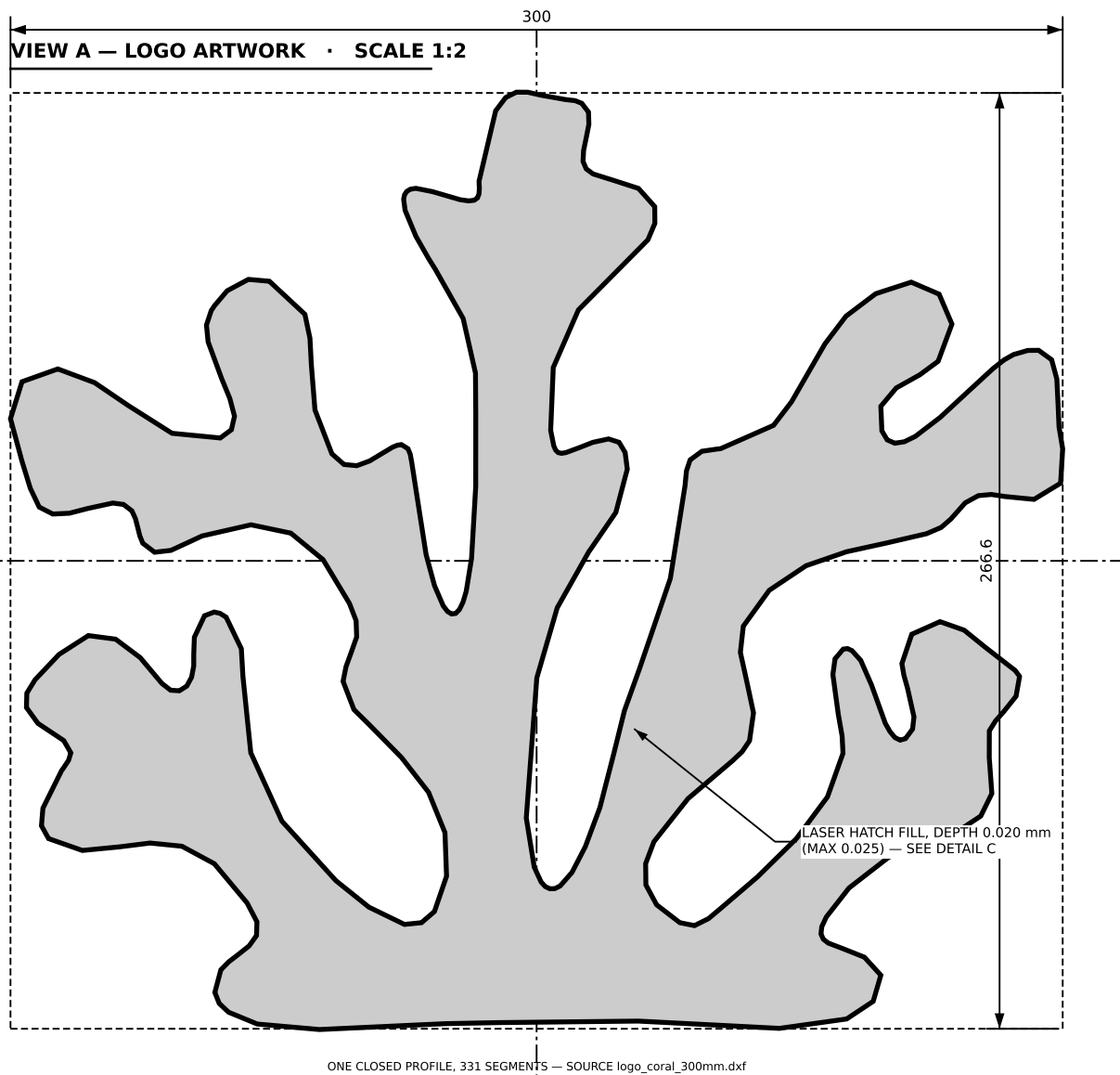
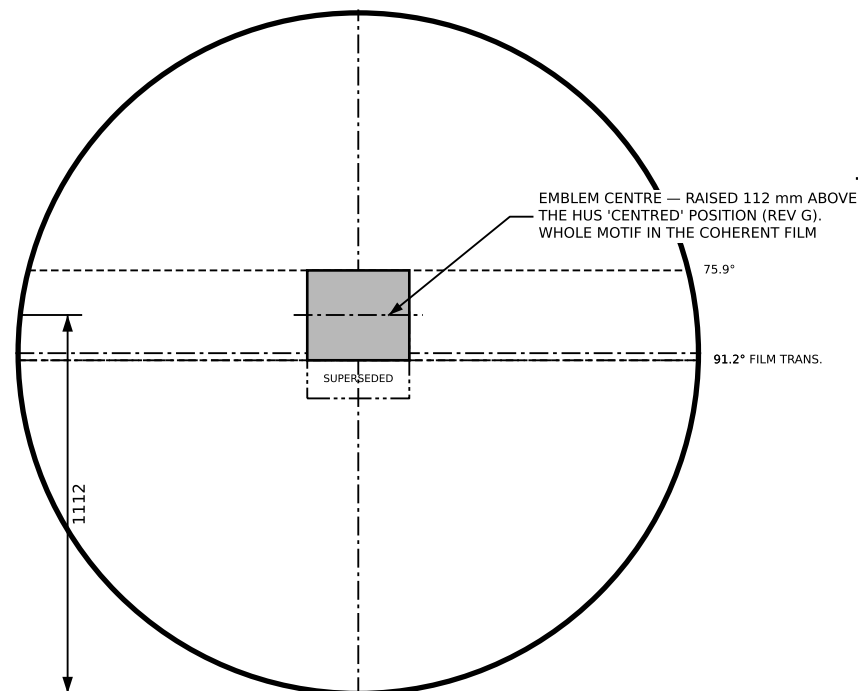




NOTES

1. DEPTH IS SET BY THE WATER FILM, NOT BY THE MARKING PROCESS. The film over the logo band is 0.326-0.366 mm across the operating band (0.344 at 1.00 U/s). The limits $d \leq 0.10$ h (not registered), ≤ 0.30 h (attached) and $\geq h$ (separates) are SCREENING CRITERIA from thin-film-over-topography literature, not validated on this sphere — hence the coupon wet test above, which is a HOLD before the sphere is marked.
2. A separated film is not expected to heal: linear capillary levelling of the spanwise deficit needs ~26 km of travel against 2.1 m available, so a separation would print a dry stripe from the logo to the collector. This is a linear estimate; it is why the depth is capped and why the coupon test must show no streak downstream of the mark.
3. At 0.020 mm no edge treatment is required. If the depth is ever raised above 0.10 mm, every edge must be ramped at least 7 mm (3x the capillary-viscous response length, 2.0 mm).
4. MARK AFTER FORMING, WELDING AND FINAL POLISH. Gore forming stretches the blank and would distort artwork marked flat; welding and polishing would remove it. The surface is doubly curved: over the 300 mm field the sphere sags 11.2 mm, so marking needs a 3-D dynamic-focus galvo or a robot-carried head with focus metrology, qualified on coupons — NOT a flat-film engraving job.
5. Laser marking depletes chromium locally. Passivate the marked zone to ASTM A967 (citric preferred over nitric) and prove it on the SH14 witness coupon before the sphere is marked.
6. A hatched mark reads by texture. Wetted, the film fills the texture and the contrast falls. If the logo must read while the fountain runs, substitute laser COLOUR (oxide) marking at zero depth and re-run the coupon — refer to the designer.
7. POSITION (REV G): the HUS sheet 02/09/26 centres the logo on the sphere (82.4-97.6°), straddling the 91.2° regime transition with the lower 42% in the thinning, sagging film. At Rev G the centre is RAISED 112 mm to polar 83.6° (75.9-91.2°, 979-1243 above paving) so the whole motif sits in the coherent film — owner instruction; HUS TO BE INFORMED. Seam clearance at the top of the logo 104 mm. The coupon wet test still applies.
8. Logo must be centred on a gore, never across a seam. At AZ 180° there is 104 mm clear to each weld. CONFIRM THE PRIMARY VIEWING DIRECTION BEFORE RELEASE.



FPL 0.000
SET OUT: EMBLEM CENTRE 1112 ABOVE FPL · AZ 180° GORE CENTRELINE · POLAR 83.56° · 104 CLEAR TO EACH SEAM

OR BY TAPE ON THE MERIDIAN FROM THE CROWN: 1458 TO CENTRE, 1325 TO TOP, 1592 TO BOTTOM

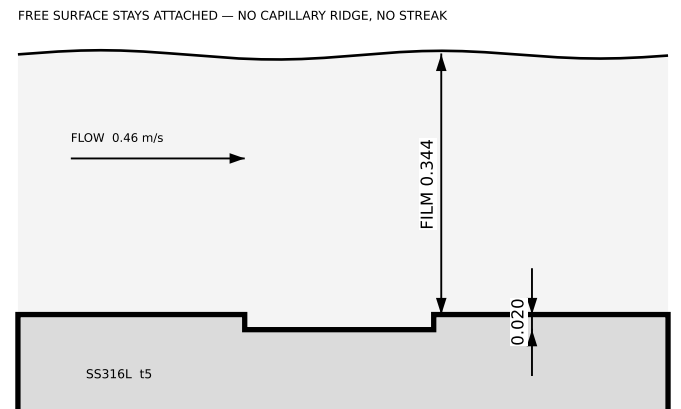
ENGRAVING SPECIFICATION

PARAMETER	SPECIFICATION
Process	Pulsed fibre laser, hatch fill, 3-D DYNAMIC-FOCUS head
Field geometry	sphere sags 11.2 mm over 300 — flat-field PROHIBITED
Film over the mark	0.326-0.366 mm over 0.85-1.20 L/s
Depth, nominal	0.020 mm
Depth, maximum	0.025 mm — DO NOT EXCEED
Governing limit	0.10 x thin-end film = 0.033 mm (screening)
Artwork	300 x 266.6 mm, 1 closed profile
Position	polar 75.9° to 91.2°
Azimuth	AZ 180° gore centreline
Sequence	AFTER forming, welding and final polish
Post-treatment	Passivate to ASTM A967, citric

ACCEPTANCE — HOLD POINT BEFORE THE SPHERE IS MARKED

CHECK	ACCEPTANCE
First-article depth	Profilometer, 5 points, all ≤ 0.025
Edge condition	No burr, no recast lip above surface
Heat tint	Removed / passivated, no visible tint
Salt spray	ASTM B117 96 h on the coupon, no pitting
COUPON WET TEST — HOLD	Emblem on the SH14 panel under a falling film,
	q 0.159 kg/m·s, 60-90°: no streak in 500 mm, no ridge
Running appearance	Witness with film at 1.00 L/s

DETAIL C — ENGRAVING SECTION · SCALE H 1:1 / V 100:1


$$d / h = 0.058$$

FILM DOES NOT REGISTER IT

REV	DATE	DESCRIPTION	BY
D	2026-08-05	CONCEALED SKIRT ANCHORAGE, RESERVOIR + PLANT, PEBBLE COLLECTOR	NX
E	2026-08-20	REV D.2 ALIGNMENT + VISUAL QA CORRECTIONS	NX
F	2026-09-03	LOGO ENGRAVING ADDED (SH15); SHEET COUNT 14 -> 15	NX
G	2026-09-05	AUDIT CLOSE-OUT: CART 082 RB, SLOT 24, 24 TRAYS, DN80	NX
G.2	2026-09-06	PART DRAWINGS SH30-38; SLOTS A222.5; DOUBLER R995	NX
G.3	2026-09-06	SH37 BRACKET, SH42 WELD MAP, P-16 BELLOWES; IFF	NX

SPA FOUNTAIN — B7 SPA, MALDIVES

SPA-F-SH15 — LOGO ENGRAVING — ARTWORK, POSITION AND DEPTH

DRAWN: NaXief Eng.		CHECKED: NX 2026-09-06	APPROVED: I. NAZEEF 2026-09-06	STATUS: IFF REV G.3
DATE: 2026-09-06	REV: G.3	UNITS: mm	SCALE: AS NOTED	A3 · SHEET 15/25

ISSUED FOR FABRICATION — REV G.3 · HOLD POINTS PER SH42

