/05	03/02/95
DRAWN	CHECKED	ENGR

CLAMP, LOOP-TYPE, SUPPORT, CUSHIONED, FOR 1/4" MOUNTING BOLT

PART AND/OR ASSEMBLY DESCRIPTION

SIZE B

SCALE: NONE

S520

PRINT NUMBER