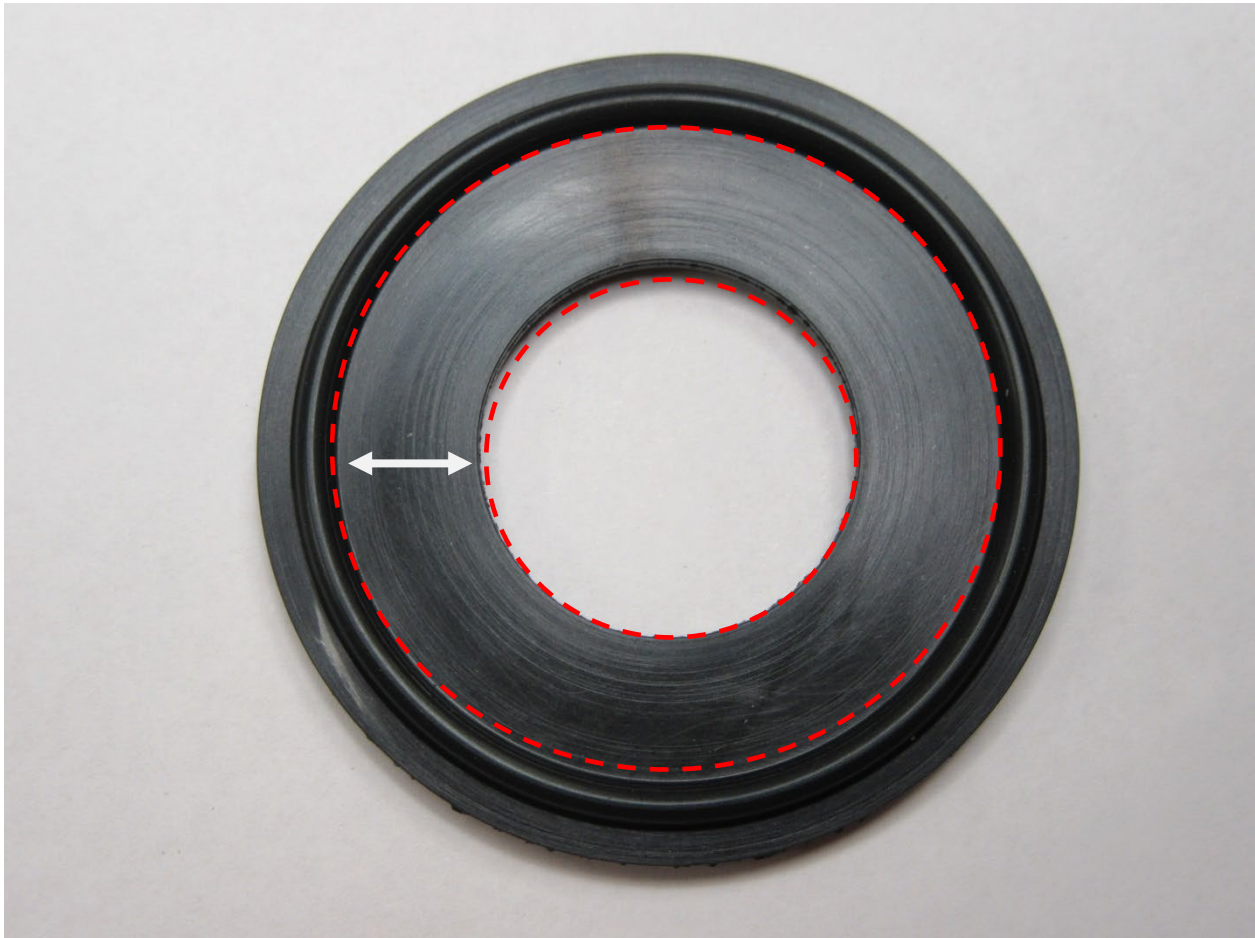


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General Overview

This document should be referred to as a guide during the inspection of hygienic clamp seals. The guide should be used along with the DJ and Drawing. The photograph below shows a general view of the seal and its main features.



Area indicated between dotted lines is the critical sealing surface, including inside diameter. Other areas are non-critical. They are to be visually inspected using good lighting, 2 X magnification is not required unless to verify defect type.

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This shows torn flash on the OD which is too deep and not acceptable.



This shows torn flash on the OD which has no depth and is acceptable.

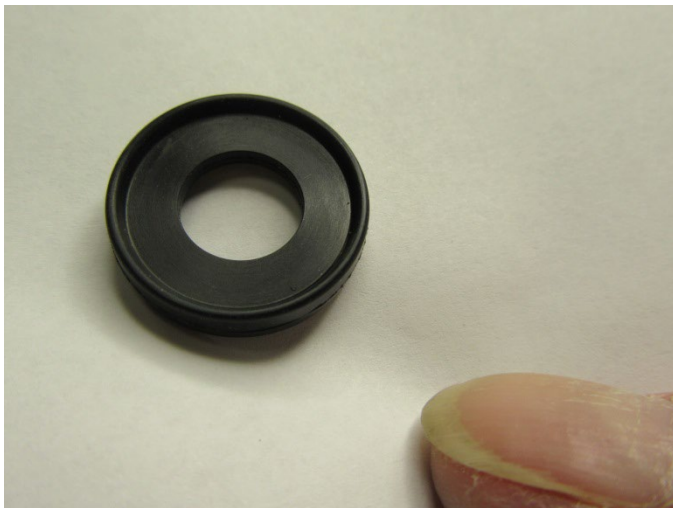


Poor Surface finish on sealing area, not acceptable.

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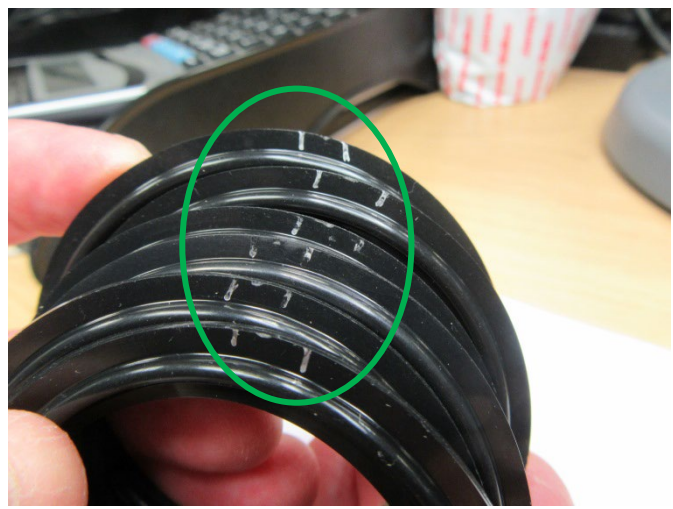
Surface blemish on non-critical area, this is acceptable.



Good surface finish on Sealing area and no excess flash on ID.



Breaking away on non-critical area, excessive depth, unacceptable.

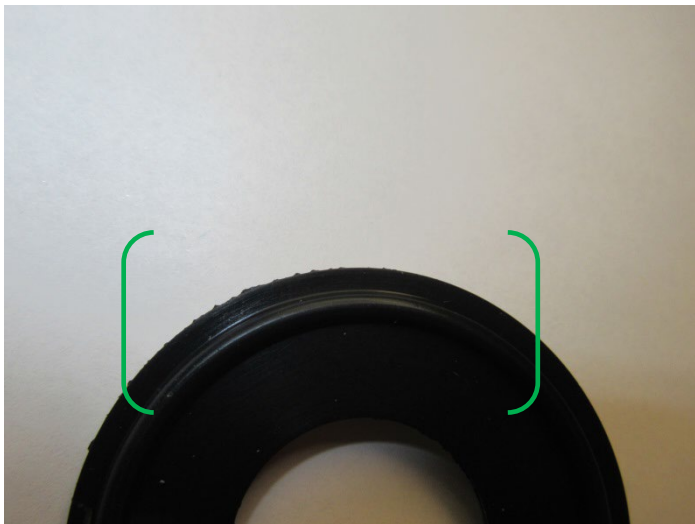


Breaking away on non-critical area, minor depth, acceptable.

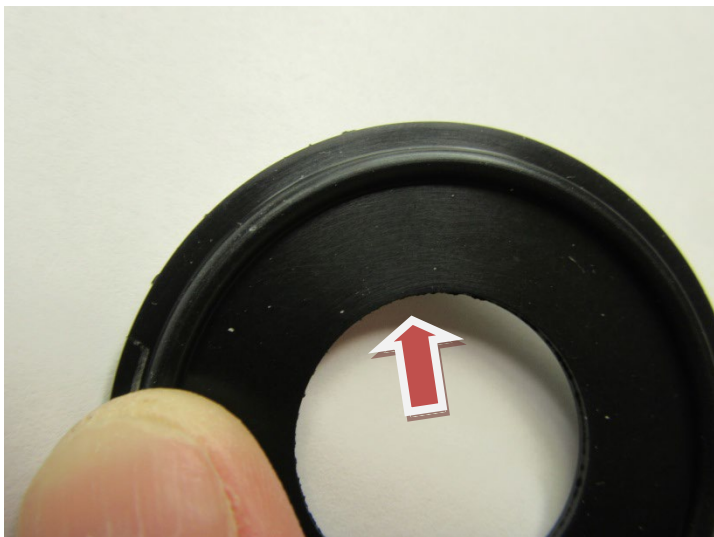
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Damaged tool mark on non-critical sealing area, this is acceptable.



Small amount of excess flash is permitted on OD.



Excess flash on ID is not permitted.

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Chipped OD from CRYO trimming, this is not acceptable.



Poor flow of material at moulding stage, not completed in cavity, appears on both sides of seal, this is not acceptable.

No splits, inclusions, blisters or recessed flow marks permitted anywhere on the seals. If in doubt ask!

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