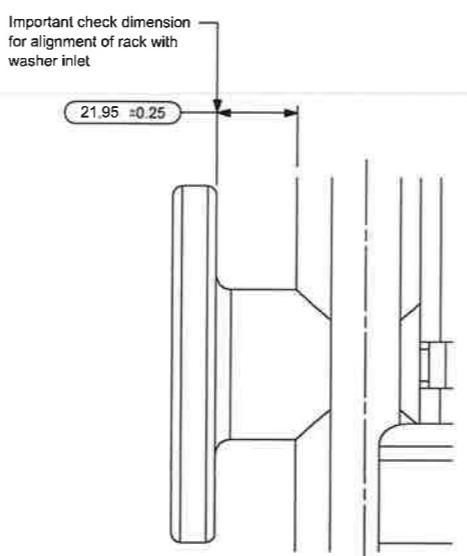
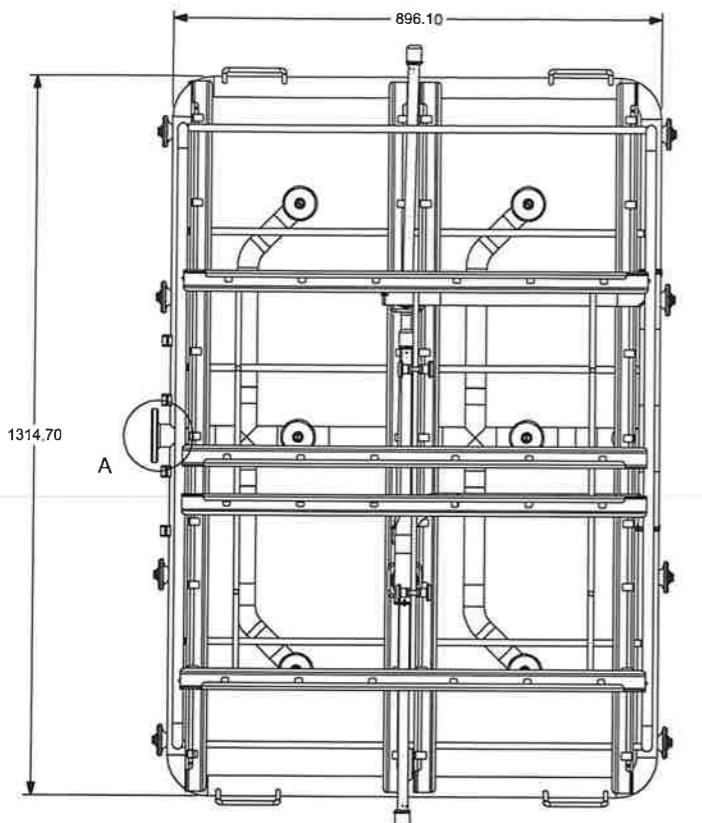


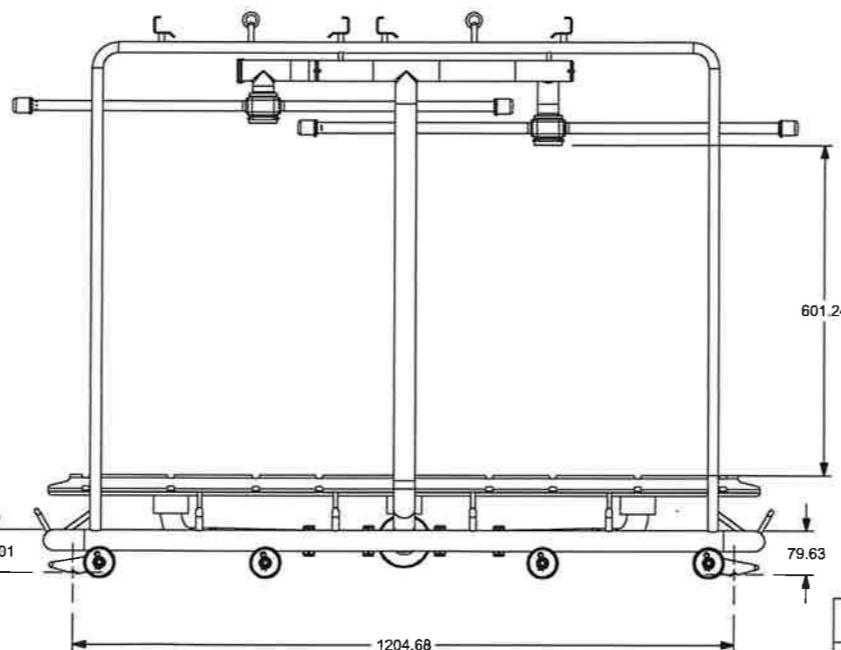
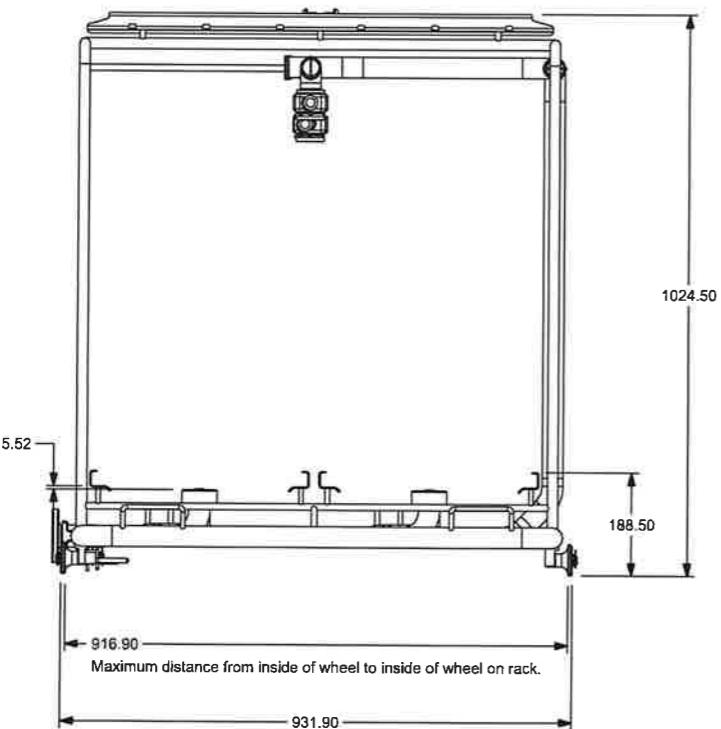
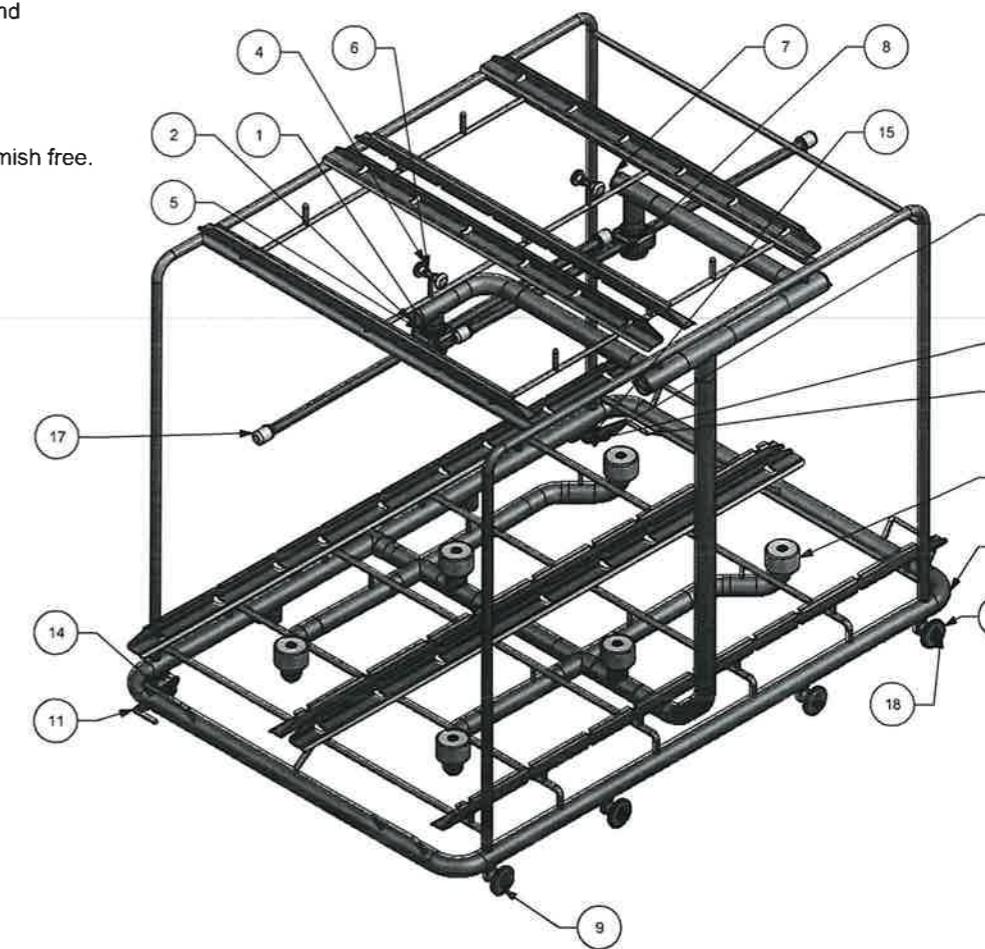
REVISION HISTORY		
DATE	DESCRIPTION	REV
19/03/2024	ORIGINAL RELEASE	A
20/05/2024	50020-3021 W ASM Updated	B

Assembly of plastic & Stainless steel Requirements - SF1 & SF4:

- Any blemishes such as porosity, pinholes, undercutting, cracks, are not permitted on any surface of the part. See Table SF-2.2-1 in ASME BPE 2019 (page 248) for full details.
- Maximum size of scratches permitted - cumulative length to be less than 6.4mm (0.25") and if depth less than 0.08mm (0.003 in) and Ra max. is met. See Table SF-2.2-1 in ASME BPE 2019 (page 248) for full details.
- Engineer/QC to be informed of all issues in fitting the items together as they are found before further assembly continues.
- Part to be packaged before and after assembly to prevent damage.
- Internal and external surfaces to be visually inspected with Borescope & under Magnifying Lamp to ensure they conform to latest ASME BPE Standards.
- All grooves to have specified O-ring fitted where applicable. The O-ring must be blemish free.
- Ensure IPT form is completed correctly.



DETAIL A  
SCALE 1:1



Latches & wheels to be checked on  
jig 50011-020.

APPROVAL

19	50020-3031 W ASM_DWG	1
18	50020-3022-01_DWG	8
17	50020-3018-003 ASM_DWG	2
16	50020-3016-01_DWG	2
15	50020-3006-003 DWG	2
14	50020-3006-002 DWG	1
13	50020-3006-001 DWG	1
12	50020-3005-008 ASM_DWG	1
11	50020-3005-007 ASM_DWG	1
10	50020-3002-007 DWG	8
9	50010-1003-018 DWG	10
8	50010-1003-015 DWG	2
7	50010-1003-012 DWG	4
6	50010-1003-002 DWG	4
5	50000-2300-008 DWG	4
4	50000-1800-189 DWG	4
3	50000-1800-188 ASM_DWG	6
2	50000-1800-145 ASM DWG	4
1	50000-1202-010 DWG	2
PC NO	PART NAME	QTY

Design Stamp Released: R.Sosickyte Date: 20/05/2024



	Name	Date	teg
Drawn	M.Looram	20/05/2024	
Checked	C.Gilsenan	20/05/2024	

PROPRIETARY AND CONFIDENTIAL		UNLESS OTHERWISE SPECIFIED:	Title
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF TECHNICAL ENGINEERING GROUP. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF TECHNICAL ENGINEERING GROUP IS PROHIBITED.		DIMENSIONS ARE IN mm	Main Rack for Belimed PH860 - Top Tier - No Manifolds
TOLERANCES:	ANGULAR: $\pm 0.5^\circ$		Size Drawing No. Rev
GENERAL MACHINE: $\pm 0.10$	SHEET METAL: $\pm 0.5$	A3 50020-3031 ASM_dwg B	
INTERPRET GEOMETRIC TOLERANCING PER: ASME Y14.5		Scale NTS Standard Washer Racks Sheet 1 of 1	

Design Review Checks	Yes	No
Chamfers		
Engraving		
Material		
Finish		
Quantity		
TE No.		
Job No.		
Revision No.		
Customer Name		
IPT		
BOM		
diff/ges		
Loc. holes/slots offset		
Loc. holes/slots tol.		
Thread details		
Assembly part list		
Parts/fittings sourced		
All assemblies ok		
Correspondence		
Job No.	See Process Card	
Quantity	See Process Card	
Material	See Parts	
Finish	See Note	
<input checked="" type="checkbox"/> or <input type="checkbox"/> Denotes IPT Dimension		

Preferred Material Blank Size See Parts