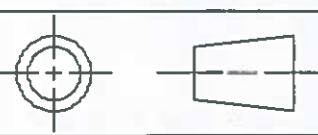
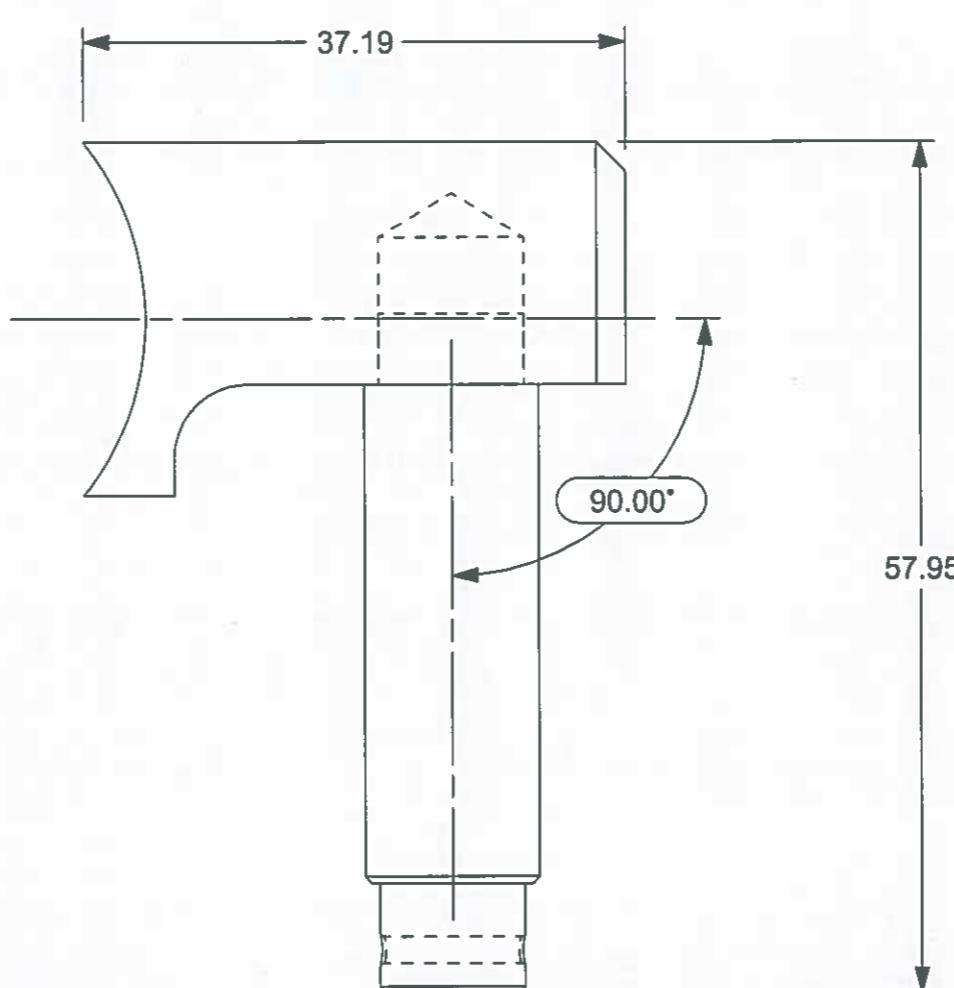
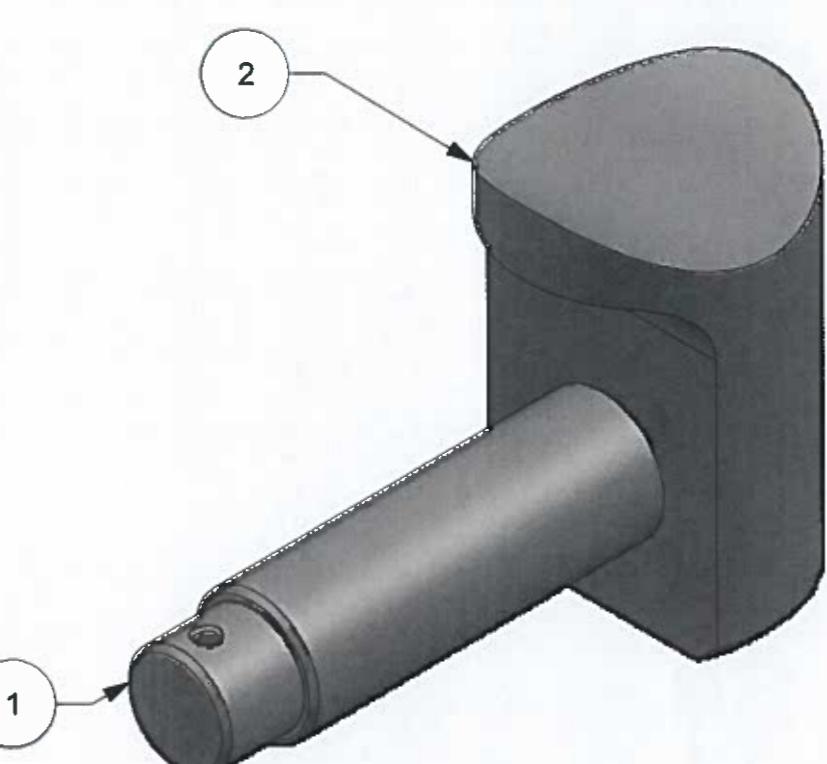
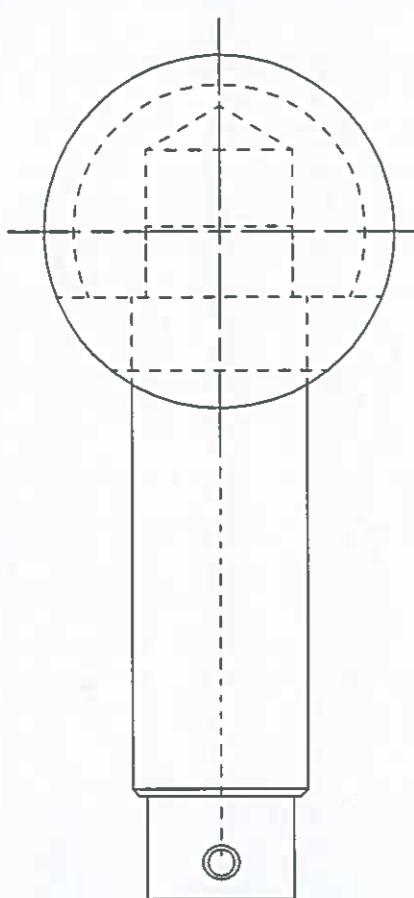
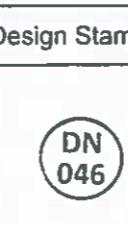


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<p>Biobore Tube/ Stainless Part Requirements - SF1:</p> <ul style="list-style-type: none"> -- Any blemishes such as porosity, pinholes, undercutting, cracks, are not permitted on any surface of the part. See Table SF-2.2-1 in ASME BPE 2016 (page 231) 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). -- 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. 																																																																															
<p>Design Review Checks</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 15%;">Chamfers</td><td style="width: 15%;">Yes</td><td style="width: 15%;">No</td></tr> <tr> <td>Engraving</td><td></td><td></td></tr> <tr> <td>Material</td><td></td><td></td></tr> <tr> <td>Finish</td><td></td><td></td></tr> <tr> <td>Quantity</td><td></td><td></td></tr> <tr> <td>TE No.</td><td></td><td></td></tr> <tr> <td>Job No.</td><td></td><td></td></tr> <tr> <td>Revision No.</td><td></td><td></td></tr> <tr> <td>Customer Name</td><td></td><td></td></tr> <tr> <td>IPT</td><td></td><td></td></tr> <tr> <td>BOM</td><td></td><td></td></tr> <tr> <td>dx/iges</td><td></td><td></td></tr> <tr> <td>Loc. holes/slots offset</td><td></td><td></td></tr> <tr> <td>Loc. holes/slots tol.</td><td></td><td></td></tr> <tr> <td>Thread details</td><td></td><td></td></tr> <tr> <td>Assembly part list</td><td></td><td></td></tr> <tr> <td>Parts/fittings sourced</td><td></td><td></td></tr> <tr> <td>All assembly ok</td><td></td><td></td></tr> <tr> <td>Correspondence</td><td></td><td></td></tr> </table> <p>F</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 15%;">Job No.</td><td colspan="2">See Process Card</td></tr> <tr> <td>Quantity</td><td colspan="2">See Process Card</td></tr> <tr> <td>Material</td><td colspan="2">316L Stainless Steel</td></tr> <tr> <td>Finish</td><td colspan="2">Polish below 0.5Ra</td></tr> <tr> <td colspan="3"> <input checked="" type="checkbox"/> () Denotes IPT Dimension </td></tr> </table>								Chamfers	Yes	No	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	Polish below 0.5Ra		<input checked="" type="checkbox"/> () Denotes IPT Dimension		
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APPROVED

	Released: Frank Digan			Date: 04/09/2020
	Drawn	Name	Date	
	Checked	M Looram	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: ± 0.10 SHEET METAL: ± 0.5 INTERPRET GEOMETRIC TOLERANCING PER: ASME Y14.5				Title
Size	Drawing No.			Rev
A3	50020-3001-009 W ASM_dwg			B
Scale	NTS	Standard Washer Racks		Sheet 1 of 1