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| James Walker | Recording of Press Temperatures | Date: Jul 28, 2025 | Rev: 7 | Page: Page 1 of 2 | Document No: OPI15 Approved by: Operations Manager |
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REASON FOR UPDATE: Digital process introduced across site

ASSOCIATED DOCUMENTS: FMP Ref: [FMP 20](#) [QPD 21](#) [F685](#) [F686](#)

1. **PURPOSE**

1.1 To provide a procedure for the recording of press temperatures.

2. **SCOPE**

2.1 This document applies to all those involved with the recording of press temperatures.

3. **RESPONSIBILITY**

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

4. **PROCEDURE**

Key Points

Notes

Schedule

1. Presses throughout all moulding areas must have their heated moulds (top and bottom) checked for temperature on a job by job basis.
2. Temperatures are to be recorded for every DJ and at the beginning of each shift.
3. The information is to be recorded using a Digital PRS form (press record sheet)

**Master File/
Register**

4. Records to be archived in a SharePoint list for a 5 year period. Retaining this evidence allows full traceability of the process verification stages.

Procedure

5. For **Moulded products** the top and bottom mould temperatures to be within **+5°C -4°C** limits of nominal temperature for the material being cured.
6. For **Pre-form products** the top and bottom mould temperatures to be within **+5°C -0°C** limits of nominal temperature for the material being pre formed.
7. Both top and bottom mould readings to be recorded separately (and each shift change) on the digital PRS form press record sheet.
8. Unit Manager / Team Leader / Lead Operator / Process Control Operator to undertake random press audits at least once during every shift and record result using PAS Press audit Sheet
9. Temperature of moulds to be measured using equipment which is within current calibration status and accuracy traceable to National Standards.
10. Temperature controllers on press to be set at required temperature plus or minus the correction factor where applicable. Correction factor may differ from job to job depending on mould size and depth.
11. Extra readings may be taken when there is reason to believe mould temperatures are outside specified limits.
12. A corrective action task will generate in the Microsoft planner, to detail the corrective action undertaken by the supervisor (Team Leader / Lead Operator).

Non-conformance

13. Where temperature readings are outside limits, production on the press must stop.
14. Corrective Action with verification shall be undertaken by the supervisor (Team Leader / Lead Operator) and detail recorded within the Microsoft planner

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Equipment

15. Following equipment available for carrying out temperature checks: -
 - a) Digital electronic thermometers with surface probes.
16. This equipment must be calibrated at prescribed intervals against National Standards with records thereof.

System

17. In the event of a system failure or issue, operators shall complete the excel version of the PRS - F685 & F686

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