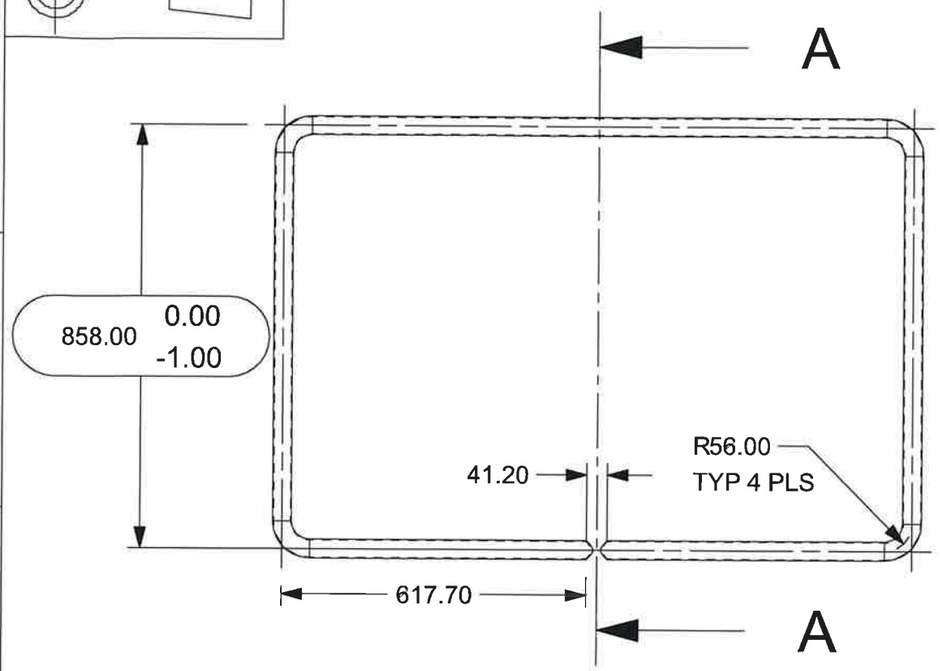
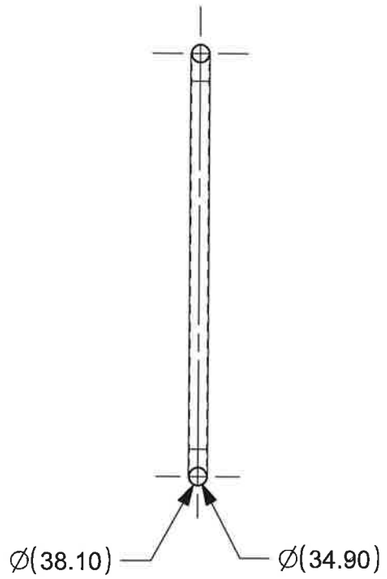
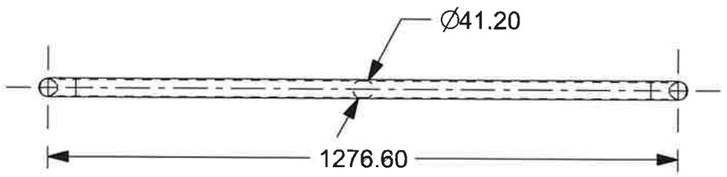
REVISION HISTORY		
DATE	DESCRIPTION	REV
10/02/2020	ORIGINAL RELEASE	A
09/09/2022	Standard Approved Drawing Format	B

( )





SECTION A-A



No water runs through this tube.
External Surface polished to 0.5 Ra

Laminated Copy in circulation - Rev B

Customer: See process card
File saved in folder named below

1.5 inch Tube
316L Stainless Steel
SF1 Finish

Bar Straight Length 4465.8584
Cut to length after folding.

APPROVED

OV Dairy Tube
Material Billet Size: 1.5" Tube x 4480mm

Design Review Checks	Yes	No
Chamfers		
Engraving		
Material		
FInish		
Quantity		
TE No.		
Job No.		
Revision No.		
Customer Name		
IPT		
BOM		
dxf/iges		
Digitised data		
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	SF1

D or ( ) Denotes IPT Dimension

Biobore Tube/ Stainless Part Machining Requirements - Frame tubing - No water internally (SF1 & SF4)

-Any blemishes such as porosity, pinholes, undercutting, cracks, are not permitted on any external 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.
-Internal Surface roughness max. = no polishing requirements - hidden.
-External Surface roughness max. = 0.8 micro meter RA (SF1).
-All deburring to be completed as per WI - 150 - 0038 for SF1 requirements.
-Engineer to be informed if the dimensional tolerances cannot be achieved prior to manufacturing.
-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	1.5" Tube x 4480mm

Design Stamp	Released: Michael Williams		Date: 09/09/2022
DN 047		Name	Date
	Drawn	S.Egan	10/02/2020
	Checked	C.Gilsenan	10/02/2020

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

1.5" Tubing - Outer Ring

Size	Drawing No.	Rev
A3	50020-3014-005_dwg	B

Scale NTS | Standard Washer Racks | Sheet 1 of 1