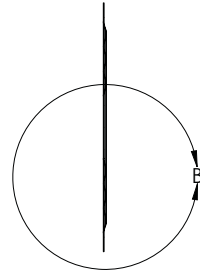
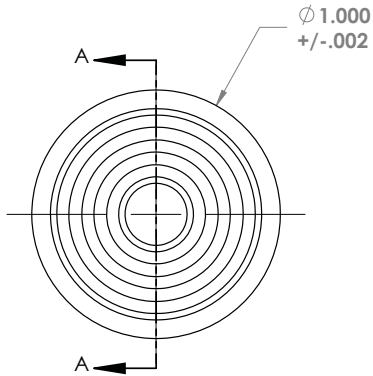


4

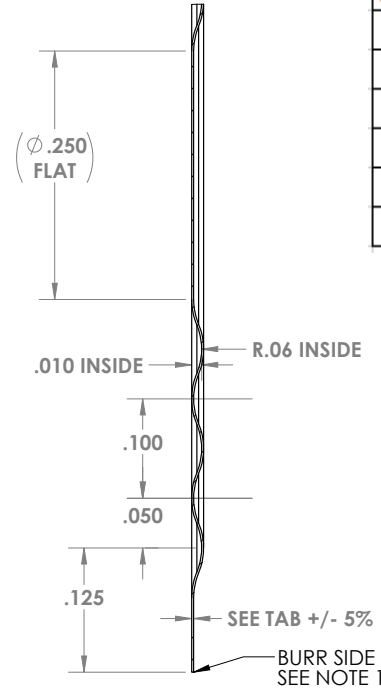
3

2

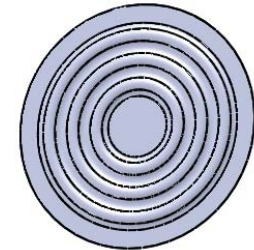
1



SECTION A-A

DETAIL B  
SCALE 8 : 1

| REV | DESCRIPTION                     | DATE      | INITIALS |
|-----|---------------------------------|-----------|----------|
| C   | DEFLECTION CALCULATIONS UPDATED | 7/21/2017 | JD       |
|     |                                 |           |          |
|     |                                 |           |          |
|     |                                 |           |          |
|     |                                 |           |          |
|     |                                 |           |          |



## 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-HSLP-1.000
- 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  | HSLP1.000-0020-316 | 1.000    | 0.002     | SS316L   | AMS-5507      | 0.0033       |
| -2  | HSLP1.000-0020-718 | 1.000    | 0.002     | IC718    | AMS-5596      | 0.0031       |
| -3  | HSLP1.000-0030-316 | 1.000    | 0.003     | SS316L   | AMS-5507      | 0.0017       |
| -4  | HSLP1.000-0030-625 | 1.000    | 0.003     | IC625    | AMS-5599      | 0.0015       |
| -5  | HSLP1.000-0030-718 | 1.000    | 0.003     | IC718    | AMS-5596      | 0.0016       |

\* Deflections listed at 1.0 psi are simulated results. Actual results may vary.

UNLESS OTHERWISE SPECIFIED:  
 DIMENSIONS ARE IN INCHES  
 TOLERANCES:  
 FRACTIONAL  $\pm 1/32$   
 ANGULAR: MACH  $\pm$  BEND  $\pm$   
 TWO PLACE DECIMAL  $\pm .015$   
 THREE PLACE DECIMAL  $\pm .005$   
 INTERPRET GEOMETRIC  
 TOLERANCING PER: ASME Y14.5M94  
 DO NOT SCALE DRAWING

|                                                                                                                                                                                                                                                          |                           |                        |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|------------------------|
| NAME                                                                                                                                                                                                                                                     | DATE                      | TITLE: Metal Diaphragm |
| DRAWN WAGNER                                                                                                                                                                                                                                             | 9-21-15                   |                        |
| CHECKED DEBONE                                                                                                                                                                                                                                           | 9-22-15                   |                        |
| ENG APPR.                                                                                                                                                                                                                                                |                           |                        |
| MFG APPR.                                                                                                                                                                                                                                                |                           |                        |
| Q.A.                                                                                                                                                                                                                                                     |                           |                        |
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| SIZE<br><b>B</b>                                                                                                                                                                                                                                         | DWG. NO.<br>HSLP1.000-TAB | REV<br><b>C</b>        |
| SCALE: 2:1                                                                                                                                                                                                                                               | WEIGHT:                   | SHEET 1 OF 1           |

**HUDSON** **DEEP** **DRAW**  
 A PRECISION Company

4

3

2

1