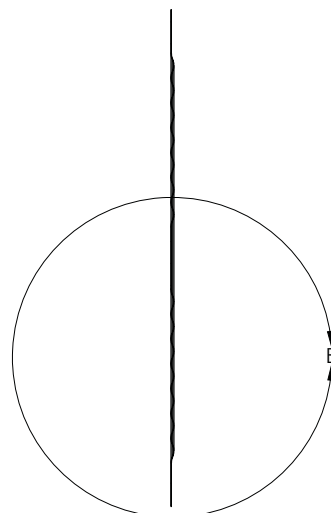
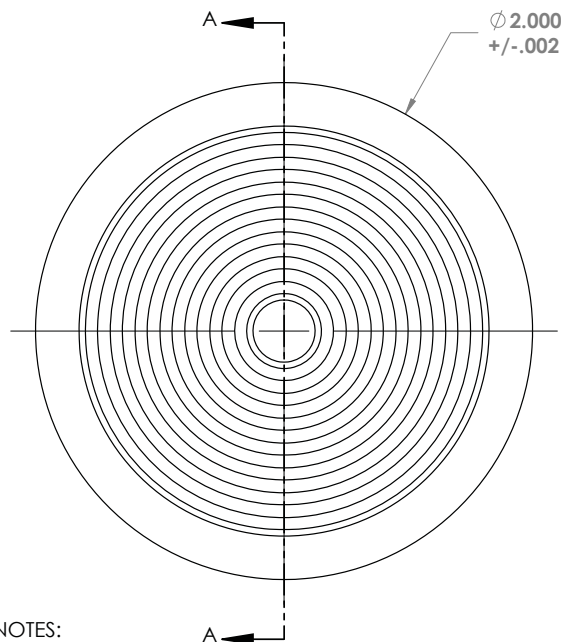


4

3

2

1



SECTION A-A

(ϕ .250
FLAT)

.05 Typ.

.100 Typ.

.225

R.06 INSIDE

.010 INSIDE

SEE TAB +/- 5%

BURR SIDE SEE NOTE 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-2.000
- 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	HSLP2.000-0020-316	2.000	0.002	SS316L	AMS-5507	0.0277
-2	HSLP2.000-0020-718	2.000	0.002	IC718	AMS-5596	0.0269
-3	HSLP2.000-0030-316	2.000	0.003	SS316L	AMS-5507	0.0169
-4	HSLP2.000-0030-625	2.000	0.003	IC625	AMS-5599	0.0161
-5	HSLP2.000-0030-718	2.000	0.003	IC718	AMS-5596	0.0164

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

DETAIL B
SCALE 6 : 1

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	8-18-15	
CHECKED DEBONE	8-19-15	
ENG APPR.		
MFG APPR.		
Q.A.		
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SIZE B	DWG. NO. HSLP2.000-TAB	REV C
SCALE: 2:1	WEIGHT:	SHEET 1 OF 1

HUDSON DEEP DRAW
A PRECISION Company