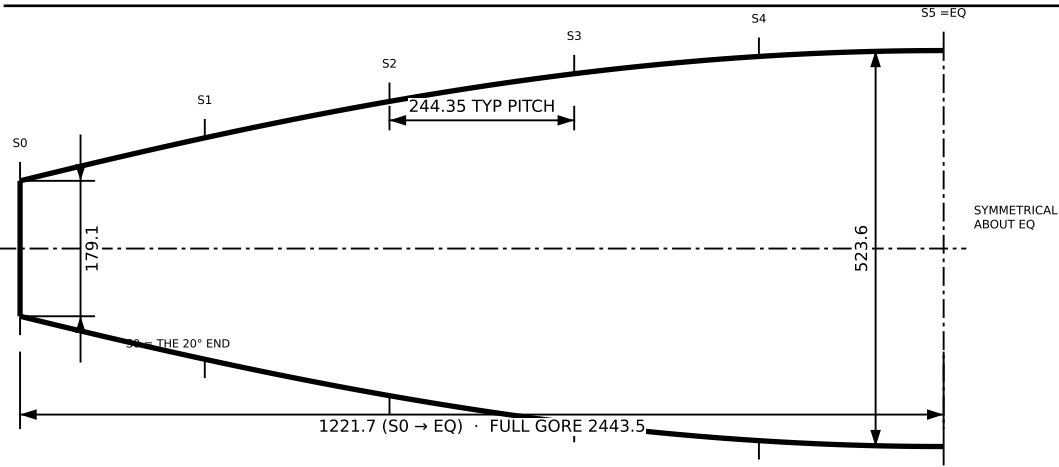
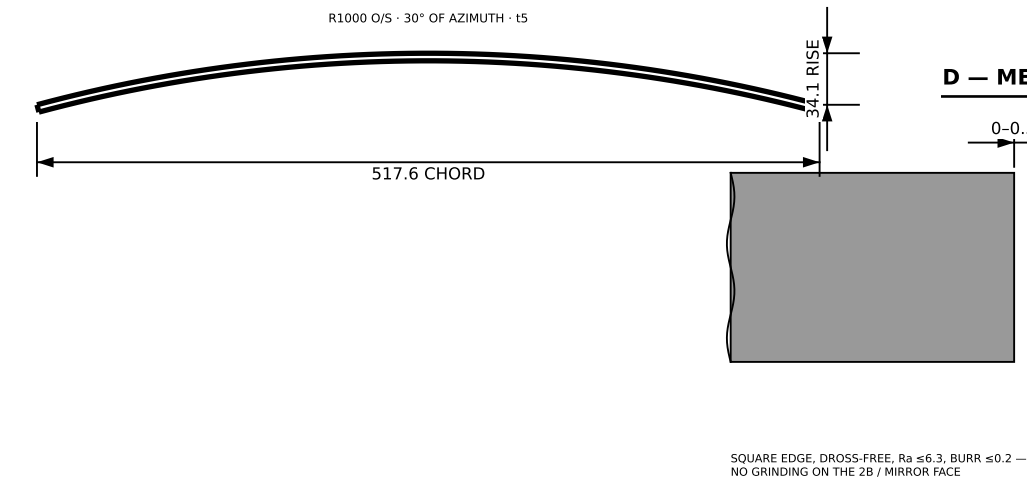


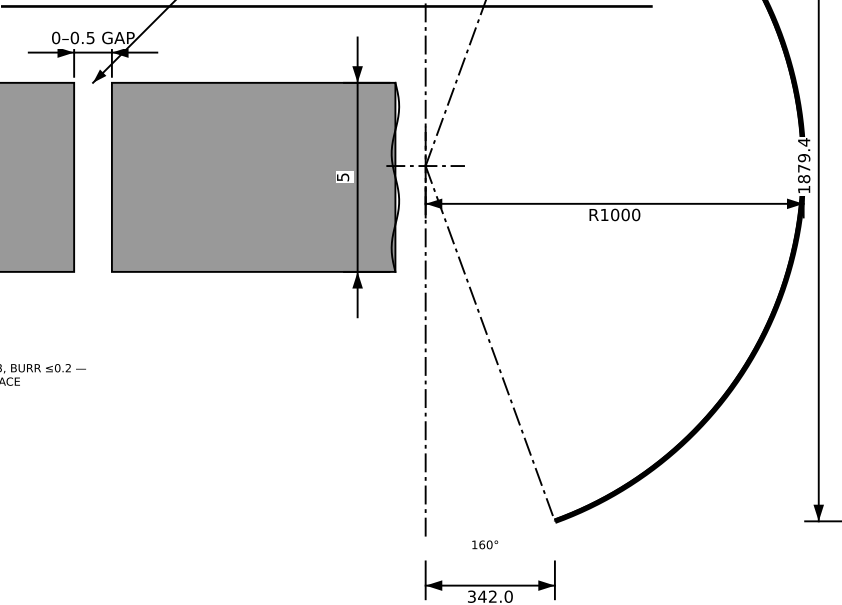
A — P-01a GORE FLAT PATTERN, HALF (12 OFF, t5) — gore_flat.dxf 1:1 GOVERNS · SCALE 1:10



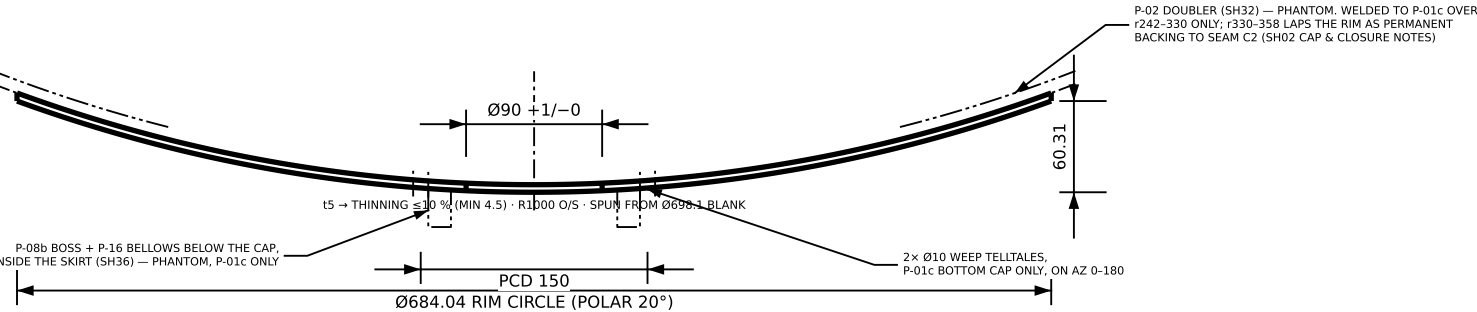
C — SECTION AT THE EQUATOR (S5), FORMED · SCALE 1:5



D — MERIDIAN EDGE PREP (ALL 24 EDGES) · SCALE 5:1



E — POLAR CAP SECTION (P-01b TOP / P-01c BOTTOM), SPUN · SCALE 1:5



GORE STATION / NET WIDTH GRID

STA	s (mm)	2w NET (mm)	θ (°)
S0	0.0	179.1	20.0
S1	244.3	292.8	34.0
S2	488.7	389.1	48.0
S3	733.0	462.3	62.0
S4	977.4	508.0	76.0
S5 =EQ	1221.7	523.6	90.0
S6	1466.1	508.0	104.0
S7	1710.4	462.3	118.0
S8	1954.8	389.1	132.0
S9	2199.1	292.8	146.0
S10 =END	2443.5	179.1	160.0

$\theta = 20^\circ + s/1000 \text{ rad}$; $w(\theta) = 1000 \cdot \sin \theta \cdot \pi / 12$. NET WIDTHS: THE DXF ADDS +0.8 PER WELDED EDGE.

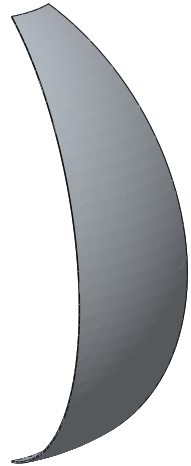
P-01a GORE — FABRICATION

- MATERIAL 316L 1.4404 t5, 2B finish, EN 10204 3.1 (SH13). One heat per gore set where possible.
- CUT laser or waterjet from gore_flat.dxf (1:1) — the file governs, it carries +0.8 per welded edge for shrinkage; working edge ± 0.3 . Scribe S0-S10 and the CL meridian LIGHTLY, INSIDE face only.
- FORM to R1000 O/S in both directions. 316L springback: trial roll R970-R985, over-form, verify on the S2 / S5 / S8 sweep templates plus the chord-800 longitudinal template; gap ≤ 0.5 anywhere (SH02).
- FIRST ARTICLE: one gore formed and accepted on the templates BEFORE the batch (hold H2, SH14 witness panel).
- EDGES per detail D. Fit-up gap ≤ 0.5 , mismatch ≤ 0.2 before tack; seam flushness ≤ 0.2 then ≤ 0.03 (SH02).
- MARK G01-G12 vibro-etch 6 mm on the INSIDE face near S0, in azimuth order; G01 centred on AZ 0.

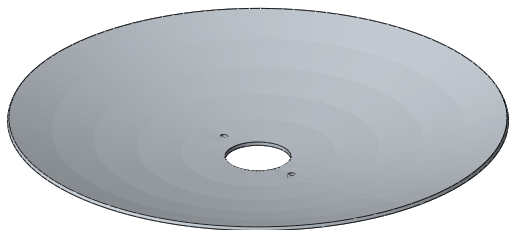
P-01b / P-01c CAPS — FABRICATION

- SPIN from the Ø698.1 blank (cap_blank.dxf) to R1000 O/S; thinning $\leq 10\%$, min 4.5 at the rim; rim trimmed to Ø684.04 ± 1.0 concentric ≤ 0.3 to the polar axis.
- Ø90 $+1/-0$ pole hole DRILLED AFTER SPINNING on the polar axis (SH03 D1 / SH36). Deburr; no countersink on the mirror face.
- P-01c BOTTOM: 2x Ø10 weeps PCD 150 on AZ 0-180; weld P-02 doubler (r242-330 only) and P-08b boss to it BEFORE it joins the gores (copper chill, SH02); the doubler's r330-358 band is the backing for seam C2. P-01b TOP: no weeps, no doubler; the crown port is final-machined after the riser weld.
- Cap-to-gore butt: trim the gore ends to the rim at fit-up; square groove WPS-01; ISO 5817 B; mirror #8 after welding (SH13).
- P-01c also carries the ½ BSP CRC-V drain-plug boss at r100 AZ 90 on the OUTER face (weld B4, WPS-02, SH42) — the interior low-point drain of design basis §2.9.

3D — P-01a (parts3d/P-01a.step)



3D — P-01c (parts3d/P-01c.step)



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 f8, SLOT 24, 24 TRAYS, DN80	NX
G.2	2026-09-06	PART DRAWINGS SH30-38; SLOTS AZ22.5; DOUBLER R995	NX
G.3	2026-09-06	SH37 BRACKET, SH42 WELD MAP, P-16 BELLOWS; IFF	NX

SPA FOUNTAIN — B7 SPA, MALDIVES

SPA-F-SH31 — P-01 SHELL GORE AND POLAR CAPS

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 17/25	
ISSUED FOR FABRICATION — REV G.3 · HOLD POINTS PER SH42									
WORK TO FIGURED DIMENSIONS - ISO 2768-mK U.O.S.									