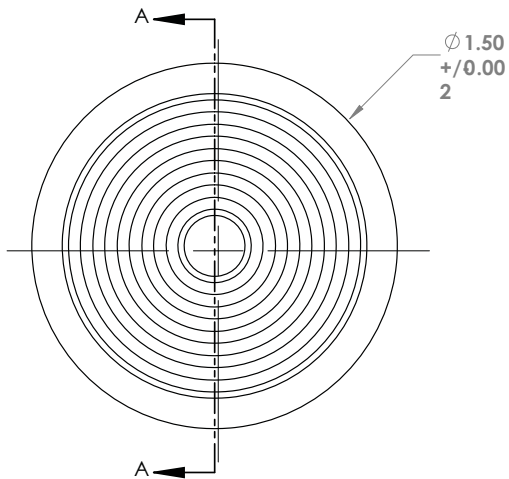
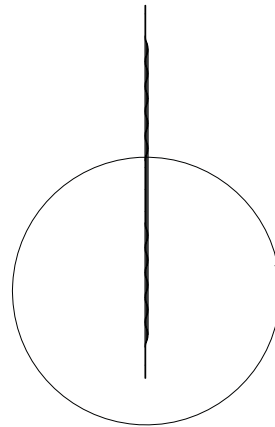


4

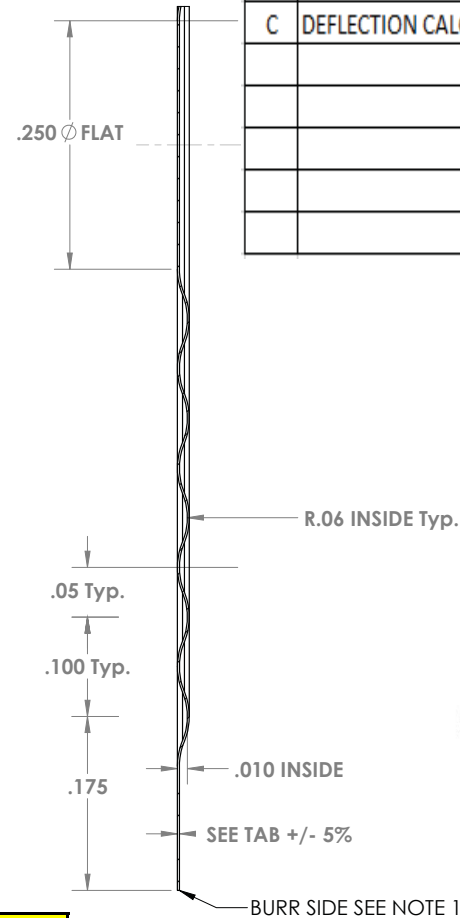
3

2

1


 $\phi 1.50$   
 $+0.00$   
 2


SECTION A-A

.250  $\phi$  FLAT

R.06 INSIDE Typ.

.05 Typ.

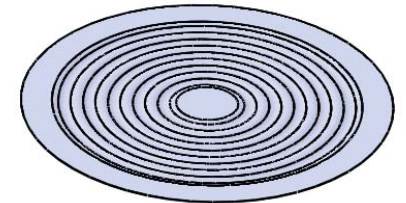
.100 Typ.

.175

.010 INSIDE

SEE TAB +/- 5%

BURR SIDE SEE NOTE 1

RIPPLE 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-1.500
- 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	HSLP1.500-0020-316	1.500	0.002	SS316L	AMS-5507	0.0130
-2	HSLP1.500-0020-718	1.500	0.002	IC718	AMS-5596	0.0124
-3	HSLP1.500-0030-316	1.500	0.003	SS316L	AMS-5507	0.0072
-4	HSLP1.500-0030-625	1.500	0.003	IC625	AMS-5599	0.0067
-5	HSLP1.500-0030-718	1.500	0.003	IC718	AMS-5596	0.0068

\* 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:
DRAWN WAGNER	8-15-15	Metal Diaphragm
CHECKED DEBONE	8-17-15	
ENG APPR.		
MFG APPR.		
Q.A.		

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SIZE <b>B</b>	DWG. NO. HSLP1.500-TAB	REV <b>C</b>
SCALE: 2:1 WEIGHT:		SHEET 1 OF 1

4

3

2

1