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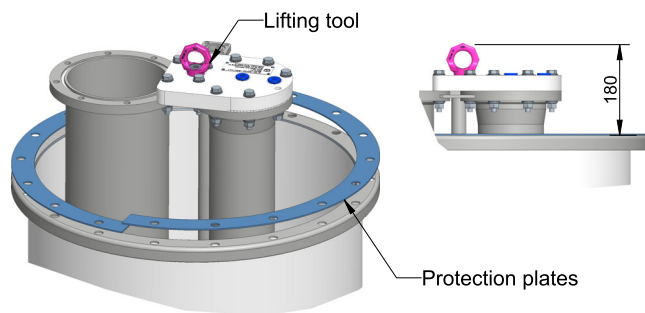
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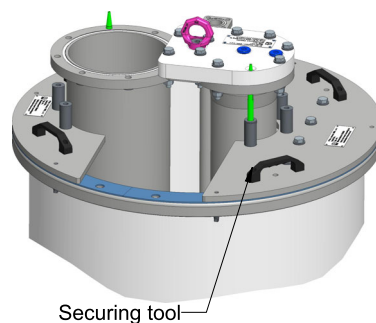
1

Step 1

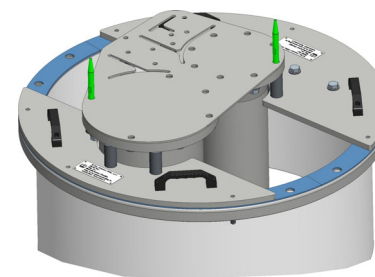
Place protection plates on top of trunk to protect sealing surface. Secure them with strips. Lower first pump section through trunk.

**Step 2**

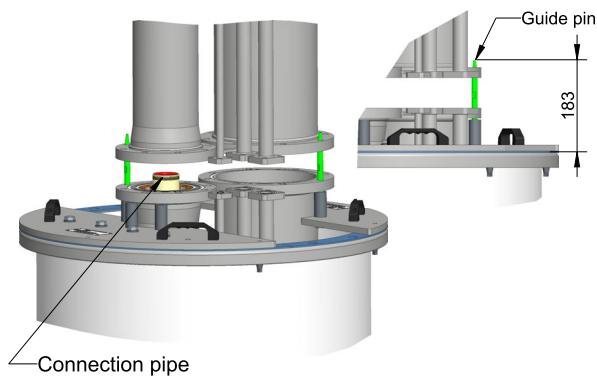
Install securing tool, and lower the section in position with guide pins.

**Step 3**

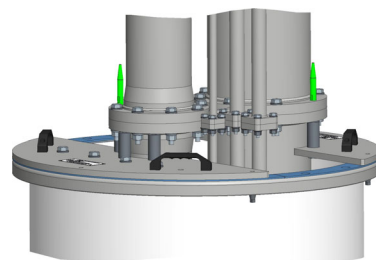
Install transportation gasket and flange on the pump split flange, to avoid impurities entering pipestack, when preparing for the next pipe section.

**Step 4**

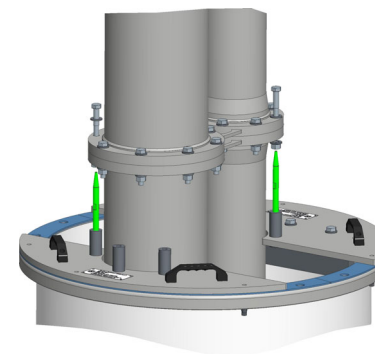
Lift the next section of pipes in position. Remove transportation gasket and flange. Install items in splitlist according to splitlist drawing.


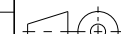
**Step 5**

Lower pipestack and assemble all bolts possible. Be careful not to damage connection pipe and seals.

**Step 6**

Lift pump and assemble the remaining bolts. Remove securing tool and continue with next section. Dismantling of pump sections is done in reversed order according to this instruction.



			Permissible deviations for dimensions without a tolerance indicaton														Item			Qty	Id. no.		Drw. no./Type			Drw. no./Type			Material	
			Linear dimension or shortest leg of an angle		Machined: Tolerance		Welded: Tolerance											This drawing is our property. It is not to be traced, copied or published without our written consent, nor to be misused in any way.			Status	Sign.	Date	 Frank Mohn AS	Weld. drw./Cast. drw.					
Dim & tolerance	Upper limit	Lower limit	over	to	linear	angle	linear	angle										Constr.	RES	07Feb14	Replaced by:									
			6	30	± 0.1	± 0.5°	± 1	± 0.6°										Drawn by			Securing tool for SD200-4/5/6 (pipestack split)	Replaces:								
			30	120	± 0.2				± 0.3	± 0.4°																				
			120	315	± 0.3				± 0.5	± 0.3°	± 1.5	± 0.5°																		
Surface roughness in Ra (µm)			315	1000	± 0.8	± 0.2°	± 2	± 0.3°										Checked	AH	27Feb14										
			1000	2000	± 1.2		± 3										Prot. rel.													
			2000	4000	± 2		± 4										Prod. rel.	AH	09Apr14											
			4000	8000	± 3		± 5																							
Fill. & edg. not dim.		Fillets		Edges						A		E-8023		RES/10Jun14						1:10							0367-2084-3			
										R. Zone		R.O.no.		Sign./Date		Ctrl		Proj. type		Scale										

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