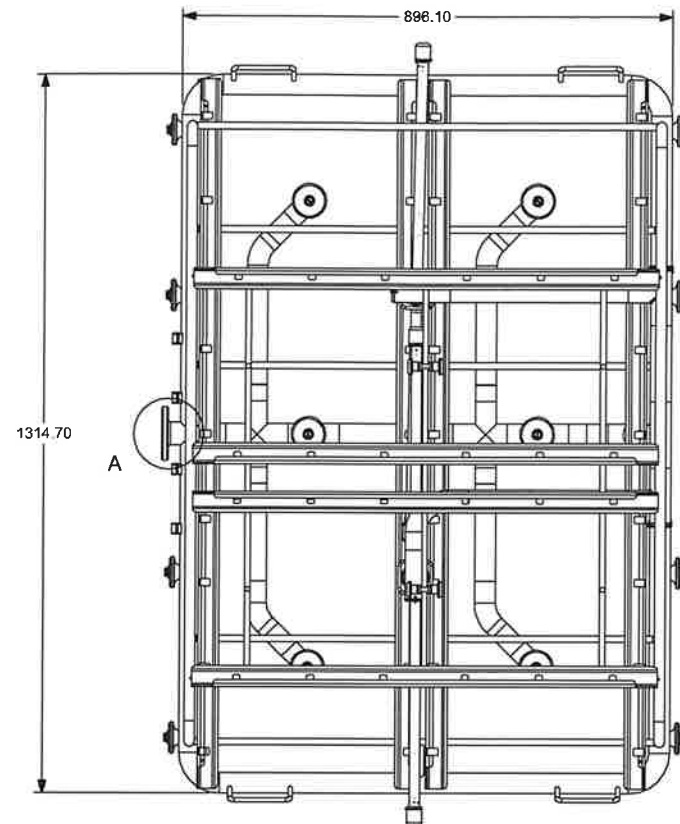


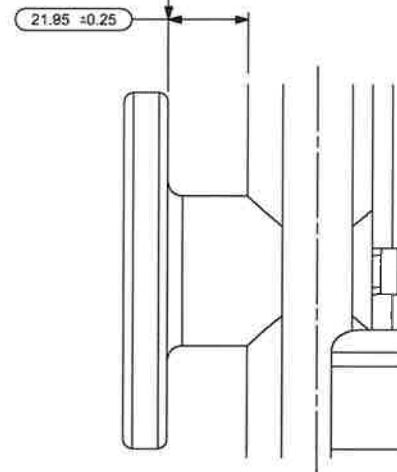
REVISION HISTORY		
DATE	DESCRIPTION	REV
19/03/2024	ORIGINAL RELEASE	A

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

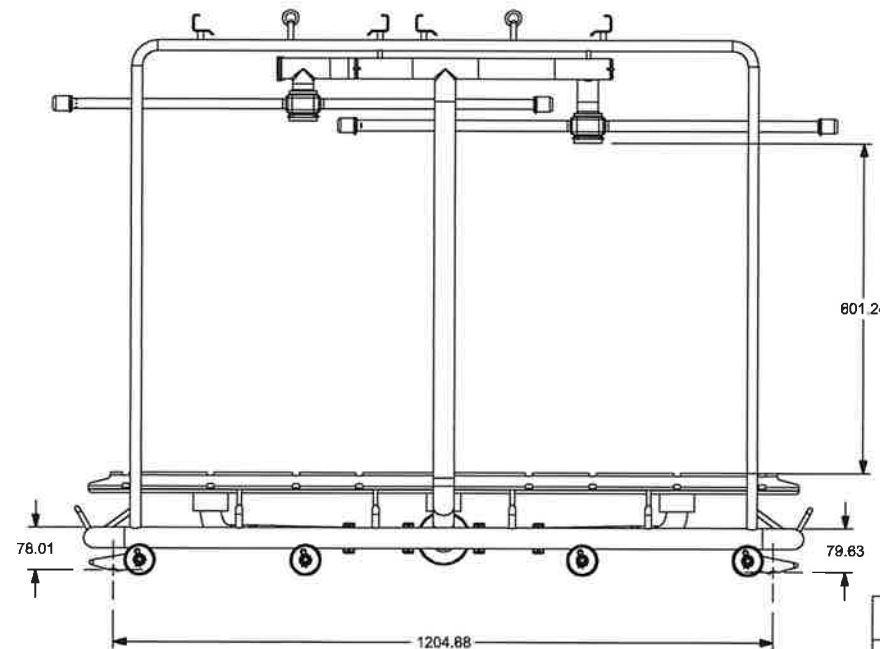
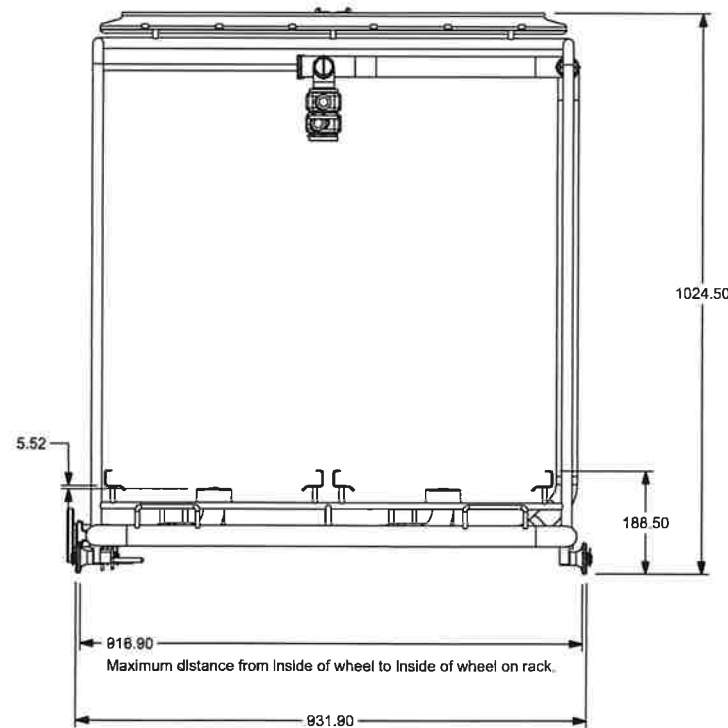
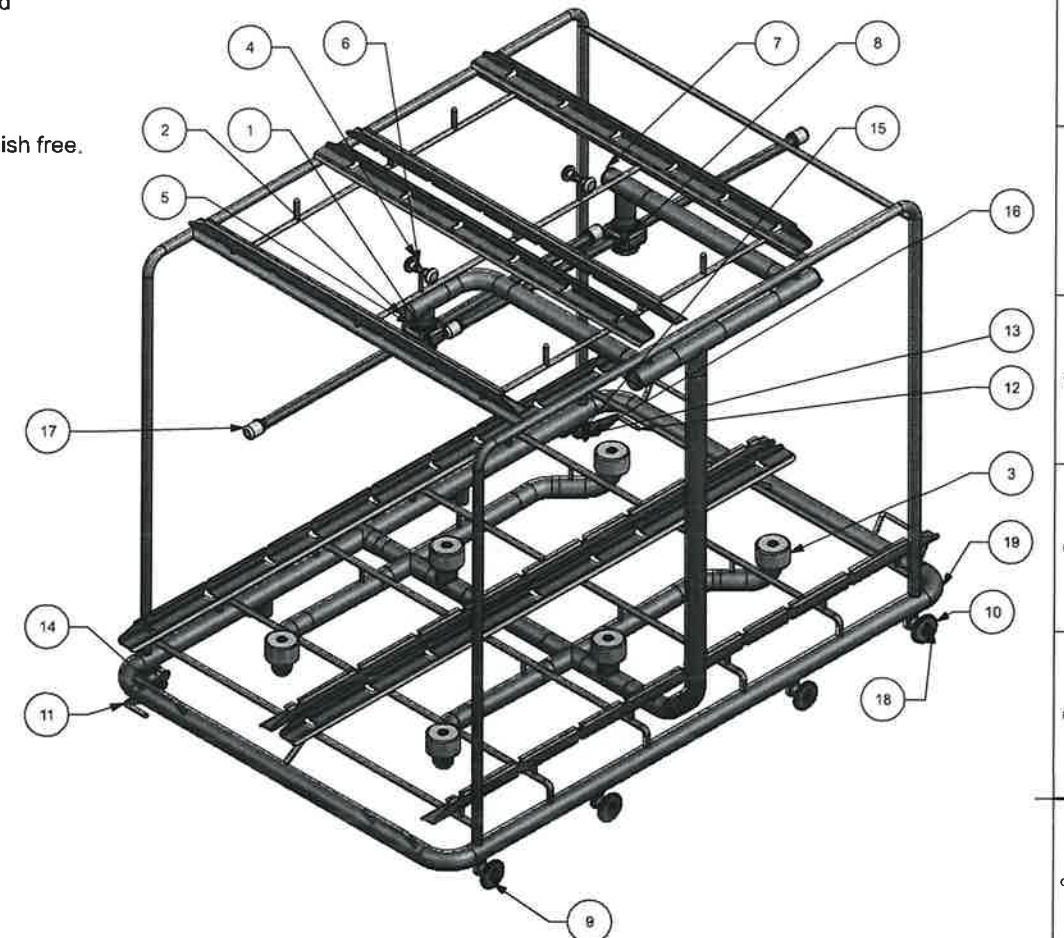
- Any blemishes such as porosity, pinholes, undercutting, cracks, are not permitted on any surface of the part. See Table SF-2.2-1 in ASME BPE 2019 (page 248) for full details.
- Maximum size of scratches permitted - cumulative length to be less than 6.4mm (0.25") and if depth less than 0.08mm (0.003 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.



APPROVED

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

PC NO	PART NAME	QTY
19	50020-3031 W ASM_DWG	1
18	50020-3022-01_DWG	8
17	50020-3018-003 ASM_DWG	2
16	50020-3018-01_DWG	2
15	50020-3008-003_DWG	2
14	50020-3008-002_DWG	1
13	50020-3008-001_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

Design Review Checks		Yes	No
Chamfers			
Engraving			
Material			
Finish			
Quantity			
TE No.			
Job No.			
Revision No.			
Customer Name			
IPT			
BOM			
dx/diges			
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	See Parts		
Finish	See Note		
or Dendos IPT D mention			

Preferred Material Blank Size	See Parts
-------------------------------	-----------

Design Stamp		Released: O.Fitzgerald		PC NO PART NAME		Date: 19/03/2024				
		Name	Date							
	Drawn	M.Looram	19/03/2024							
	Checked	C.Gilsenan	19/03/2024							
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: ± 0.5°			Size		Drawing No.	Rev	
			GENERAL MACHINE: ±0.10 SHEET METAL: ±0.5			A3		50020-3031 ASM_dwg	A	
			INTERPRET GEOMETRIC TOLERANCING PER: ASME Y14.5			Scale		NTS	Standard Washer Racks	Sheet 1 of 1