

<b>James Walker</b>	<b>Manufacturing Procedure:</b> <b>Anson Hammerlug Union</b>	<b>Date:</b> Jul 26, 2013 Reaffirmed 2021	<b>Rev:</b> 2	<b>Page:</b> Page 1 of 4	<b>Document No:</b> OPI 142 <b>Approved by:</b> Unit 1 Shift Manager
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**REASON FOR UPDATE:** Reformatting of Document

**ASSOCIATED DOCUMENTS:**

1. **PURPOSE**

1.1 To provide a procedure for the manufacture of a Anson Hammerlug Union.

2. **SCOPE**

2.1 This document applies to all those involved with the Anson Hammerlug Union manufacturing procedure.

3. **RESPONSIBILITY**

3.1 The Operations Director is responsible for updating and communicating the details within this procedure.

4. **PROCEDURE**

<b>Customer:</b>	<b>Anson</b>
<b>Item no:</b>	<b>MS 134424</b>
<b>Material:</b>	<b>FR 73/80</b>
<b>Tool no:</b>	<b>172309</b>
<b>Cavities:</b>	<b>4</b>
<b>Tooling Type:</b>	<b>Injection</b>
<b>Tooling Life (dom)</b>	
<b>Part/Drg no :</b>	<b>JW 172309</b>



**Make Up Details**

**Material:** FR 73/80

**Make up:** N/A

**Profile:** N/A

**Die size:** N/A

**Length:** N/A

**Weight:** N/A

<b>James Walker</b>	Manufacturing Procedure: Anson Hammerlug Union	Date: Jul 26, 2013 Reaffirmed 2021	Rev: 2	Page: Page 2 of 4	Document No: OPI 142 Approved by: Unit 1 Shift Manager
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### Press Settings

Tool temp( $\pm 10^{\circ}\text{C}$ )	180 $^{\circ}\text{C}$
Cure time	190 Seconds
Injection volume	187.25 cm <sup>3</sup>
Injection pressure	210 bar
Injection speed step 1	187.25cm <sup>3</sup> @ 27.5mm sec
Injection speed step 2	65 cm <sup>3</sup> @ 1 mm sec
Holding pressure	210bar @ 1 second

## 4.1 Moulding Instructions

### Tool Inspection Requirements:

The tooling is to be inspected to ensure the moulding cavities and tear trims / flash groves are free from damage. Ensure the moulding surface is free from dirt, mould protector and flash from previous mouldings. (All flash should be removed before mould is returned to storage)

**IF IN DOUBT ASK.**



### Tool Fitting Details:

Once mould has been checked for damaged and cleaned it can be fitted to the press. The two half's of the mould must be placed together prior to fitting the mould in one piece. Press must be in Set up mode before fitting mould. Care must be taken when aligning mould with the injection nozzle. The mould may need to be pre heated prior to fitting. Once mould is aligned with nozzle it can be then fixed to the platens using four M8 cap head bolts top and bottom.

**IF IN DOUBT ASK.**



### Material Preparation:

Material will be provided in reel form. Ensure material identification is available at all times with a material batch ticket. The material must be kept clean and free from contamination at all times.

**IF IN DOUBT ASK.**



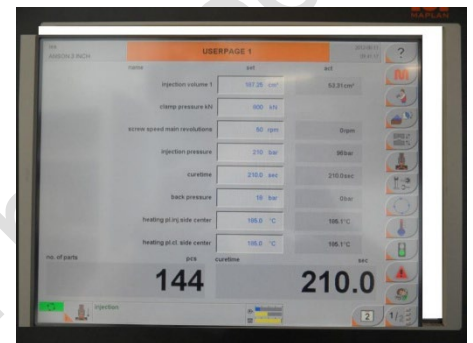
James Walker	Manufacturing Procedure: Anson Hammerlug Union	Date: Jul 26, 2013 Reaffirmed 2021	Rev: 2	Page: Page 3 of 4	Document No: OPI 142 Approved by: Unit 1 Shift Manager
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## Machine Set Up

Once the tool is fitted to the press, operating parameters need to be loaded into the press. This is done by loading the saved mould data. "Load mould data" can only be carried out when the machine motor is switched off. Re- call settings from mould data page or USB stick and load into machine. The tool must then be allowed to achieve operating temperature before applying the approved mould release (**Diamond kote W4048**) The mould release must then be allowed to bake onto the tool.

Once mould data has been loaded, mould release applied and mould temperature checked, ensure machine is free of contamination from any previously moulded compounds. This is done by "purging" the new compound through the machine.

**IF IN DOUBT ASK.**



## Production

Care must be taken to ensure a continuous feed of rubber, this aids production and prevents non fills and gives a consistent volume of material to each moulding cycle. On completion of the material preparation and machine set up, production can commence.

Machine will be put into semi automatic mode and the first cycle can commence.

At the end of each cycle remove seals from tool with airline and remove excess flash from tool. Apply touch up coat of mould release if required. There is no requirement to purge rubber in between cycles. Remove rubber storks from seals and allow cooling prior to trimming.

**IF IN DOUBT ASK.**



James Walker	Manufacturing Procedure: Anson Hammerlug Union	Date:  Jul 26, 2013 Reaffirmed 2021	Rev:  2	Page:  Page 4 of 4	Document No: OPI 142  Approved by: Unit 1 Shift Manager
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### **Moulding Inspection Requirements:**

Moulded parts are to be inspected to ensure parts are free from moulding defects i.e. Non- fills, Backgrinding, Inclusions, Contamination, Splits, Excessive flash, Dirty mould marks and Air traps.

**IF IN DOUBT ASK.**

