

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	.09	.11	.050
-13 THRU -23	13/16" TO 1-7/16"				.062
-24 THRU -32	1-1/2" TO 2"	"D"/2 + .530	.13	.11	.050
-33 THRU -66	2-1/16" TO 4-1/8"				.062
-33L THRU -66L					

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

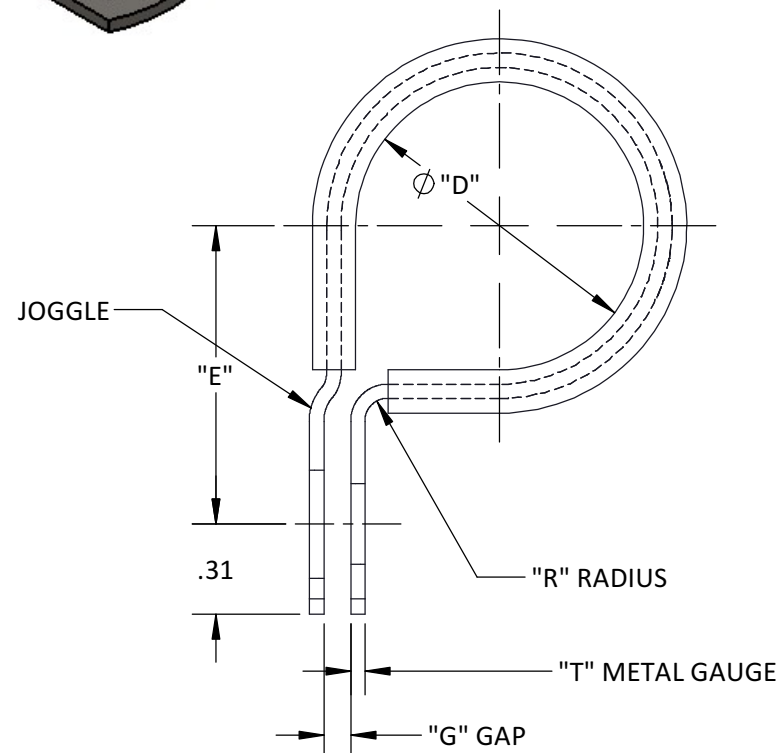
EXAMPLE OF PART CALLOUT:

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

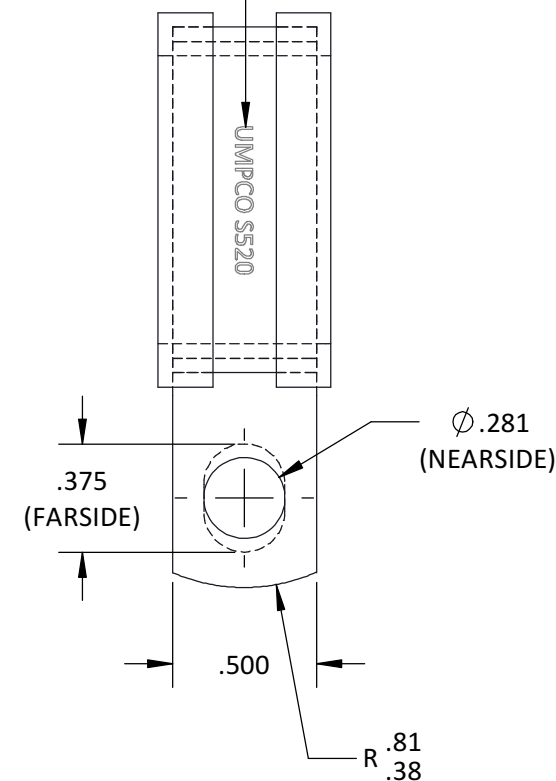
S520 D G 16 L
 LIGHT WEIGHT METAL OPTION (SEE CHART)
 DIA "D" IN 1/16" INCREMENTS
 CUSHION CODE
 METAL CODE (OMIT FOR "NO CODE")
 BASIC DRAWING NUMBER



S520



STEEL STAMP "UMPCO"
& PART 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°	UMPCO . INC. 7100 LAMPSON AVE. P.O. BOX 5158 GARDEN GROVE, CA. 92846		
	DECIMAL:	.XX	± .03			
GENERAL MACHINE FINISHES EXCEPT AS NOTED:	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.			FSCM/CAGE CODE No. 18076 KEL RPD LJS 03/12/82 03/02/05 03/02/95 DRAWN CHECKED ENGR		
	INTERPRET GEOMETRIC TOLERANCING PER: ASME-Y14.5M			SCALE: NONE		
REMOVE ALL BURRS AND BREAK SHARP EDGES .010 MAX	ACT. WGHT.	-		CLAMP, LOOP-TYPE, SUPPORT, CUSHIONED, FOR 1/4" MOUNTING BOLT PART AND/OR ASSEMBLY DESCRIPTION		
	CALC. WGHT.	-				
				SIZE	B S520	
				PRINT NUMBER		

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