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(54) **Title:** CONFIGURABLE SUBSEA TREE MASTER VALVE BLOCK

(57) **Abstract:** A method of manufacturing a configurable pre-machined forging for use with a multiple bore tubing hanger or a mono bore tubing hanger includes providing a configurable common master valve block with a main bore (46) along a main central axis (Ax). After providing the configurable common master valve block, a target subsea assembly is identified that has a mono bore subsea completion with a production bore along a central axis of a tubing hanger, or a multiple bore subsea completion with the production bore offset from the central axis of the tubing hanger. If the target subsea assembly has the mono bore subsea completion, the machining of a lower interface (62) of the common master valve block is centered around the main central axis (Ax). If the target subsea assembly has the multiple bore subsea completion, the machining has an eccentric interface axis (64) that is parallel to, and offset from, the main central axis (Ax).

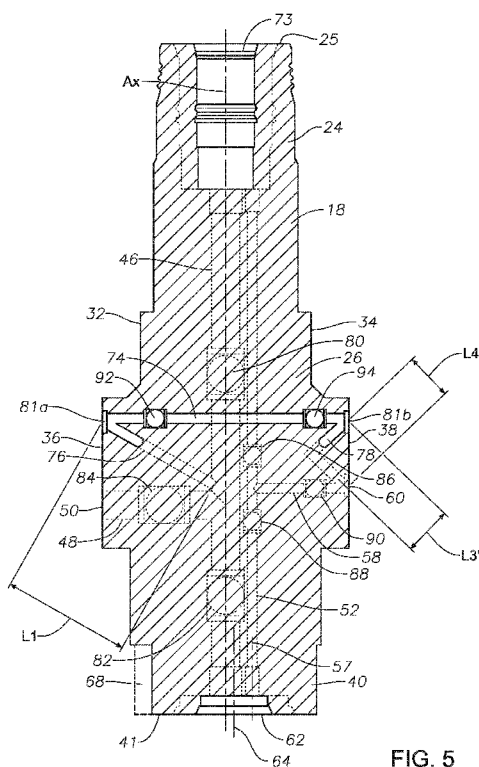


FIG. 5

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