

James Walker	Title: IK NORWAY RECTANGULAR SQUARE SECTION VISUAL INSPECTION GUIDE	Date: Feb 12, 2024	Rev: 2	Page: Page 1 of	Document No: SIP 14 Approved by: Quality Team
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General Overview

This document should be referred to as a guide during inspection of any IK NORWAY CMRD3260366 RECTANGULAR SQUARE SECTION seals. This procedure should be used in conjunction with any other inspection standard referenced on the DJ and item Drawing JWC-FP-220527. (Donor Seal CMRD3261481 JWC-FP-220552)

Seal Profile

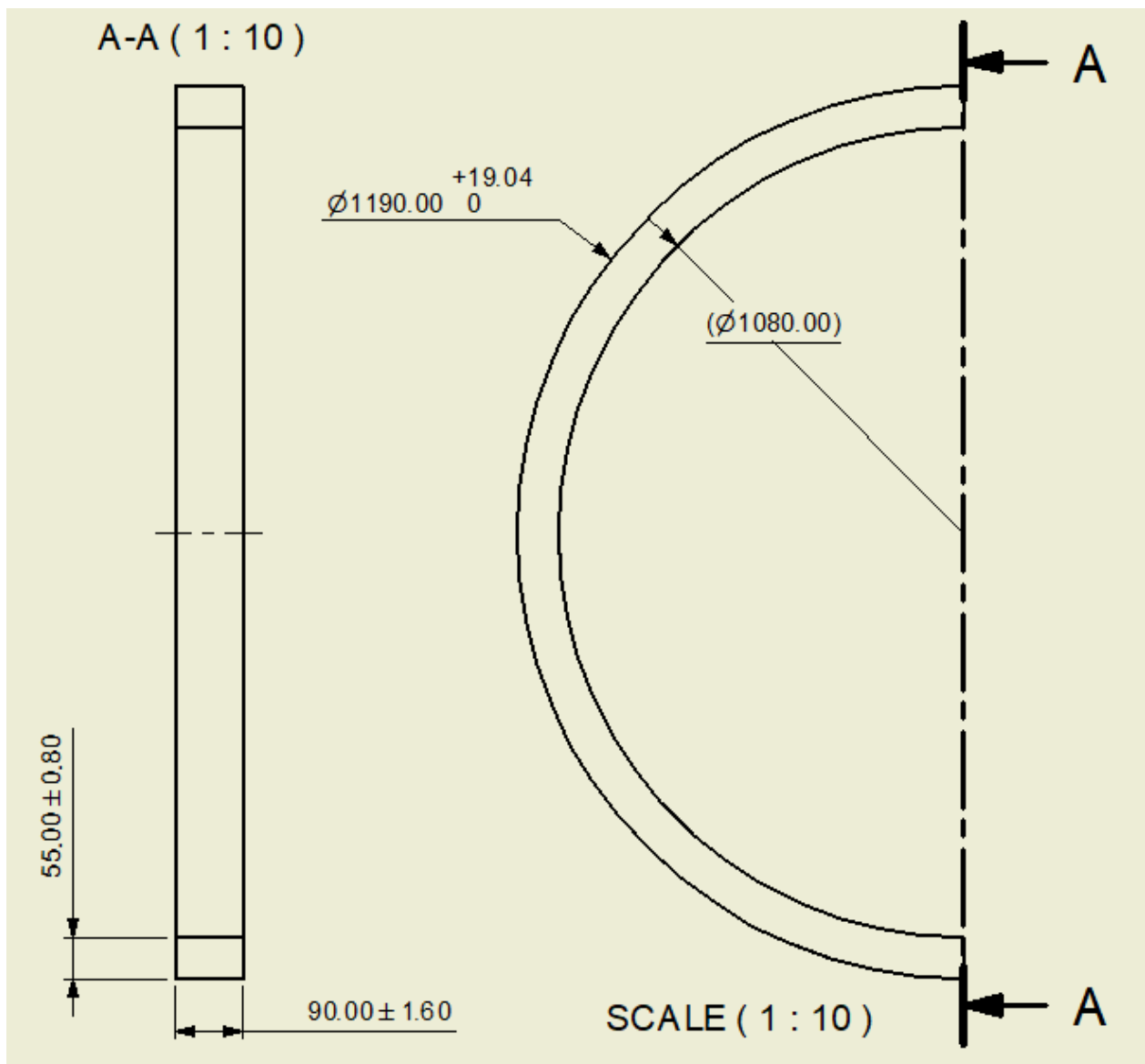


Image 1: Section drawing JWC-FP-220527

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Inspection Procedure

Inspect seals to JW STD 200 070

- All mouldings shall be scrutinised in good lighting condition, without unreasonable distortion.
- The profile of all moulding shall conform to the general outline indicated on relevant drawings.
- All mouldings shall be free from excessive flash.

It is common for BACKRIND to present on the seal, customer have acknowledged and agreed us to apply a MAX 6mm chamfer to all seal edges to eliminate or reduce backrind affect. See photographs for pass fail criteria.

It is acceptable to have different chamfer sizes on one seal. For example a 3 mm on one edge a 4 mm on two others and a 6 mm on another.

*Image 2 & 3: Clean/blank chamfer – all evidence of backrind successfully removed **ACCEPTABLE**.*



Image 2



Image 3

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Image 4 - 7: chamfer applied – slight evidence of back grinding remains **ACCEPTABLE**.

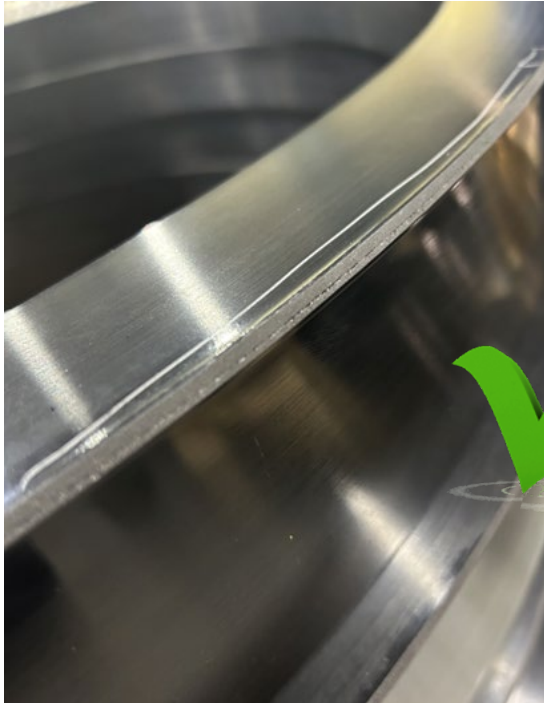


Image 4



Image 5



Image 6



Image 7

Image 8 & 9: chamfer applied – severe evidence of back grinding remains **REJECTABLE**.

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Image 8



Image 9

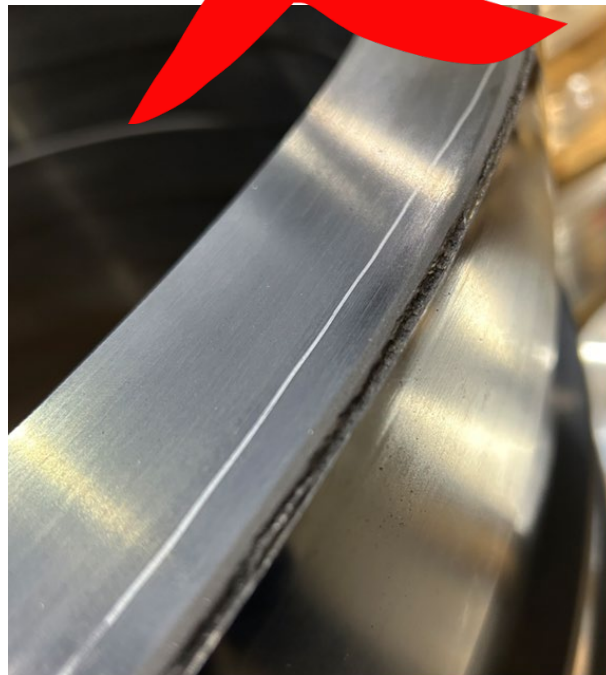


Image 10

Summary

As per Images 2-7, slight evidence of backrind is permissible after an applied MAX 6mm chamfer.
As per images 8-10, backrind is still severe after MAX 6mm chamfer is applied. Rejection necessary.

It is acknowledged that the detail on visual requirements is subjective, but acceptance must be based on the discretion of inspectors, taking regard to the criteria applicable.

IF IN DOUBT ASK!

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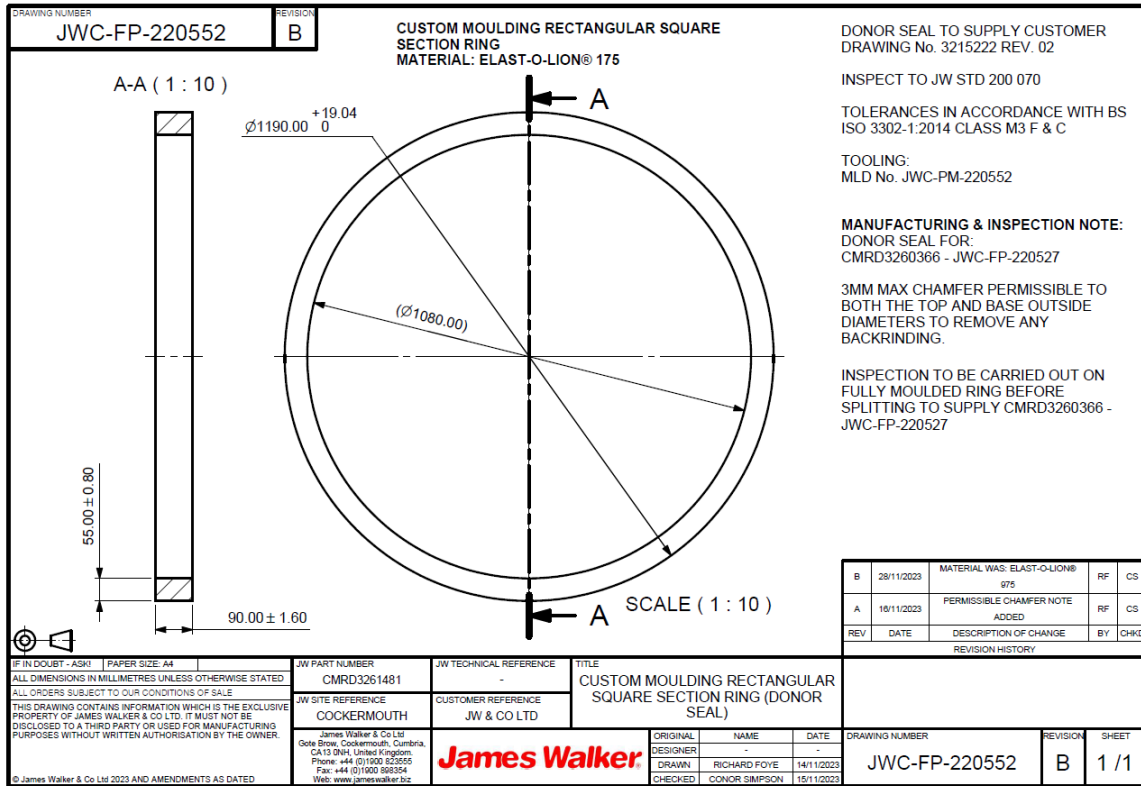


Image 11: Donor Seal CMRD3261481 JWC-FP-220552

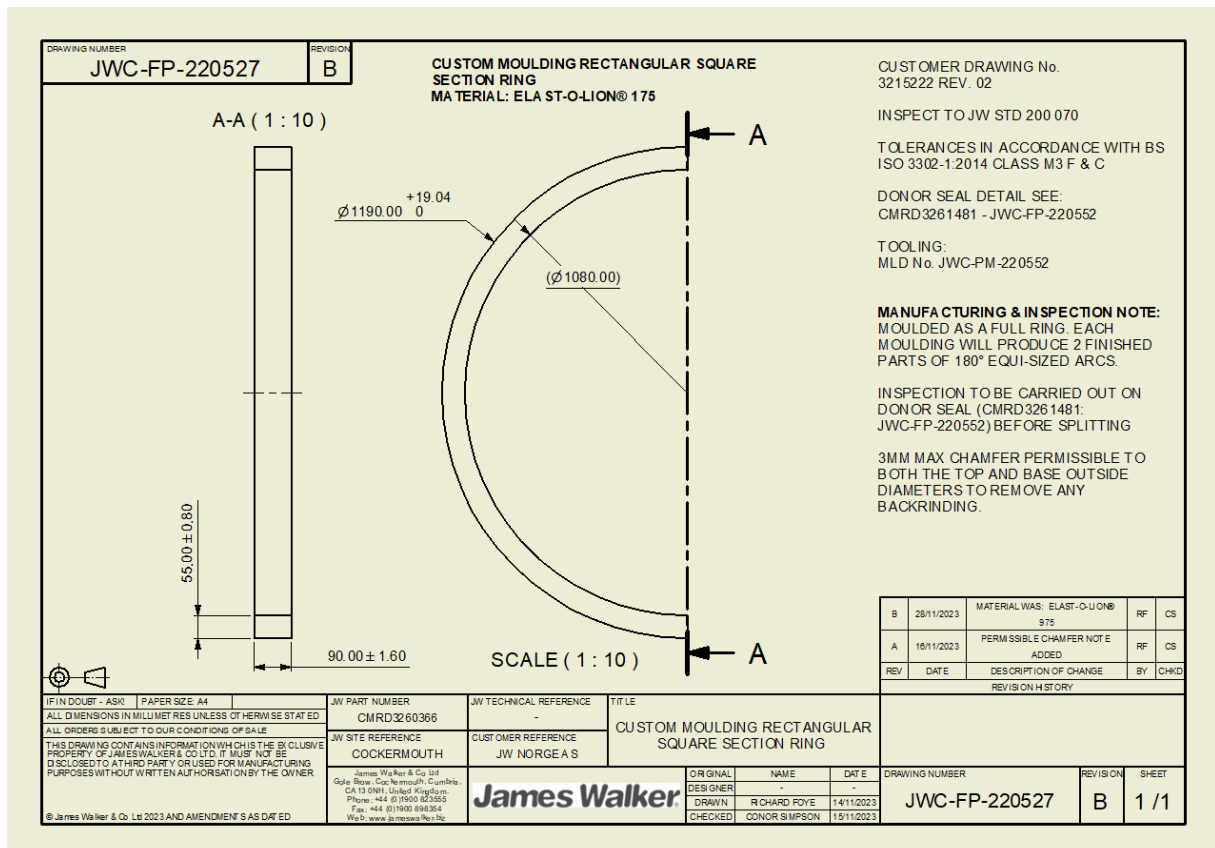


Image 12: Finished Part CMRD3260366 JWC-FP-220527