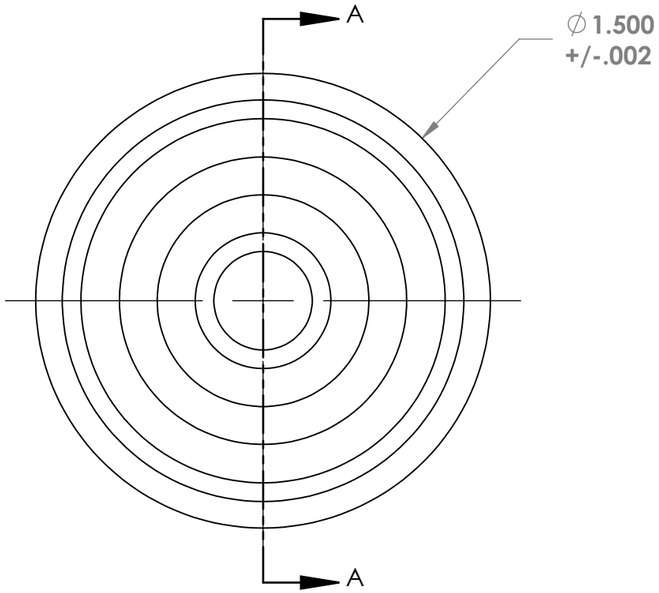
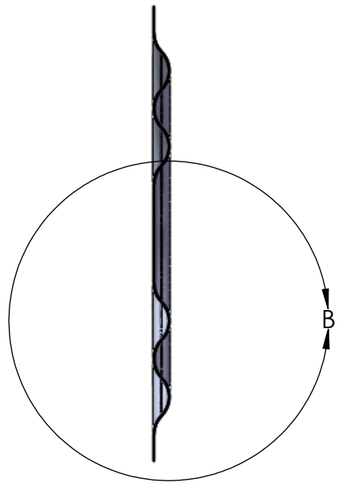
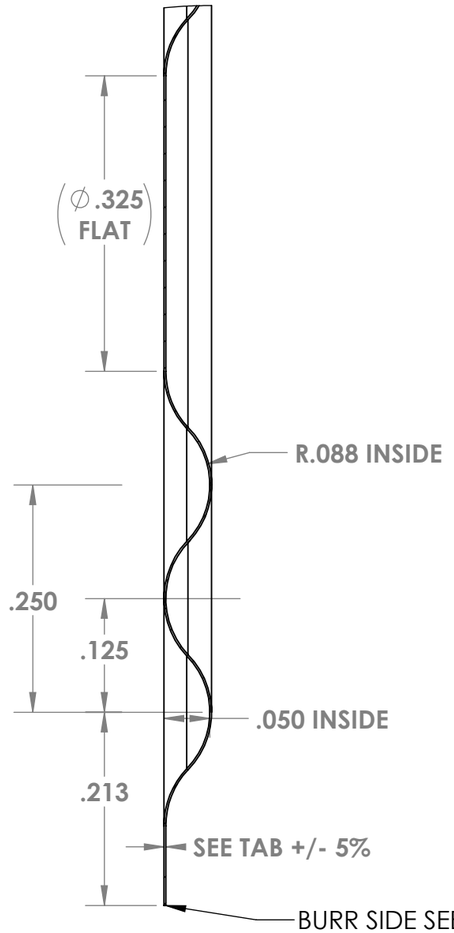
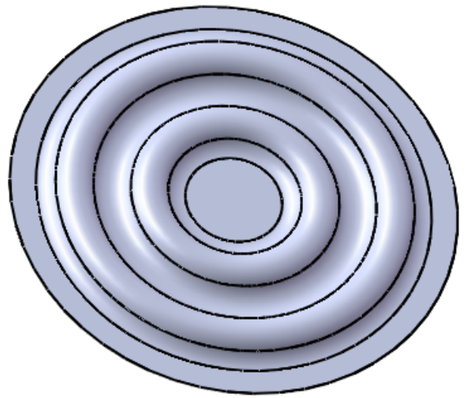



SECTION A-A




RIPPLE DETAIL B
SCALE 6 : 1



GENERAL NOTES:

1) BURR TO BE 30% OF MATERIAL THICKNESS
2) MAX CAMBER (POTATO CHIPPING) OF 2% OF OD
3) ALL RIPPLE DIMENSIONS IN VIEW B ARE TOOL CONTROLLED
4) MANUFACTURE DIAPHRAGM FROM TOOL T-LSHP-1.500
5) DINGS AND DENTS  ACCEPTABLE IF DETECTED ON ONE SIDE ONLY
6) DIAPHRAGMS TO BE NESTED AND PACKED TO AVOID DAMAGE

| TAB | Part Name | Diameter | Thickness | Material | Specification | Deflection * |
|---|---|---|---|---|---|---|
| -1 | LSHP1.500-0020-718 | 1.500 | 0.002 | IC718 | AMS-5596 | 0.004 |
| -2 | LSHP1.500-0030-316 | 1.500 | 0.003 | SS316L | AMS-5507 | 0.002 |
| -3 | LSHP1.500-0030-625 | 1.500 | 0.003 | IC625 | AMS-5599 | 0.001 |
| -4 | LSHP1.500-0030-718 | 1.500 | 0.003 | IC718 | AMS-5596 | 0.001 |

* Deflections Listed are at 1 psi and for reference only. Full range of deflections are available.

| | NAME | DATE |
|---|---|---|
| DRAWN | WAGNER | 8-18-15 |
| CHECKED | DEBONE | 8-19-15 |
| ENG APPR. | | |
| MFG APPR. | | |
| Q.A. | | |

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/32
ANGULAR: MACH ±  BEND ±
TWO PLACE DECIMAL  ± .015
THREE PLACE DECIMAL  ± .005

INTERPRET GEOMETRIC TOLERANCING PER: ASME Y14.5M94

DO NOT SCALE DRAWING

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TITLE: Metal Diaphragm

Hudson Technologies

| SIZE | DWG. NO. | REV |
|---|---|---|
| B | LSHP1.500-TAB | B |

SCALE: 2:1 | WEIGHT: | SHEET 1 OF 1