**Approved By:**

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| Susan Paterson  Quality Engineer  Brent Ave |  | Linn Falt  QMS Leader (covering)  Brent Ave |

(Electronic Approval Records kept within Agility)

**Applicability:**

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Applicable Product Lines Applicable to Tollgate Process?** | | | | |
| Subsea Production Systems (SPS) | | |  |  |
|  | Trees | Controls | Drilling | Yes (details in section 2.0) |
|  | MCS | Projects | Services & Offshore | No |
|  | | | Wellstream |  |

**Document Revision Chart:**

The following chart lists the revisions made to this document tracked by version.

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Rev** | **Section modified and revision description** | **Issue date** | **Expiry date** | **Author(s)** |
| 1.0 | New Guideline | 07.07.2016 | 07.07.2019 | B. Spence, D. Calder |

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1. Load to table on Vee Blocks as per set-up sheet.

|  |  |
| --- | --- |
|  |  |

1. Ensure component is clocked up as per Datum’s.

|  |  |
| --- | --- |
|  |  |

1. Mill Slot as per program and drawing.
2. Check part with clock to ensure part has not moved, if it has then re-set as per previous steps
3. Spot drill 14off holes.
4. Drill , chamfer and hob the 14off holes.
5. Unload from machine.
6. DO NOT DEBURR HOLES, **VERY IMPORTANT** AS THIS AFFECTS OUTCOME FROM CMM.
7. Pass onto CMM to check.