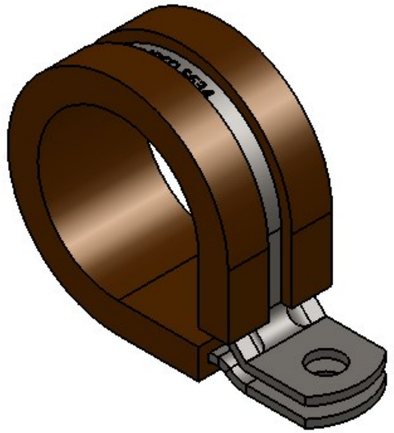
DASH NO. RANGE	"D" DIA. RANGE	"E" DIMENSION	"G" GAP	"R" RADIUS	"T" GAUGE	
					"C"	"P"
-3 THRU -8	3/16" TO 1/2"	"D"/2 + .404	.07	.06	.031	.020
-9 THRU -17	9/16" TO 1-1/16"	"D"/2 + .471		.11	.050	.031
-18 THRU -32	1-1/8" TO 2"	"D"/2 + .500	.10	.13	.062	.040
-33 THRU -48	2-1/16" TO 3"		.13			.050



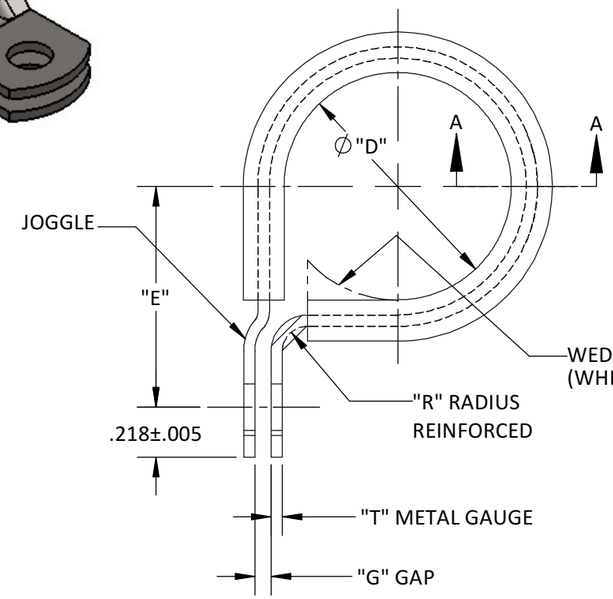
REV.	CHANGE	DATE	BY	CHK'D	APPR
F	SEE DRAWING CHANGE RECORD ON FILE.	06/14/13	HAD	KWE	HAD

S634

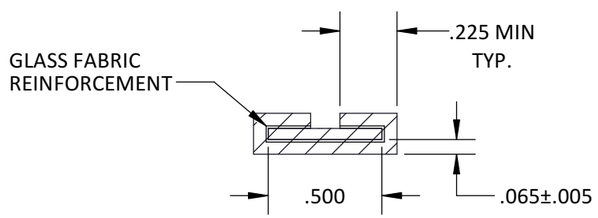
MATERIAL & FINISH CODES:

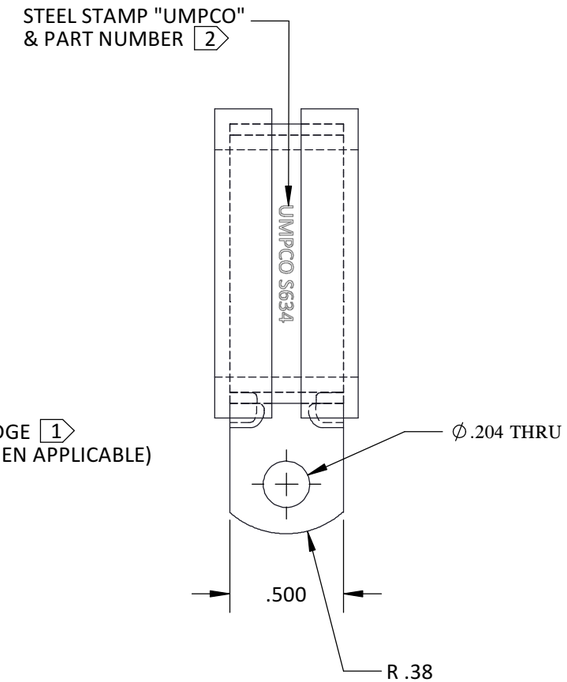
METAL: "C" 321 STAINLESS STEEL PER AMS 5510
FINISH: PASSIVATE PER AMS 2700, METHOD 1, CL. 1, TY. 6
"P" 17-7 PH STAINLESS STEEL PER AMS 5528
HEAT TREAT & STRESS RELIEVE TO TH1100 CONDITION PER AMS 2759, AMS-H-6875, AFTER FORMING.
FINISH: PASSIVATE PER AMS 2700, METHOD 1, CL. 1, TY. 6

CUSHION: FIBERGLASS REINFORCED SILICONE PER AMS 3352, PWA 36450
COLOR: BROWN



SECTION A-A
SCALE 1.5 : 1





EXAMPLE OF PART CALLOUT:

1" DIA. CLAMP, 17-7 PH STAINLESS STEEL W/WEDGED CUSHION

S634 W P 16
- 16 — DIA "D" IN 1/16" INCREMENTS
- P — METAL CODE
- W — WEDGE CODE (OMIT IF NOT APPLICABLE)
- S634 — BASIC PART NUMBER

NOTES:

1. INTEGRALLY MOLDED WEDGE IS FULL CONTOUR FROM -6 TO -24. FOR SIZES -25 THRU -48, USE -24 WEDGE.
2. FOR BOEING PROCUREMENT, THE COMPLETE BOEING NUMBER AND "UMPCO" SHALL BE PERMANENTLY MARKED IN THIS AREA.
3. CLAMPS FURNISHED IN THE NORMAL OPEN (SPRINGBACK) CONDITION.
4. INSPECT PER MIL-C-8603 CLOSURE TEST.

SHEET 1 OF 1

REFERENCES: BACC10HM

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

REMOVE ALL BURRS AND BREAK SHARP EDGES .010 MAX

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ACT. WGHT.	-
CALC. WGHT.	-

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

FSCM/CAGE CODE No. 18076

KEL	RPD	KEL
03/22/88	07/08/96	03/22/88
DRAWN	CHECKED	ENGR

CLAMP, SUPPORT, LOOP-TYPE,
HIGH TEMP (600°F, 315°C) CUSHIONED
PART AND/OR ASSEMBLY DESCRIPTION

SIZE B

SCALE: NONE

S634
PRINT NUMBER