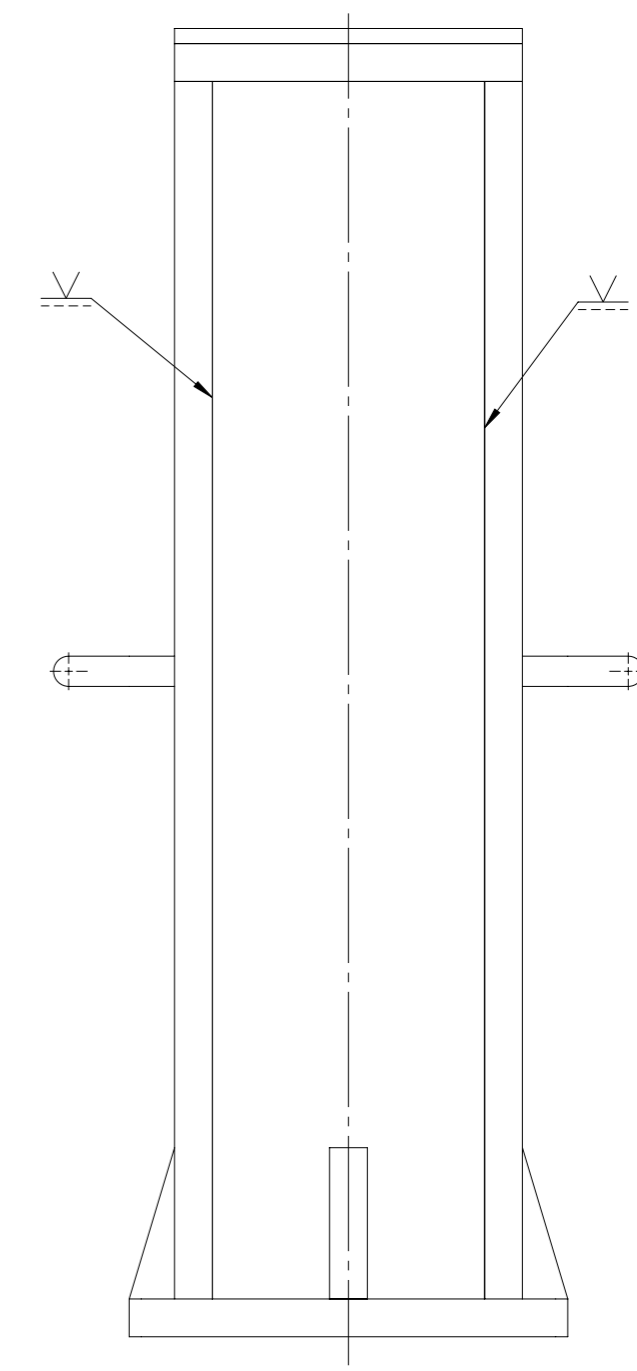
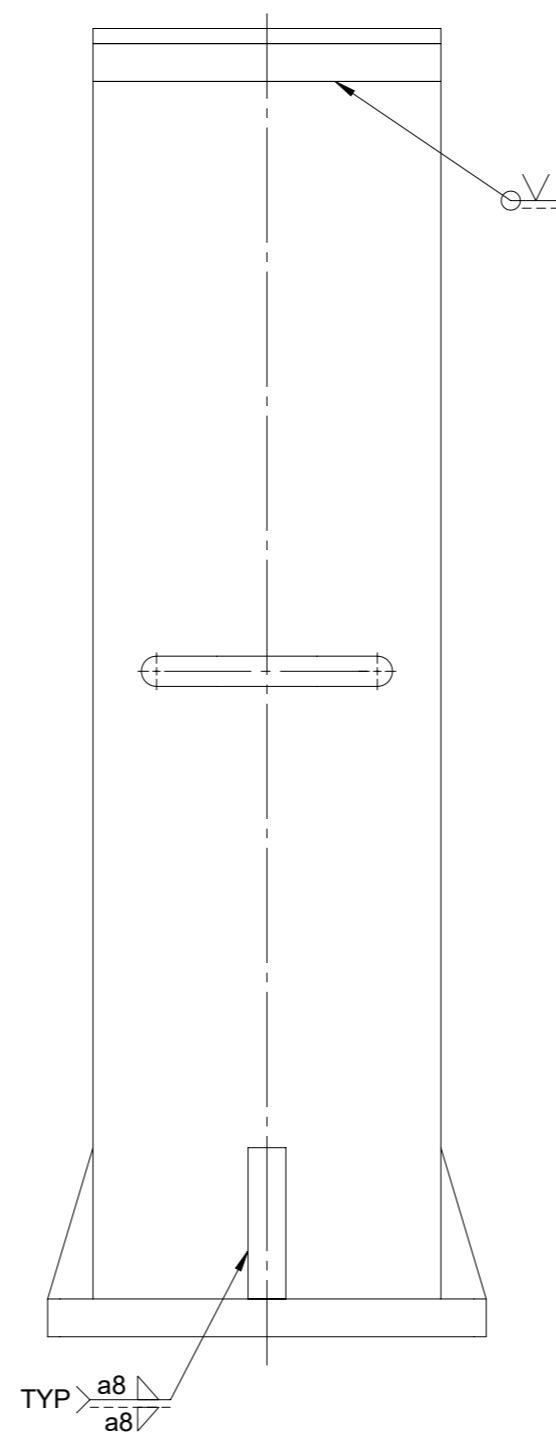
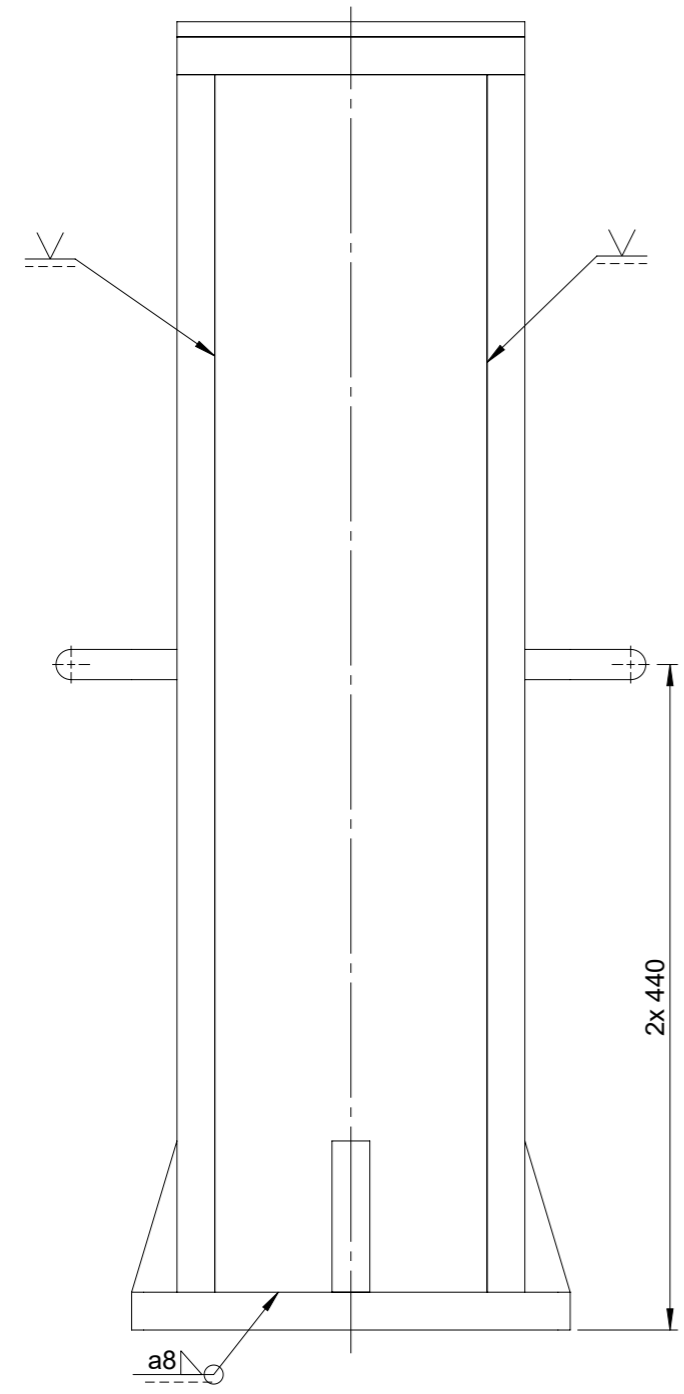
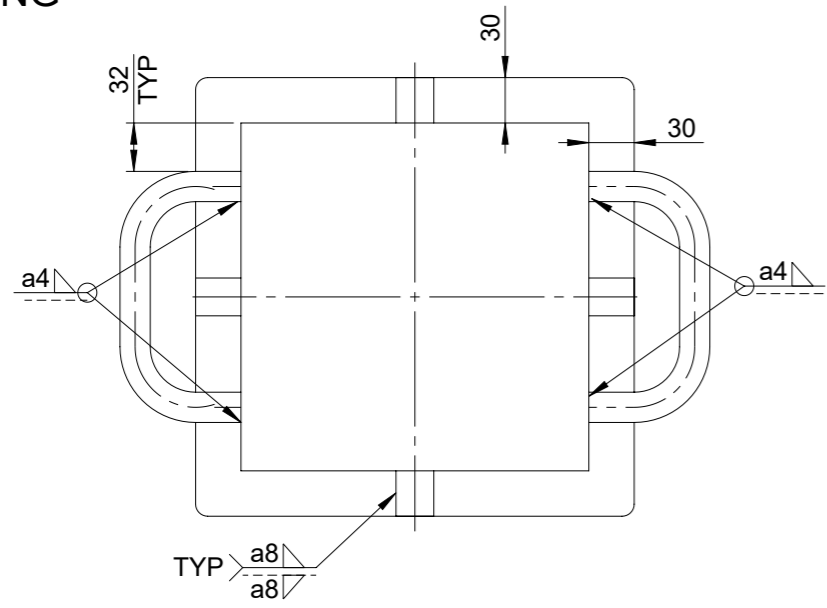


- NOTES:**
1. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETRES  
ALL STANDARDS REFERRED TO SHALL BE THE CURRENT ISSUE.
  2. TOLERANCING ISO 8015.  
GENERAL WELDING TOLERANCES ISO 13920-BF
  3. UNLESS OTHERWISE SPECIFIED:  
DEBURR EXTERNAL EDGES AND CORNERS.
  4. ALL WELDING ACCORDING TO NORSOK M-102  
STRUCTURE ALUMINIUM FABRICATION, INSPECTION CLASS D.
  5. PROCESS SPECIFICATION AS PER MDP REPORT FOR REFERRED MATERIAL NUMBER
  6. TRACEABILITY MARKING  
USE LOW STRESS PERMANENT MARKING
  7. ITEM 7 SHALL BE ATTACHED TO ITEM 4 WITH STRONG ADHESIVE.
  8. USE THE HANDLE ONLY FOR LIFTING OF THE TEST STAND

ITEM NO.	QTY.	DESCRIPTION	MATERIAL	WEIGHT (KG)
1	1	PLATE, 25 x 290 x 290	Al 6082-T6	5.87
2	2	PLATE, 25 x 230 x 805	Al 6082-T6	12.96
3	2	PLATE, 25 x 180 x 805	Al 6082-T6	10.14
4	1	PLATE, 25 x 230 x 230	Al 6082-T6	3.70
5	4	PLATE, 25 x 30 x 100	Al 6082-T6	0.10
6	2	ROD $\phi$ 20	Al 6082-T6	0.22
7	1	PLATE, 10 x 230 x 230	PTFE	1.16

<b>Proprietary information</b> This document contains confidential information that is the property of OneSubsea. Receipt or possession does not convey any rights to disclose, reproduce or use same for any purpose other than that granted by prior agreement or express written permission of OneSubsea	<b>Title</b> TIE-IN STAND 865 MM HEIGHT, WORKSHOP USE WELDING / MACHINING				
	<b>Modified by</b> SUSHMA, SIRIKONDA	<b>Originator</b> SUSHMA, SIRIKONDA	<b>Document no.</b> 10009026086	<b>Doc. ver.</b> 00	<b>ECO no.</b> 00
	<b>Checked by</b> CHAUDHARI, MUKESH	<b>Material no. (part)</b> 10389074	<b>Plant</b> 160	<b>Release date</b> 28.10.2024	<b>Reason for issue</b> IFC
	<b>Approved by</b> AGNIHOTRI, NIKHIL	<b>Material spec.</b> SEE CUTLIST		<b>Estimated Weight</b> 58 kg	<b>Size</b> A3

WELDING



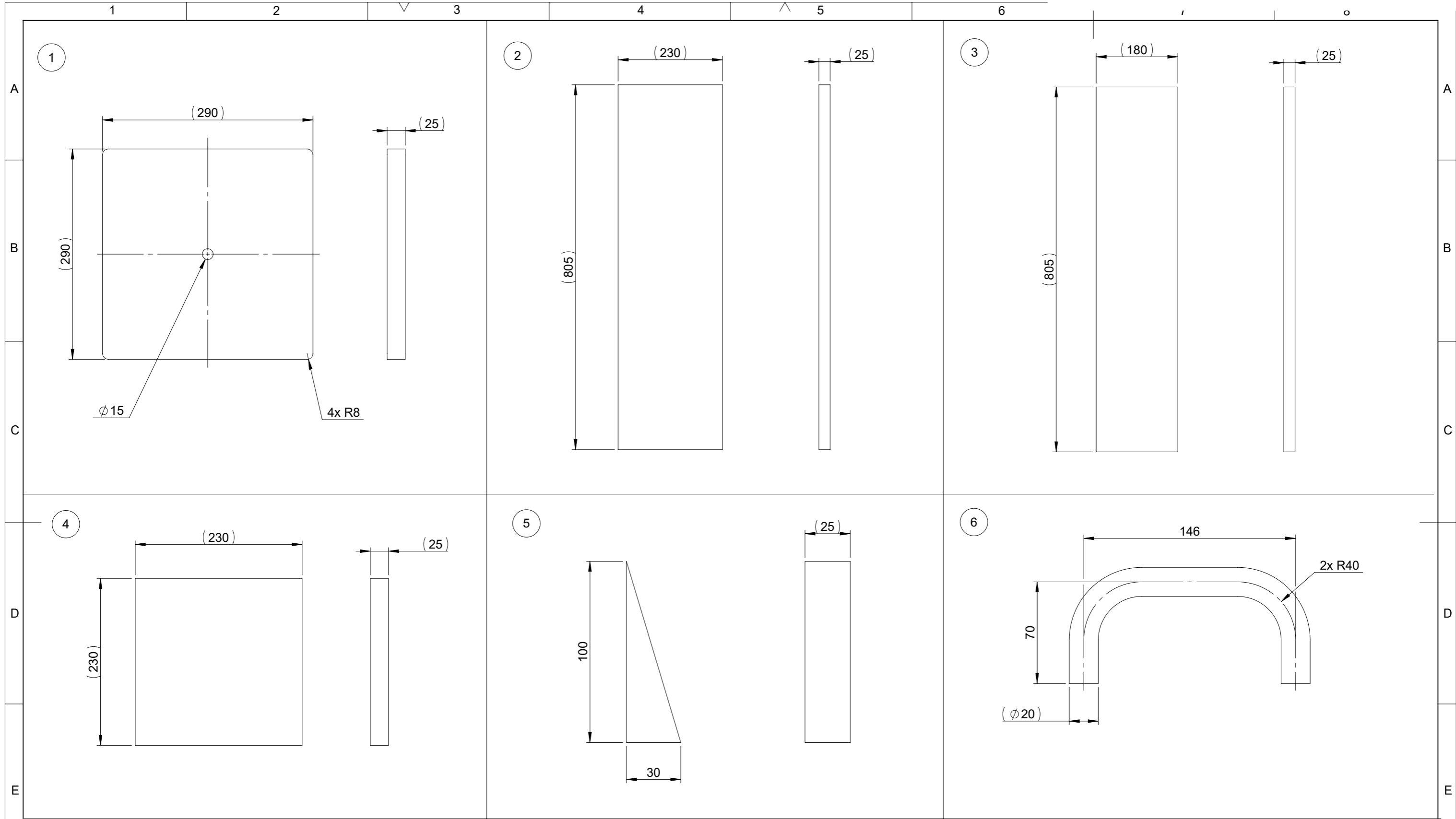
Welding dimensional tolerances ISO 13920-BF (millimetres)	Linear dimensions	
	Range	Tol
	2-30	±1
	>30-400	±2
	>400-1000	±3
	>1000-2000	±4
	>2000-4000	±6
	>4000-8000	±8
	>8000-12000	±10
	>12000-16000	±12
	>16000-20000	±14
	>20000	±16

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Title <b>TIE-IN STAND 865 MM HEIGHT, WORKSHOP USE WELDING / MACHINING</b>			
Modified by <b>SUSHMA, SIRIKONDA</b>	Originator <b>SUSHMA, SIRIKONDA</b>	Document no. <b>10009026086</b>	Doc. ver. <b>00</b>
Checked by <b>CHAUDHARI, MUKESH</b>	Material no. (part) <b>10389074</b>	Plant <b>160</b>	Release date <b>28.10.2024</b>
Approved by <b>AGNIHOTRI, NIKHIL</b>	Material spec. <b>SEE CUTLIST</b>	Estimated Weight <b>-</b>	Reason for issue <b>IFC</b>

slb One Subsea

Reason for issue <b>IFC</b>	Size <b>A3</b>	Sheet no. <b>2 of 3</b>
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F	1	2	3	4	5	6	7	8	<b>Tolerancing according to ISO 8015, ISO 1101</b> Dimensions without individual tolerance indications: ISO 2768-mK See ISO 2768 part 1 and 2 for more information ISO 2768-K (features)		<b>Proprietary information</b> This document contains confidential information that is the property of OneSubsea. Receipt or possession does not convey any rights to disclose, reproduce or use same for any purpose other than that granted by prior agreement or express written permission of OneSubsea		Title <b>TIE-IN STAND 865 MM HEIGHT, WORKSHOP USE WELDING / MACHINING</b>											
									ISO 13715 √ Ra 3,2 (✓) -0.4 / -0.8 / +0.4 / +0.8		<b>Linear dimensions</b> Range Tol 0.5-3 ±0.1 >3-6 ±0.1 >6-30 ±0.2 >30-120 ±0.3 >120-400 ±0.5 >400-1000 ±0.8 >1000-2000 ±1.2 >2000-4000 ±2		<b>External radii and chamfer heights</b> Range Tol 0.5-3 ±0.2 >3-6 ±0.5 >6 ±1 <math>\le 10</math> ±1° >10-50 ±0°30' >50-120 ±0°20' >120-400 ±0°10' >400 ±0°05'		Modified by <b>SUSHMA, SIRIKONDA</b>		Originator <b>SUSHMA, SIRIKONDA</b>		Document no. <b>10009026086</b>		Doc. ver. <b>00</b>		ECO no.	
									Range ∇ ⊥ = ∠ ≤ 10 0.05 >10-30 0.1 0.4 0.6 >30-100 0.2 >100-300 0.4 0.6 >300-1000 0.8 0.8 0.8 >1000-3000 0.8 1 1		<b>Angular dimensions</b> Range Tol <math>\le 10</math> ±1° >10-50 ±0°30' >50-120 ±0°20' >120-400 ±0°10' >400 ±0°05'		Checked by <b>CHAUDHARI, MUKESH</b>		Material no. (part) <b>10389074</b>		Plant <b>160</b>		Release date <b>28.10.2024</b>		Reason for issue <b>IFC</b>		Estimated Weight	
									Approved by <b>AGNIHOTRI, NIKHIL</b>		Material spec. <b>SEE CUTLIST</b>		Size <b>A3</b>		Sheet no. <b>3 of 3</b>									