REASON FOR UPDATE: Revision of Existing Procedure, updated example and responsibility

ASSOCIATED DOCUMENTS: n/a

1. PURPOSE

1.1 To provide a procedure for using Make-Up Calculators. The make-up calculators have been developed to help operations staff with creating make-up details for certain family products. These calculators are based on the JW & Co Company Standards so while the details provided can be regarded as a starting point it is expected that exact make-up details are confirmed through production, and that these are recorded on the DJ paperwork. It is important that some details such as number of plies are subject to set tolerances so no change outside these tolerances should be made without consulting the Technical department.

2. SCOPE

2.1 This document applies to all Make-Up Calculators for moulded seals.

3. RESPONSIBILITY

3.1 The Technical Support Team (part of the Elastomers Technical Team) is responsible for maintaining the tools, the Make-Up Calculators. It is the responsibility of each product Stream Manager, through their network of Team and Shift Leaders to enforce the implementation of this procedure. The calculators are only to be used by those who have been trained on them. This will include, but not be limited to, Product Stream Configurators, Shift Leaders and Team Leaders.

4. PROCEDURE

4.1 Navigation - The make-up calculators are location on the company's LionShare system in the following location and are available to all. You can set these up as favourites on your LionShare but you SHOULD NOT copy to your desktop.

Home » Technical Information » Technical Information JW & Co. » Operations » Production Testing and Applications » Calculators

4.2 Select the appropriate calculator for your product. If a calculator does not exist, consult your production team leader. This example uses a Walkersele D6.

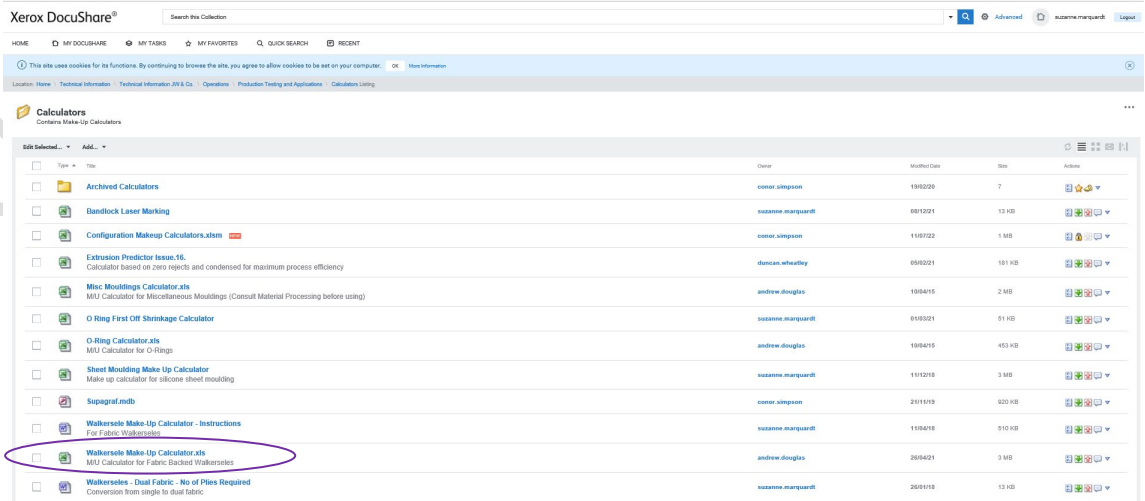

Figure 1: Location of Make-Up Calculators

4.3 Enter the rubber material grade of the item using the drop down list “Select Rubber”, for the rubber material grade see the part description or drawing. Repeat for “Select Fabric”. and/or any design features of the item.

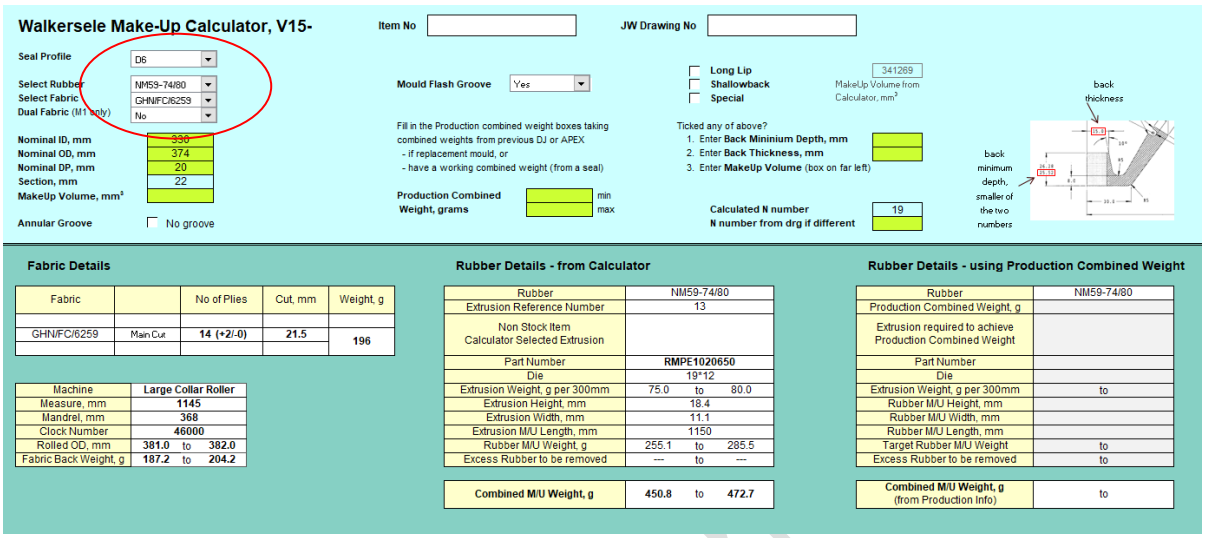

Figure 2: Enter Item Material and Design Details

4.4 Enter the **nominal dimensions** from the item description or the drawing into the green boxes; **do not use the actual dimensions** from the drawing. The Nominal Section will be automatically calculated.

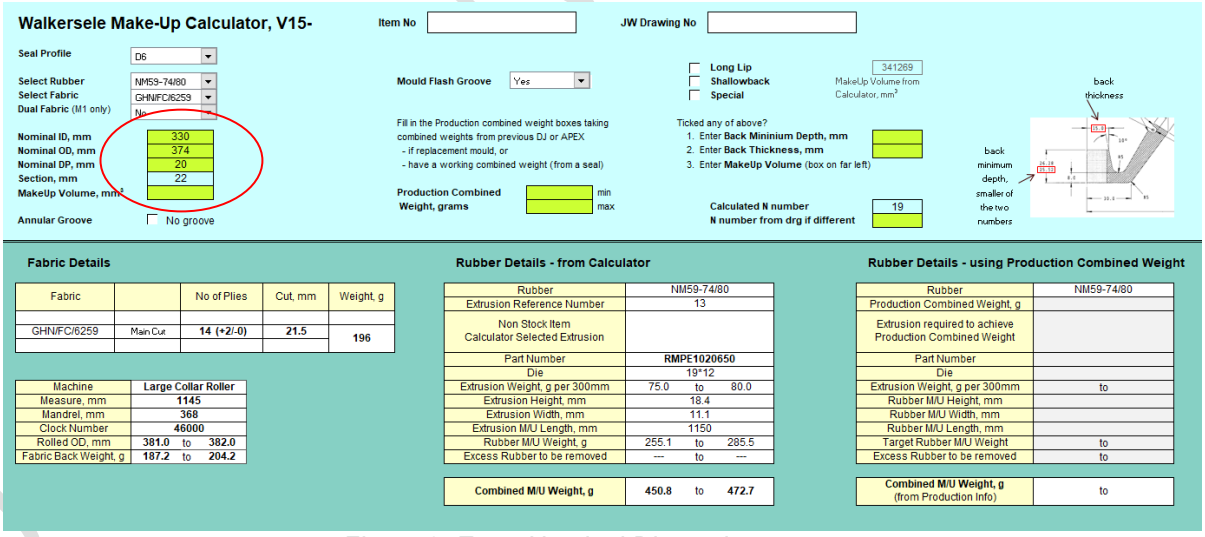

Figure 3: Enter Nominal Dimensions

4.3 Select design features of the item.

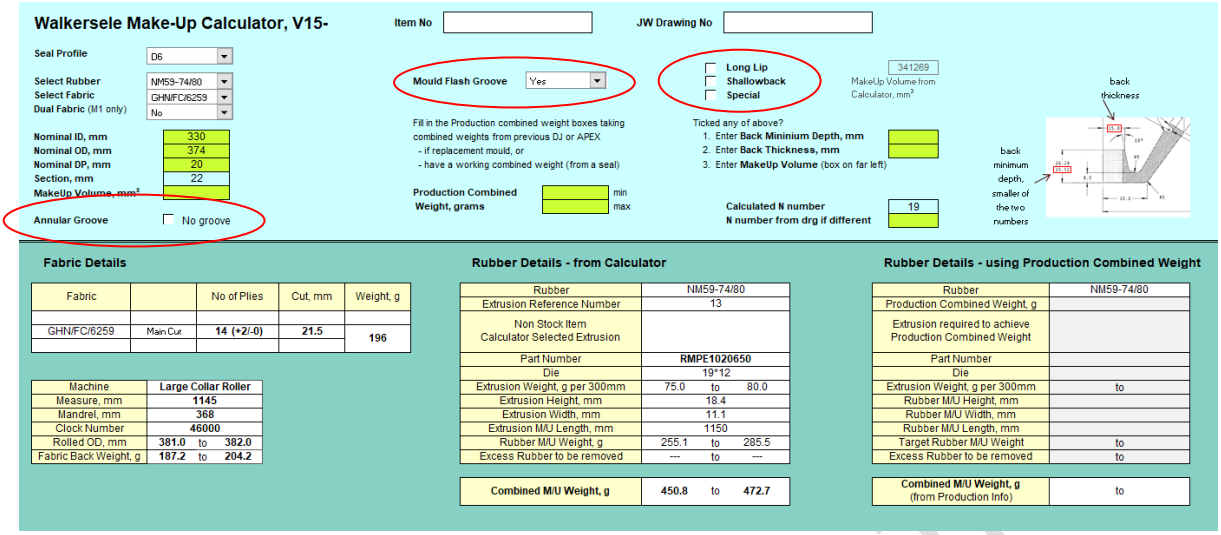

Figure 4: Enter Design and Mould Features

4.5 If warning messages are displayed, firstly double check the dimensions, materials and designs you have entered, then secondly consult the Technical Team BEFORE issuing to the shop floor.

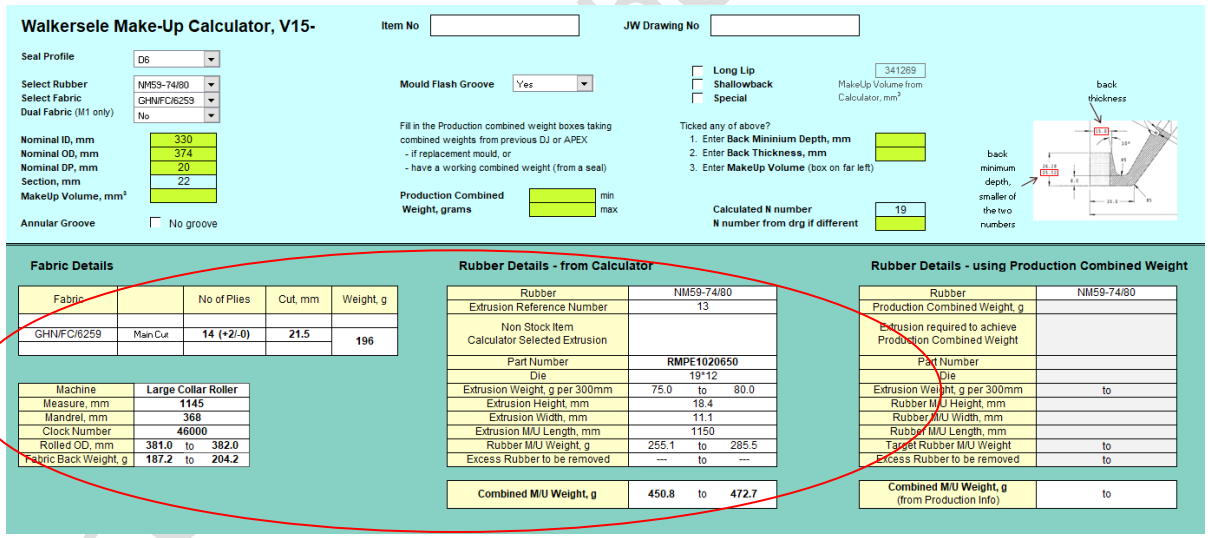

Figure 4: Change the Extrusion Ref & Watch Out for Warning Messages

4.6 If you intend to print this document enter the drawing number and item number.

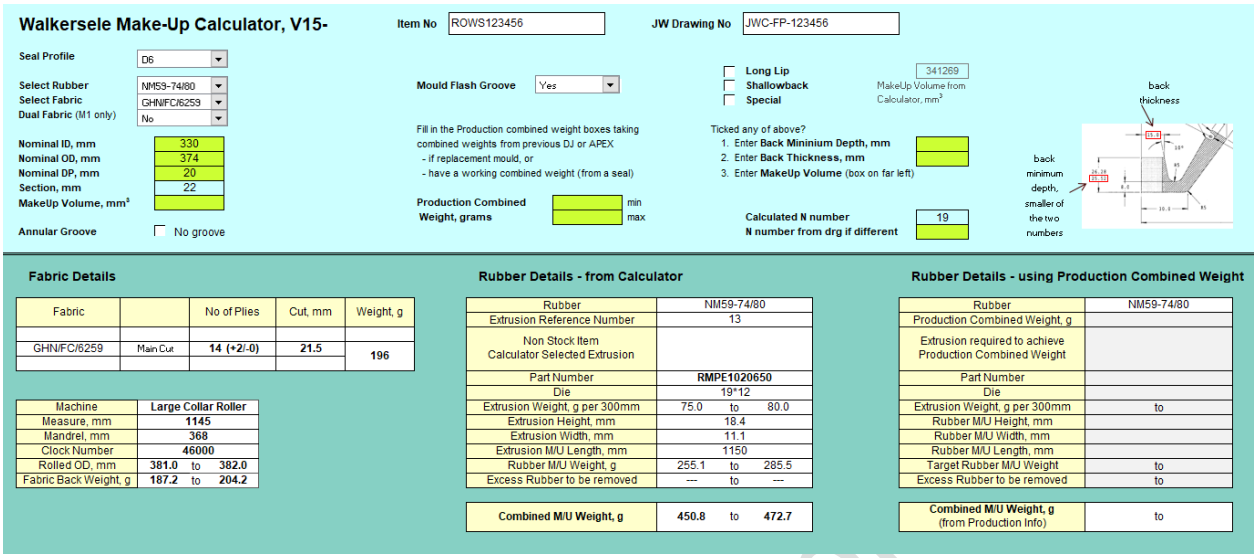

Figure 5: Enter Item Number and JW Drawing Number