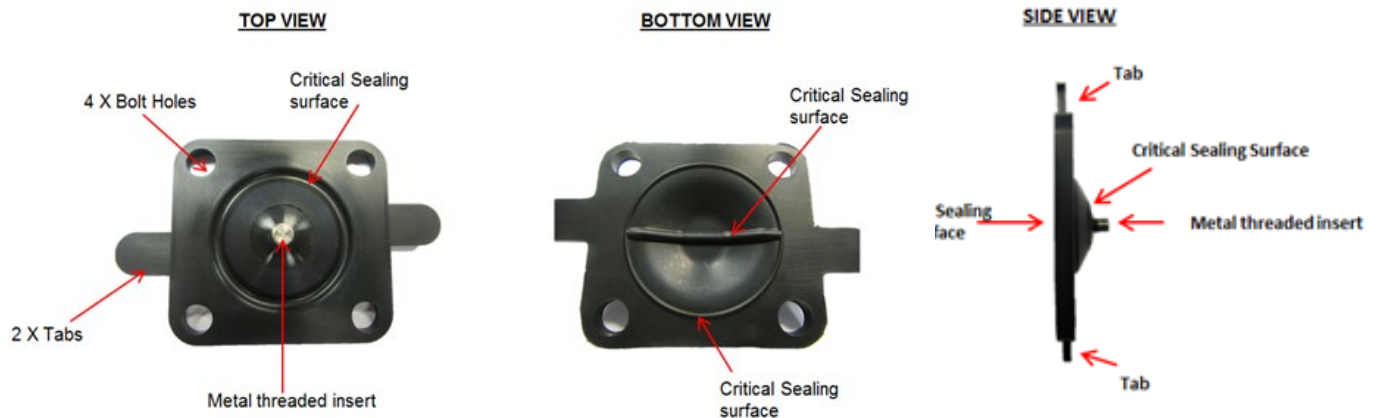


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General Overview

This document should be referred to as a guide during inspection of Hygienic Diaphragm's, the guide should be used along with the DJ and Drawing.
The below photographs show a general view of the Diaphragm and shows the main features of the seal.

Fig.1.



Highly critical areas

Highly Critical areas shown below on part (Fig.2.1) highlighted in red to be inspected using 2x magnification inspection lamp,
No blemishes, inclusions, indentations, etc. are permitted.

Fig.2.1

TOP VIEW

BOTTOM VIEW



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Highly critical areas cont...

Dome to be flexed to ensure no cracking or splitting is present especially around insert. Fig.2.2,
The underside of the dome should also be flexed to ensure cracking or splitting is not present. Fig.2.3

Fig.2.2



Fig.2.3



Metal Threaded Insert

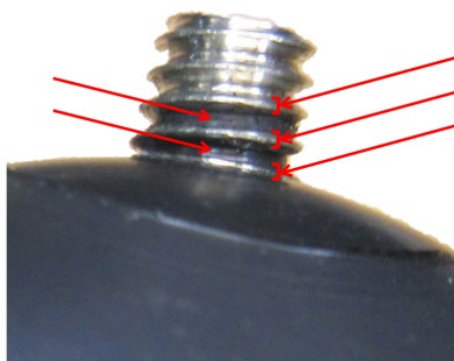
Rubber on the metal threaded insert is not acceptable as shown in Fig.6 if rubber has been molded onto the metal insert this will result in a reject.

Fig.7 bonding agent residue in-between the threads of the metal inserts is acceptable.

Fig.6



Fig.7



All inserts to be covered by a rubber cap to protect against damage at final inspection stage.
Jfreafurjvdoajr0wvj

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Flash

A small amount of flash is permitted on none critical sealing areas up to 0.5mm as shown below in Fig.3. This includes the circular area around the threaded metal insert as shown in Fig.4. Excess flash around this area should be removed using a none abrasive technic i.e. finger nail

Fig.3

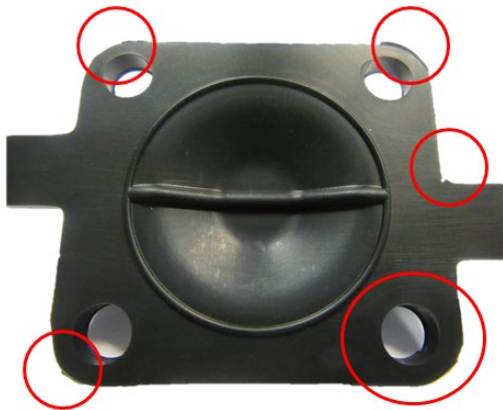
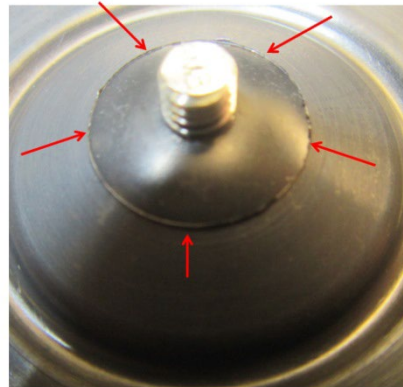


Fig.4

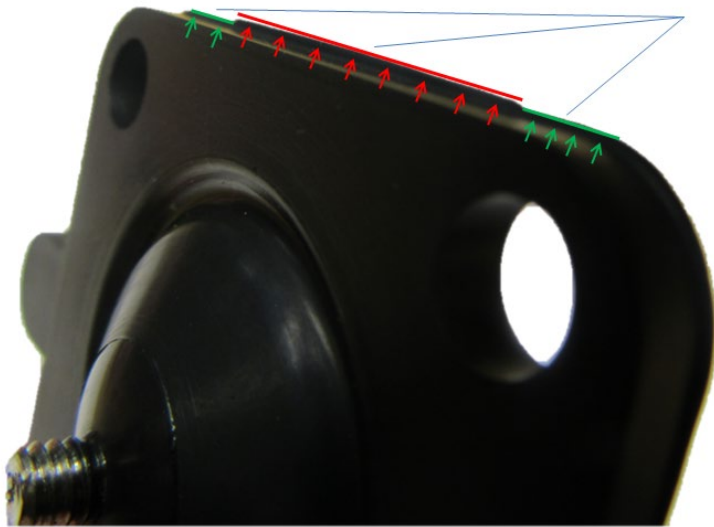


If the flash is excessive (above 0.5mm) and has occurred in larger amounts in one particular area this should be removed until within an acceptable amount as shown in Fig.5.

Fig.5

Clear area of excessive flash shown in red, greater to the flash in surrounding areas shown in green.

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