

Quality Requirement

Machining
General Requirements

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CHANGE DESCRIPTION

Revision	Change description
1	Changed Sections 1.1 General, 1.2 & 2.2 - Tolerances
0	Initial release

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1 MACHINING

1.1 General

All dimensions and tolerances (linear, angular, surface, etc.) are to be in accordance with the drawings. Tolerances may appear attached to the dimension or in the title block. If nothing else is noted machining tolerances shall meet the requirements below.

1.2 Tolerances

Machining tolerances shall meet requirements stated in ISO 2768-m (metric) or ANSI B4.1 (imperial) if nothing else is indicated on drawings.

Work pieces not according to requirements as specified on drawing shall be rejected. All work rejected, based on being out of tolerance or any other requirement shall be corrected or reviewed by use of a Technical Query or any equivalent approved communication method, in writing, between the supplier and the buyer.

Technical responsible (NOV) shall review and either approve or reject the submitted Technical Query or written communication with request for deviation.

1.3 Maintenance and control of machining equipment

All machining equipment shall be periodically maintained and calibrated according to applicable standards. All records shall be available for NOV or 3rd party inspectors to verify.

1.4 Post Machining Treatment

All chips and cuttings are to be thoroughly cleaned out of machined bores, crevices etc.

In the case of interconnecting bores, continuity to be checked and thorough hole cleaning to be performed.

2 DIMENSIONAL CONTROL

2.1 General

The Supplier shall carry out dimensional control.

2.2 Tolerances

Tolerances for overall dimensions, special components, and interface points to equipment or to other structures will be specified on Issued for Construction (IFC) drawings. For traceable parts all dimensions with specified tolerance shall be verified, recorded and reported, as well as be a part of the final manufacturing documentation.

All deviations or out of tolerances on the drawing shall be approved as specified in section 1 above. Notice of deviation or out of tolerance dimensions must be given to NOV prior to delivery.

For non-traceable parts, it is the responsibility of the supplier to ensure that all parts meet design specifications and keep relevant and applicable records.

2.3 Measuring Equipment

All measuring equipment shall be calibrated and certified with traceability to international standards. Calibration certificates shall be available for review by NOV or certifying authority.

2.4 Documentation

All dimensional control shall be recorded and documented according to a recognizable international standard. The reporting may be in the Suppliers own format, but NOV reserves the right to comment and accept / reject the submitted dimensional control reports.