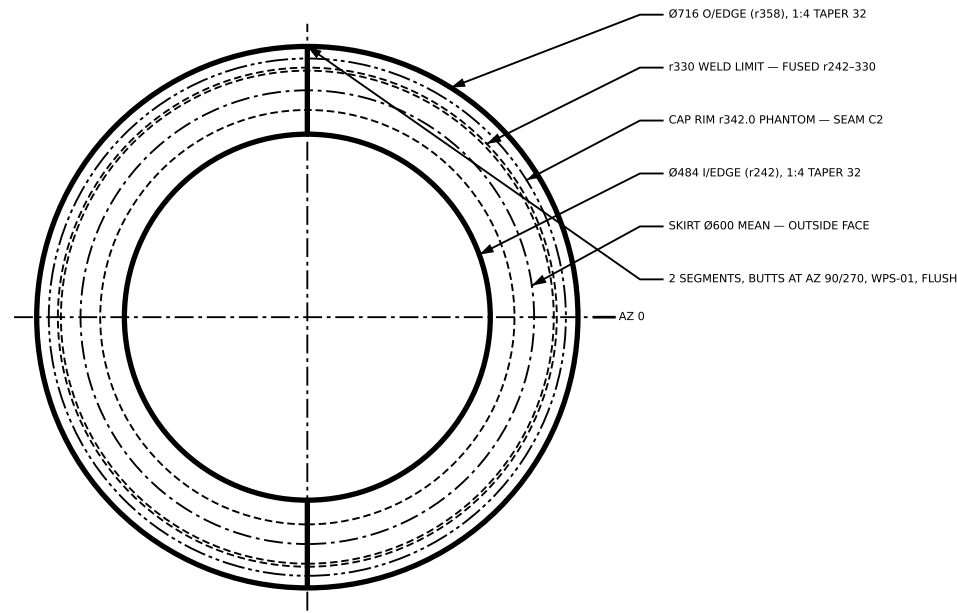
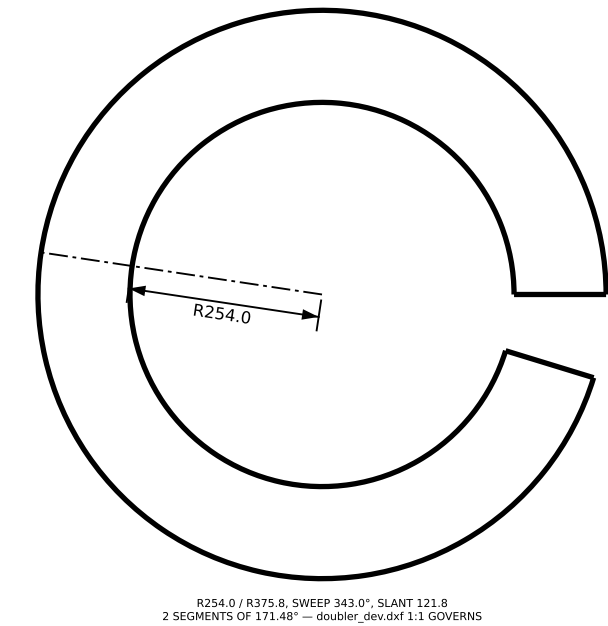


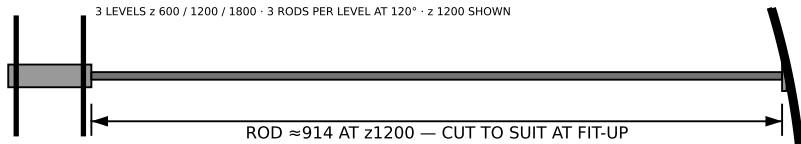
A — P-02 DOUBLER COLLAR, PLAN (1 OFF, t8) · SCALE 1:10



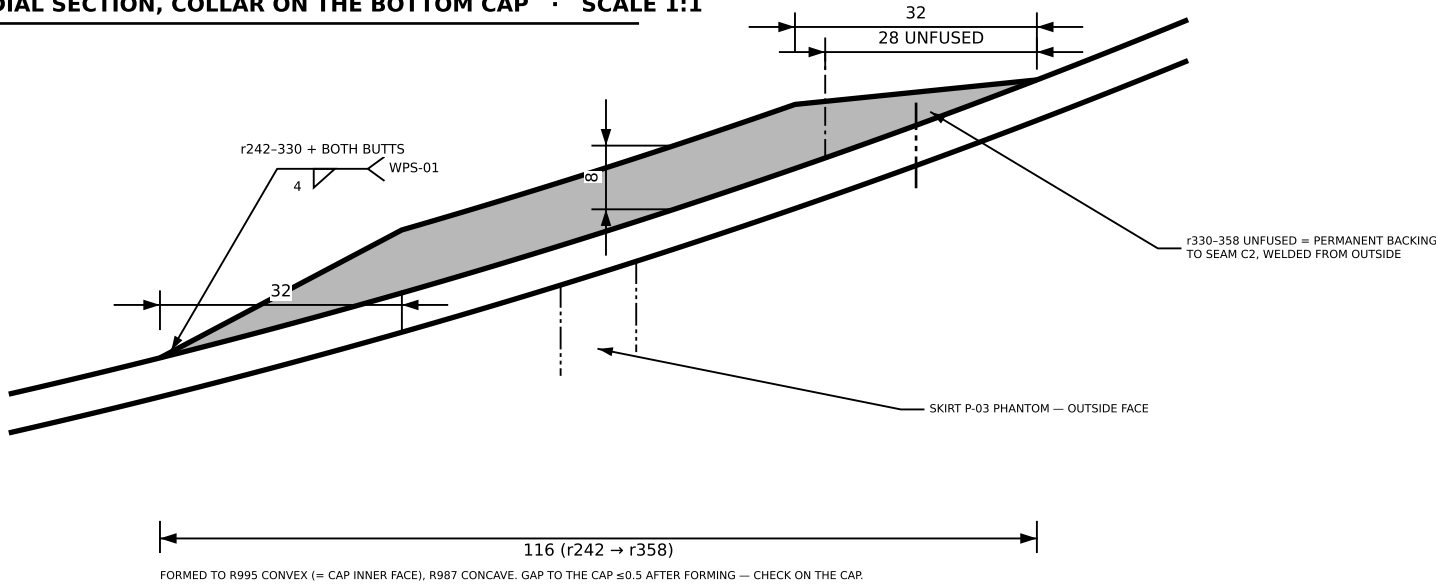
C — DEVELOPMENT (FRUSTUM) · SCALE 1:10



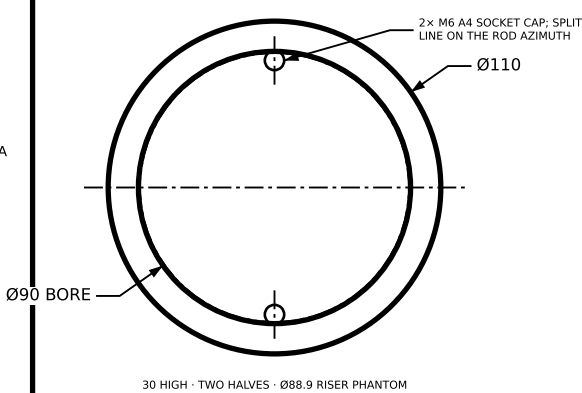
D — P-15 STAY, ONE ROD (SPANS z600 ≈847 · z1200 ≈910 · z1800 ≈527) · SCALE 1:10



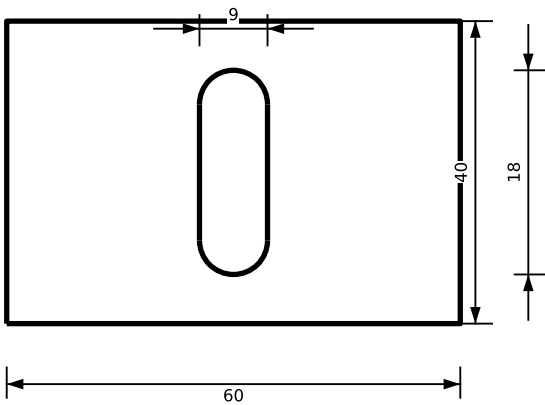
B — RADIAL SECTION, COLLAR ON THE BOTTOM CAP · SCALE 1:1



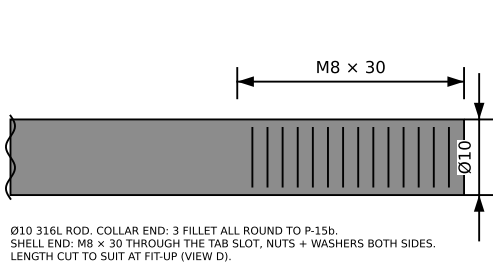
E — P-15b COLLAR (3) · SCALE 1:2.5



F — P-15c TAB t6 (9) · SCALE 1:1



G — P-15a ROD END (9) · SCALE 1:1



PARTS ON THIS SHEET

MARK	QTY	kg EA	MATERIAL
P-02	1	10.72	316L 1.4404 t8
P-15a	9	0.57	316L rod Ø10
P-15b	3	0.75	316L 1.4404
P-15c	9	0.11	316L 1.4404 t6

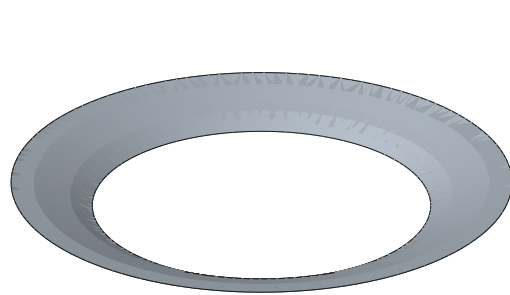
P-02 DOUBLER — FABRICATION

- MATERIAL 316L 1.4404 t8, EN 10204 3.1. Cut 2 segments from doubler_dev.dxf (1:1); grain circumferential.
- FORM (press or spin) to R995 CONVEX — the cap INNER face — NOT the shell mid-surface. Check on the cap: gap ≤0.5 anywhere. Grind the 1:4 tapers over 32 AFTER forming, feathered to zero at r242 and r358.
- WELD TO THE CAP over r242-330 only: 4 fillet at the inner edge + the two segment butts, WPS-01, copper chill on the mirror face (SH02). NOTHING is fused between r330 and r358.
- The r330-358 band is the PERMANENT BACKING for seam C2 — do not grind, drill or cut it; C2 is then a backed full-penetration butt made from outside (SH02 CAP & CLOSURE NOTES).
- PT the fillet and both butts (ISO 23277 2X). Mark P-02 on the concave face.

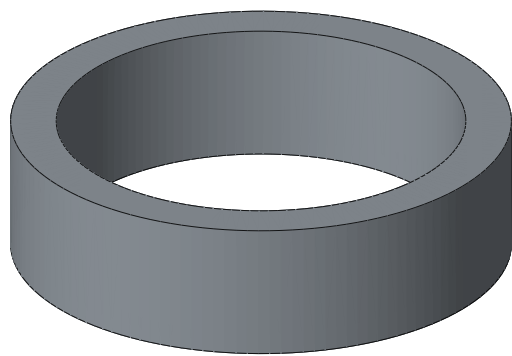
P-15 STAYS — FABRICATION AND FIT

- 9 rods, 3 collars, 9 tabs. Levels z 600 / 1200 / 1800; tab azimuths per level 0/120/240, 30/150/270, 60/180/300 — always on a gore CENTRELINE, never on a seam, and clear of the emblem gore band.
- Tabs welded to the shell inside face before closure, slot radial; collars clamp the riser and are the assembly datum for verticality ≤1:500 (SH03). Rods cut to suit at fit-up, M8 end through the slot.
- Stays are a LIGHT restraint against riser sway — snug only, never tensioned: over-tightening prints the tab through the 5 mm mirror shell.

3D — P-02 (parts3d/P-02.step)



3D — P-15b (parts3d/P-15b.step)



SPA FOUNTAIN — B7 SPA, MALDIVES

SPA-F-SH32 — P-02 DOUBLER COLLAR AND P-15 STAYS

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 18/25	
ISSUED FOR FABRICATION — REV G.3 · HOLD POINTS PER SH42 WORK TO FIGURED DIMENSIONS · ISO 2768-mK U.O.S.									