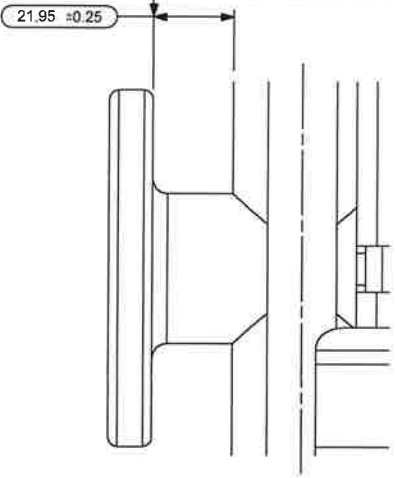


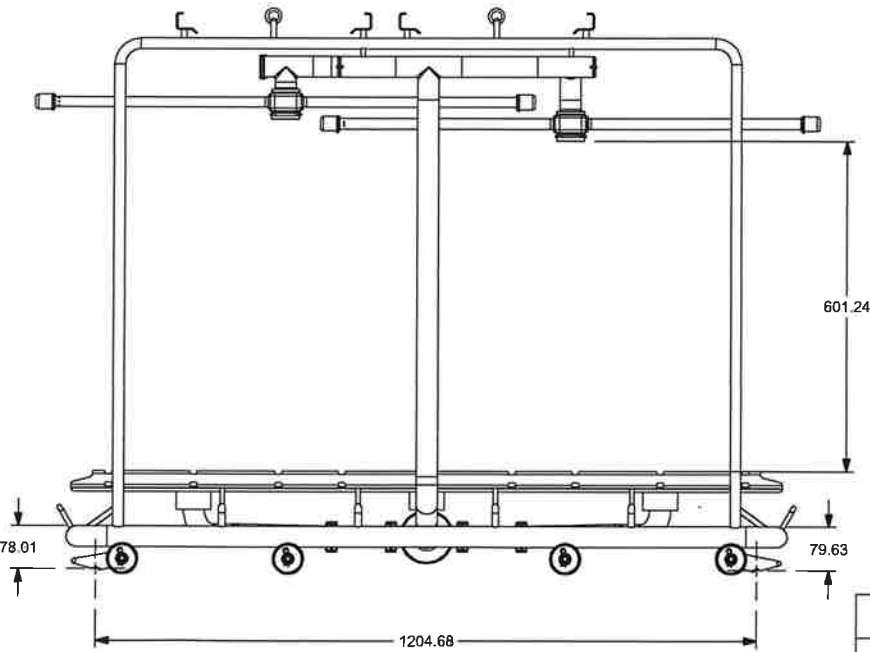
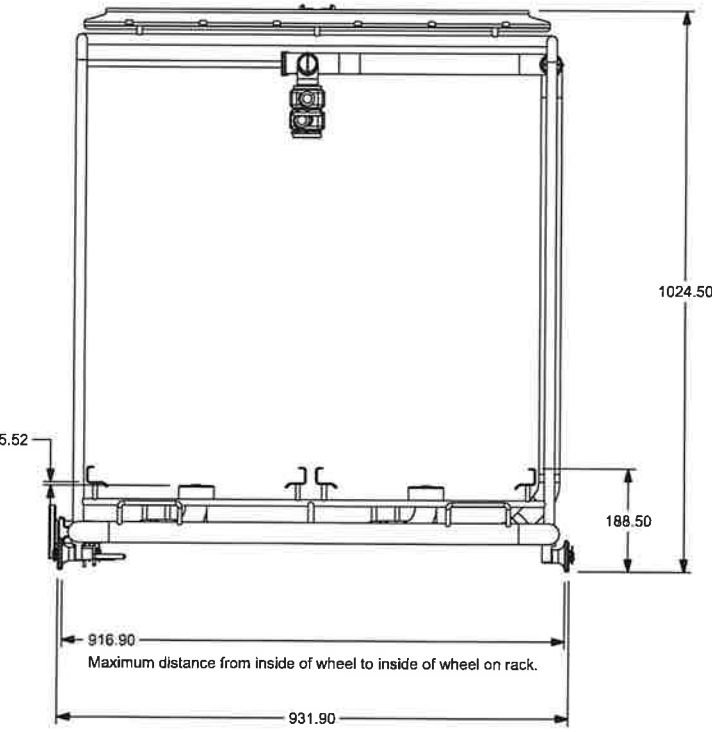
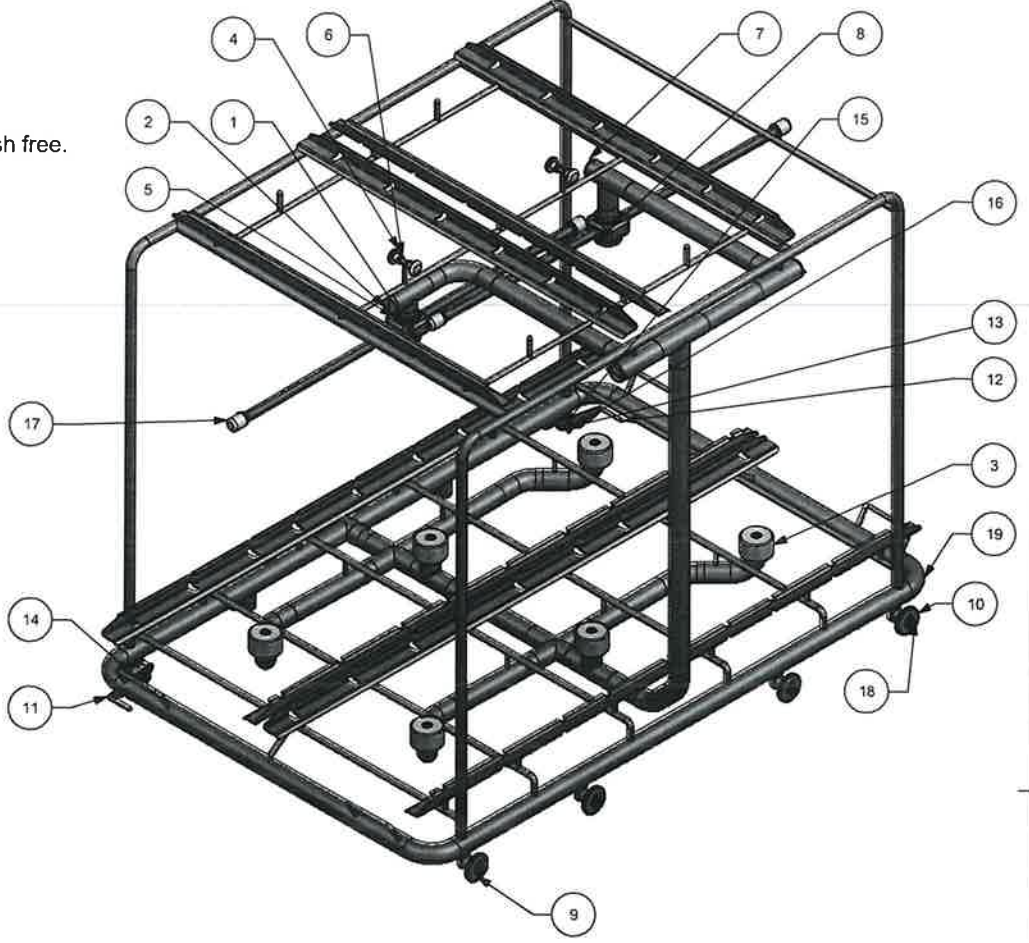
Assembly of plastic & Stainless steel Requirements - SF1 & SF4:

- 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.

Important check dimension for alignment of rack with washer inlet



DETAIL A
SCALE 1:1



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

APPROVAL

Laminated Copy in circulation - rev B
Customer: See Process Card
File saved in the folder named below

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 Review Checks	Yes	No
Chamfers		
Engraving		
Material		
Finish		
Quantity		
TE No.		
Job No.		
Revision No.		
Customer Name		
IPT		
BOM		
dxf/lgs		
Loc. notes/slots offset		
Loc. notes/slots tol.		
Thread details		
Assembly part list		
Parts/fittings sourced		
All assembly ok		
Correspondence		
Job No.	See Process Card	
Quantity	See Process Card	
Material	See Parts	
Finish	See Note	
☐ or ☐ Denotes IPT Dimension		

Preferred Material Blank Size	See Parts
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Design Stamp	Released: R.Sosickyte	Date: 20/05/2024
	Name	Date
	Drawn: M.Looram	20/05/2024
	Checked: C.Gilsenan	20/05/2024
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	Title Main Rack for Belimed PH860 - Top Tier - No Manifolds	
	Size A3	Drawing No. 50020-3031 ASM_dwg
Scale NTS		Standard Washer Racks
Sheet 1		of 1