REASON FOR UPDATE: Owner Added

ASSOCIATED DOCUMENTS:

1. PURPOSE

1.1 To provide a procedure for the moulding process within the manufacturing procedure for a M1-D6 Walkersele.

2. SCOPE

2.1 This document applies to all those involved in the moulding process of a M1-D6 Walkersele.

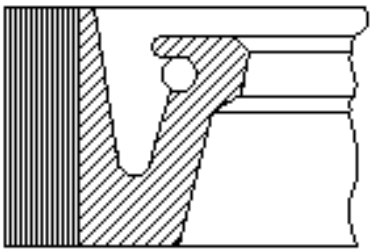
3. RESPONSIBILITY

3.1 The Head of Quality and Production Development is responsible for updating and communicating the details within this procedure.

4. PROCEDURE

4.1 Outline

M1-D6 Walkersele make-up consists of a solid rubber portion produced by extrusion and a rolled fabric collar, made from single ply straight-cut material.



This procedure applies to the moulding of M1-D6 Walkersele make-up, and unless these instructions are closely followed it will be impossible to consistently produce good mouldings.

4.2 Requirements before starting a new order

Do not start a new order until the steps 4.2.1 to 4.2.3 have been completed.

4.2.1 Read the MD info (consult your team leader if this is not available).

4.2.2 Ensure there are no marks or dirt on the mould and that it is clean and sprayed up with mould release. (4/5 light coats followed by a 10 min. cycle and then another light coat achieves this).

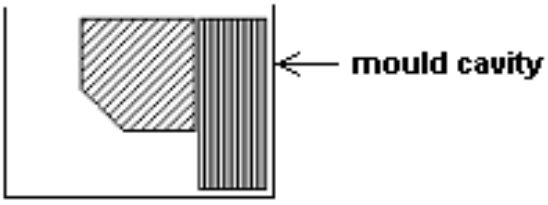
4.2.3 The mould is at cure temperature

4.3 Moulding

- Always check for marks or dirt on the make-up before moulding, and ensure that the cavity is always clean and sprayed up with mould release (four or five light coats followed by a 10 min. cycle, then one light touch up coat). Doing this will inevitably reduce the number of press rejects. Press settings can be found on the MD info.

- Check the mould for damage before use, and ensure both top and bottom parts of the mould are at the temperature specified on the MD sheet. Moulding at the wrong temperature will adversely affect the finished size of the seal. Check that the top of the mould is properly located.

- Place the make-up in the cavity with the step facing down. The collar should be a tight fit against the o.d. of the cavity without having to use excessive force to get it in or causing excessive distortion to the make-up. The fabric collar must be pushed right down to the bottom of the cavity.



- If the make-up is too small or too large do not mould it – inform your shift/team leader. Stretching small collars will cause excessive shrinkage after moulding, and collars that are too large will increase the likelihood of ply distortion or movement.

- Always perform visual checks on moulded seals to identify any marks or dirt in the cavity, and make sure the flash is even. If the flash is heavier on one side despite the m/u weight being evenly spread throughout the cavity, try rotating the top of the cavity through 90º. If this doesn't work consult your shift/team leader.

IF IN DOUBT ASK!