



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

- 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 2016 (page 231) 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 2016 (page 231) for full details.
- Internal Surface roughness max. = 0.51 micro meter RA (SF1). See Table SF-2.4-1 in ASME BPE 2016 (page 232) for full details.
- External Surface roughness max. = 0.8 micro meter RA (SF1).
- 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 edges to be fully deburred.
- 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

See Parts

(D)

or ( )

Denotes IPT Dimension

Laminated Copy in circulation - rev B  
Customer: See process card  
File saved in folder named below

**APPROVED**

3	50020-3001-008-01_DWG	1
2	50020-3001-007-01_DWG	1
1	50020-3001-005-01_DWG	1
PC NO	PART NAME	QTY

	Released: Frank Digan			Date: 04/09/2020	
		Name	Date		
	Drawn	B.Barry	04/09/2020		
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: $\pm 0.5^\circ$ GENERAL MACHINE: $\pm 0.10$ SHEET METAL: $\pm 0.5$ INTERPRET GEOMETRIC TOLERANCING PER: ASME Y14.5					
Title <b>Wheel Shaft - Welded ASM</b>					
Size      Drawing No.      Rev					
A3      50020-3001-008 W ASM_dwg      B					
Scale NTS		Standard Washer Racks		Sheet 1 of 1	