

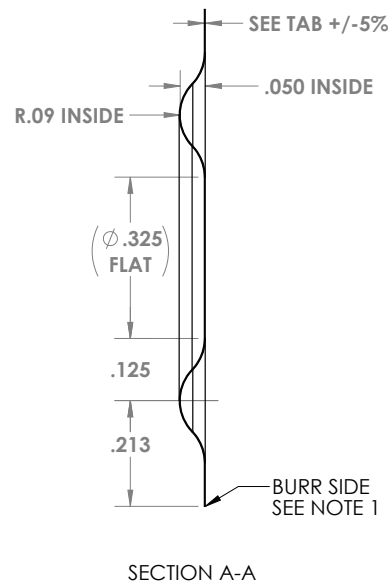
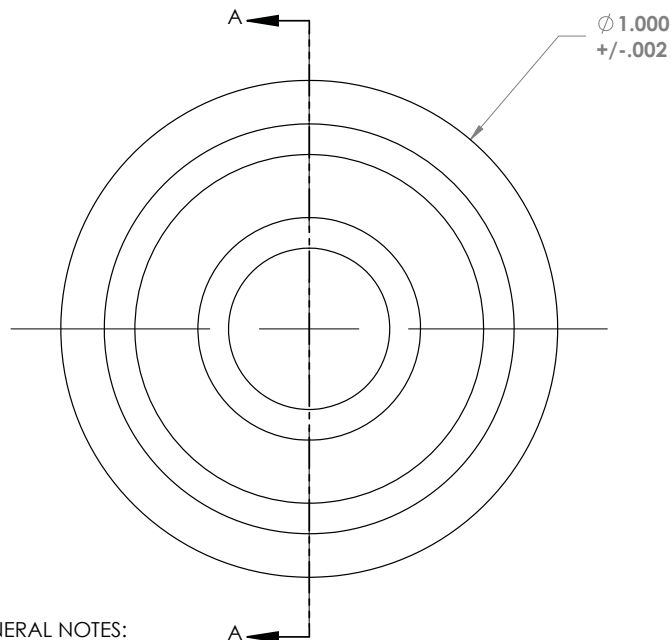
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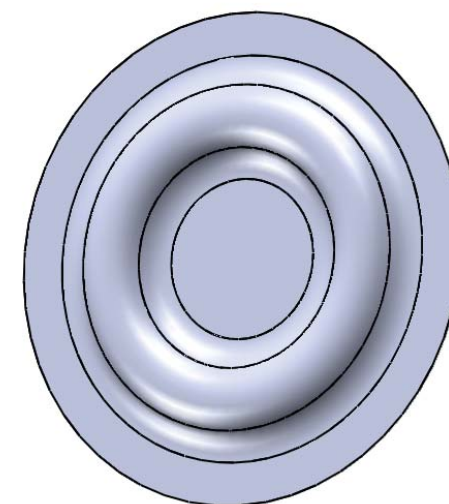
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REV	DESCRIPTION	DATE	INITIALS
C	DEFLECTION CALCULATIONS UPDATED	7/21/2017	JD



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-LSHP-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	LSHP1.000-0020-718	1.000	0.002	IC718	AMS-5596	0.0024
-2	LSHP1.000-0030-316	1.000	0.003	SS316L	AMS-5507	0.0004
-3	LSHP1.000-0030-625	1.000	0.003	IC625	AMS-5599	0.0004
-4	LSHP1.000-0030-718	1.000	0.003	IC718	AMS-5596	0.0004

* 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	9-22-15	
CHECKED DEBONE	9-22-15	
ENG APPR.		
MFG APPR.		
Q.A.		
PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF HUDSON TECHNOLOGIES. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF HUDSON TECHNOLOGIES IS PROHIBITED.		
SIZE B	DWG. NO. LSHP1.000-TAB	REV C
SCALE: 4:1	WEIGHT:	SHEET 1 OF 1

HUDSON DEEP
DRAW
A PRECISION Company

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