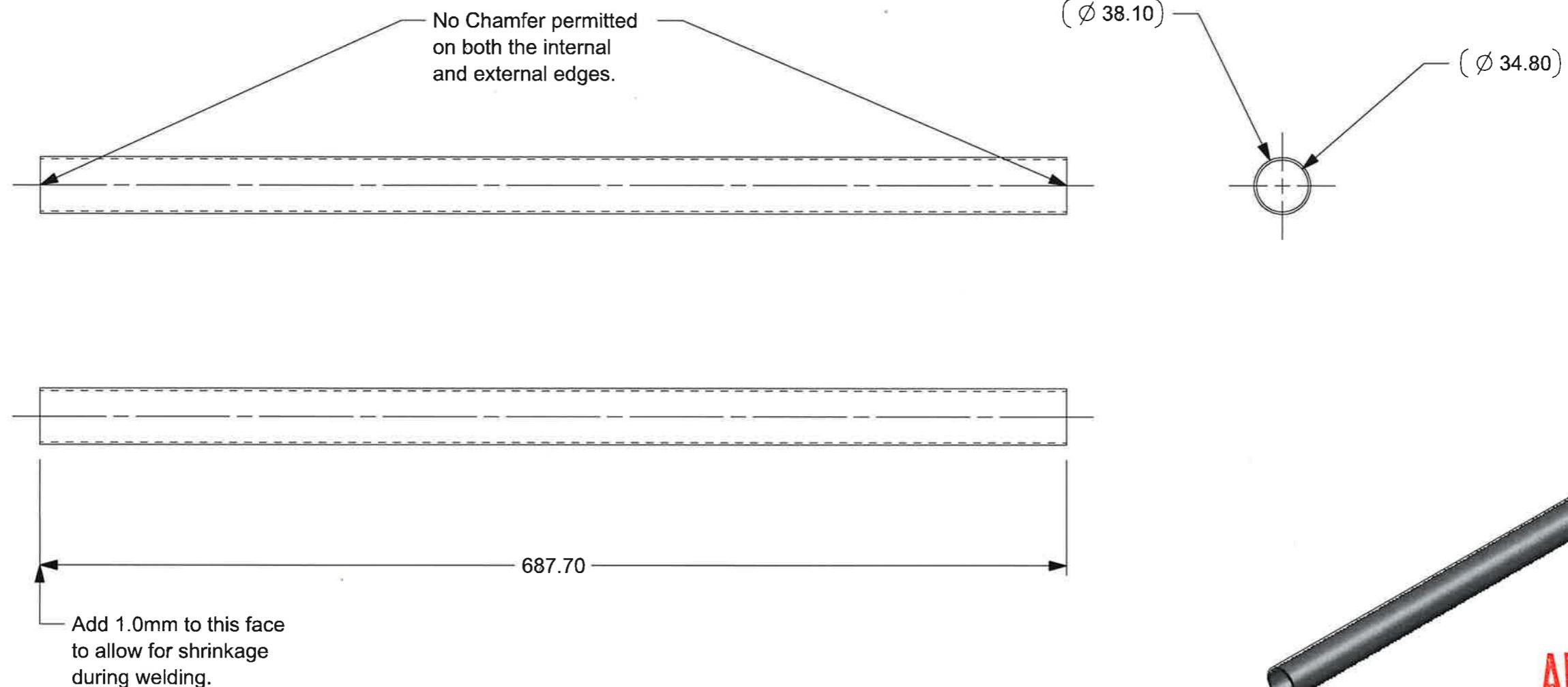


REVISION HISTORY		
DATE	DESCRIPTION	REV
04/09/2020	ORIGINAL RELEASE	A
25/11/2022	Standard Approved Drawing Format	B



**APPROVED**

#### Biobore Tube/ Stainless Part Requirements - SF1:

- Design Review Checks Yes No
- Chamfers
- Engraving
- Material
- Finish
- Quantity
- TE No.
- Job No.
- Revision No.
- Customer Name
- IPT
- BOM
- dx/iges
- Loc. holes/slots offset
- Loc. holes/slots tol.
- Thread details
- Assembly part list
- Parts/fittings sourced
- All assembly ok
- Correspondence
- Job No. See Process Card
- Quantity See Process Card
- Material 316L Stainless Steel
- Finish SF1
- D or ( ) Denotes IPT Dimension
- 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.
  - Internal Surface roughness max. = 0.51 micro meter RA (SF1). See Table SF-2.4-1 in ASME BPE 2019 (page 249) for full details.
  - External Surface roughness max. = 0.8 micro meter RA (SF1).
  - All deburring to be completed as per WI - 150 - 0038 for SF1 requirements.
  - Ends of open tubes to have small lead in blended edge on both internal and external diameters as per drawing details.
  - Engineer to be informed if the dimensional tolerances cannot be achieved prior to manufacturing.
  - No contact permitted with internal surface during machining.
  - No contact permitted with internal surface with files or other deburring tools.
  - All chamfers to be machined on.
  - Part to be packaged before and after machining 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.
  - Ensure IPT form is completed correctly.

Preferred Material Blank Size

1.5" Tube x 700mm

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

1.5 inch Tube  
316L Stainless Steel  
SF1 Finish

Design Stamp	Released	F.Digan	Date 25/11/22
		Name	Date
	Drawn	B Barry	25/11/2022
	Checked	C Gilsenan	25/11/2022
teg			
PROPRIETARY AND CONFIDENTIAL 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. UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN mm TOLERANCES: ANGULAR: ± 0.5° GENERAL MACHINE: ± 0.10 SHEET METAL: ± 0.5 INTERPRET GEOMETRIC TOLERANCING PER: ASME Y14.5			
Title 1.5" Tube			
Size A3 Drawing No. 50020-3018-002-12_dwg Rev B			
Scale NTS Standard Washer Racks Sheet 1 of 1			