

1.0 FABRICATION TECHNICAL SPECIFICATION:

Fabrication of LFH-1000-009 Units & Above	
Details	Reference No.
FRAME:	F-000001
<ul style="list-style-type: none"> Fabricated and lift / load tested to DNV 2.7-1 standard, Aberdeen lifting services to be used. To be delivered with chain slings & 3.25T Bow Shackles To be Painted with Blue RAL 5012 and in compliance with DNV 2.7-1 section 4.4.13 Coating and corrosion protection Welded tabs to be fitted with M10 Threaded Rivet Inserts (Free issued by LFH) LFH asset number, front elevation only, XXX sequential number, to be confirmed by LFH or PO. Hinges to be welded in place as per drawing (Free issued by LFH) Tie Down Plates to be assembled fitted to the frame. Painted Black Earth bosses free issued by LFH 	F-000023 F-000007 F-000039 F-000009 F-000011 F-000017
Panels:	F-000032-38
<ul style="list-style-type: none"> The stainless-steel panels are to be fitted without damaging the surface finish of the panel, free of dents scratches and abrasions. 	
DOOR ASSEMBLIES:	F-000002 F-000004 F-000041
<ul style="list-style-type: none"> All doors to be fabricated then assembled with the upper part of the Door Hinge welded. Where GRP is needed, cut to size and brackets fitted to secure GRP in place (Hinge, GRP & Brackets Free issued by LFH) Each door to be matchmarked with the unique unit number in the inside corner. 	F-000009
SHAFT GUARD:	F-000005
<ul style="list-style-type: none"> To be fabricated and Painted with Blue RAL 5012 and in compliance with DNV 2.7-1 section 4.4.13 Coating and corrosion protection 	
BRACKETRY:	H-3198NC H-3044NC
<ul style="list-style-type: none"> As per drawings, coating added for transportation purposes only 	
PAINT SPEC:	

- Compliant with NORSOK M-501 and DNV 2.7-1 section 4.4.13 Coating and corrosion protection. Paint Blue RAL 5012
- Zinc Primer 52%, (ISO 12944-5). Interzinc 52 - Dry Film Thickness 50 - 60 µm
- 1st Coat – Intergard 475 – Dry Film Thickness 150 – 200 µm
- 2nd Coat – Intergard 691 – Dry Film Thickness 50 µm
- Minimum number of coats: 3.
- The final minimum total system Dry Film Thickness, complete coating system: 250 - 310 µm
- Testing and inspection shall be carried out in accordance with NORSOK standard M-501 - Table 3.

FREE ISSUED ITEMS BY LFH:

- Fasteners
- Threaded Rivet Inserts
- GRP
- GRP Brackets
- Door Hinges
- Earth Bosses
- Door Latch/Locks
- Stainless-Steel Panels

2.0 REQUIRED APPROVALS:

Design & Engineering Manager	Approvals on File
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3.0 REVISION HISTORY

Revision	Date of Release	Author	Summary of Change
00	14/02/2023	BM	Initial Release
01	17/07/2025	GD	Title changed, added panel section, updated part numbers, added slings and shackle information.