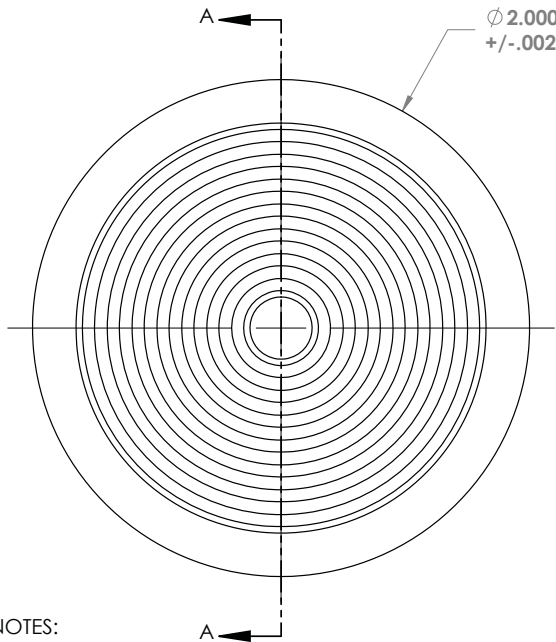
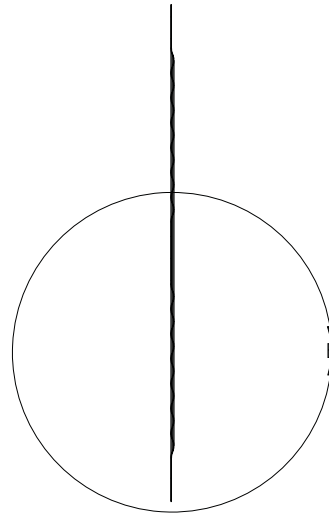


4

3

2

1


 $\phi 2.000$   
 $\pm .002$ 


SECTION A-A

 $(\phi .250)$   
 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: 1/32  
 ANGULAR: MACH ± BEND ±  
 TWO PLACE DECIMAL ± .015  
 THREE PLACE DECIMAL ± .005  
 INTERPRET GEOMETRIC  
 TOLERANCING PER: ASME Y14.5M94  
 DO NOT SCALE DRAWING

NAME	DATE	TITLE:
WAGNER	8-18-15	Metal Diaphragm
DEBONE	8-19-15	
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 DWG. NO. <b>B</b> HSLP2.000-TAB
SCALE: 2:1 WEIGHT:		REV <b>C</b> SHEET 1 OF 1

4

3

2

1