

REVISION HISTORY		
DATE	DESCRIPTION	REV
18/05/2020	ORIGINAL RELEASE	A
04/09/2020	Standard Approved Drawing Format	B

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

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

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

APPROVED

Design Stamp		Released: Frank Digan			Date: 04/09/2020		
		Name	Date				
	Drawn	B. Barry	04/09/2020				
	Checked	M Loomam	04/09/2020				
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		DIMENSIONS ARE IN mm		Wheel Shaft - Welded ASM			
		TOLERANCES: ANGULAR: ± 0.5°		Size	Drawing No.		Rev
		GENERAL MACHINE: ±0.10 SHEET METAL: ±0.5		A3	50020-3001-008 W ASM_dwg		B
		INTERPRET GEOMETRIC TOLERANCING PER: ASME Y14.5		Scale	NTS	Standard Washer Racks	
				Sheet 1 of 1			