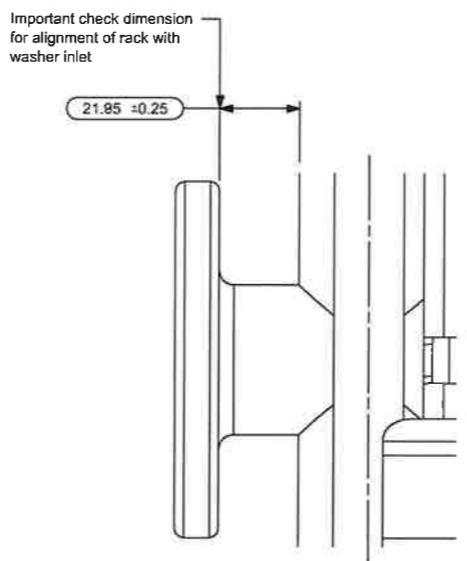
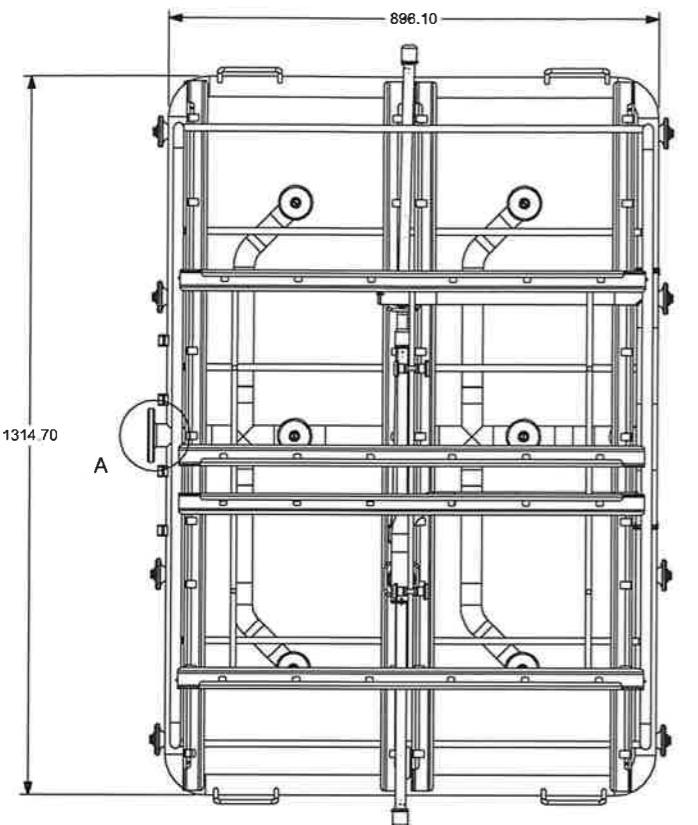


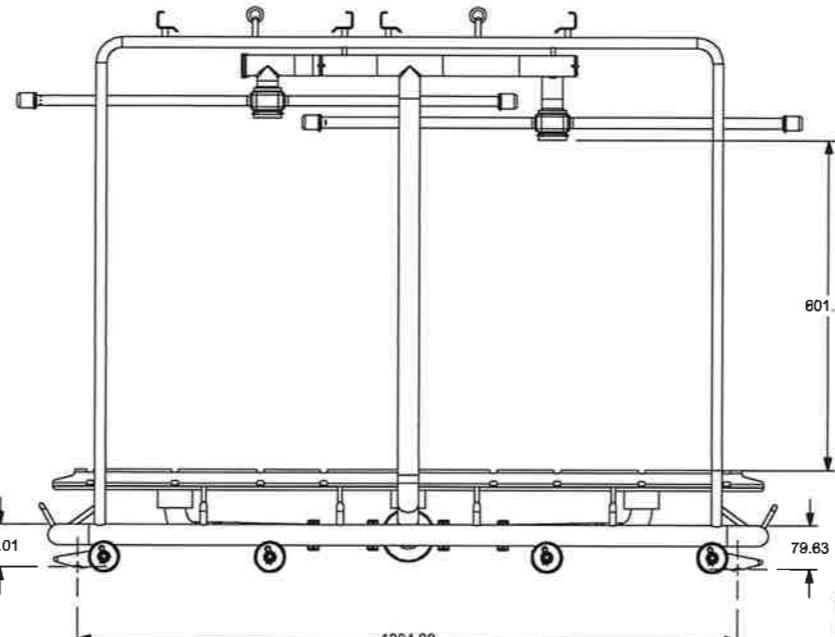
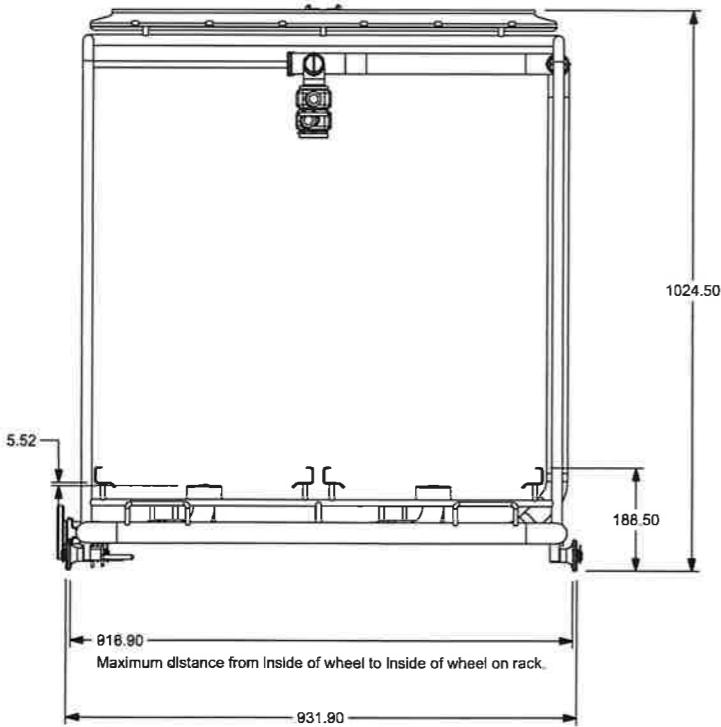
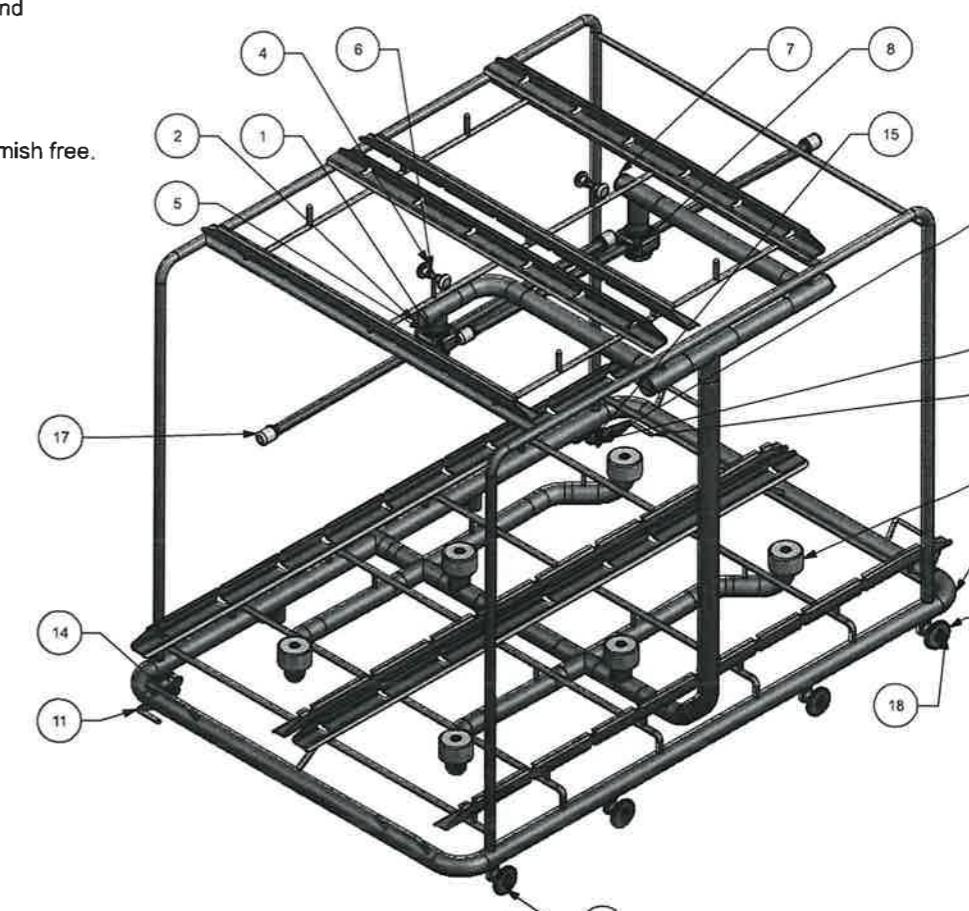
REVISION HISTORY		
DATE	DESCRIPTION	REV
19/03/2024	ORIGINAL RELEASE	A

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.



DETAIL A
SCALE 1:1



Latches & wheels to be checked on
jig 50011-020.

Preferred Material Blank Size See Parts

APPROVED

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

Design Stamp		Released: O.Fitzgerald			Date: 19/03/2024
DN 050		Name	Date		
Drawn	M.Looman	19/03/2024			
Checked	C.Gilsenan	19/03/2024			
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		Main Rack for Belimed PH860 - Top Tier - No Manifolds			
Size	Drawing No.		Rev		
A3	50020-3031 ASM_dwg				
Scale	NTS	Standard Washer Racks		Sheet 1 of 1	

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	50020-3016-01_DWG	2
15	50020-3006-003_DWG	2
14	50020-3006-002_DWG	1
13	50020-3006-001_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	50000-1800-188_DWG	4
3	50000-1800-188 ASM_DWG	6
2	50000-1800-145 ASM_DWG	4
1	50000-1202-010_DWG	2
PC NO	PART NAME	QTY

teg