

James Walker	Title: IK NORWAY RECTANGULAR SQUARE SECTION VISUAL INSPECTION GUIDE	Date: Mar 06, 2024	Rev: 1	Page: Page 1 of	Document No: SIP 16 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 CMRD3260369 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-220528. (Customer DRG 3217611)

Seal Profile

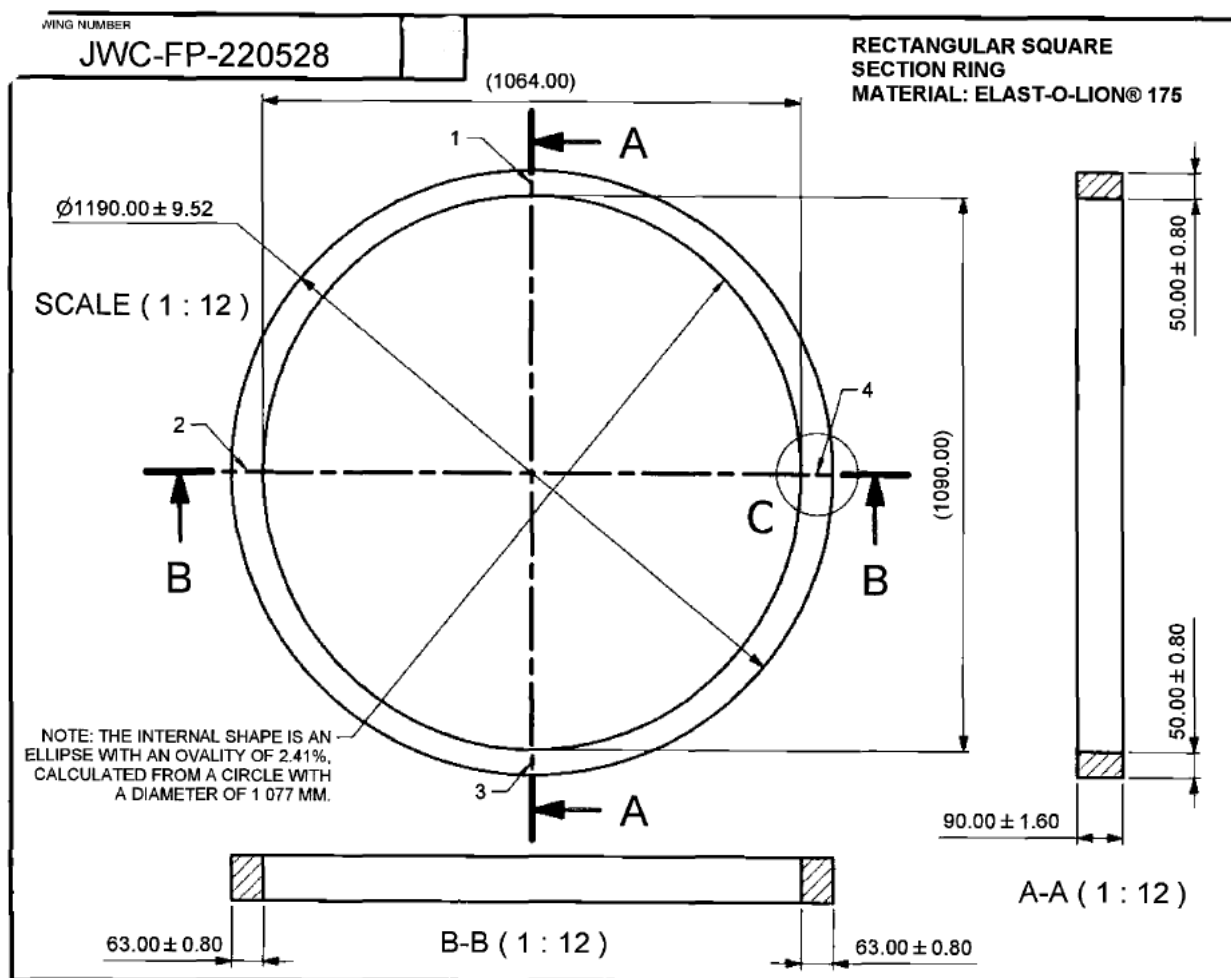


Image 1: Section drawing JWC-FP-220528

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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**.

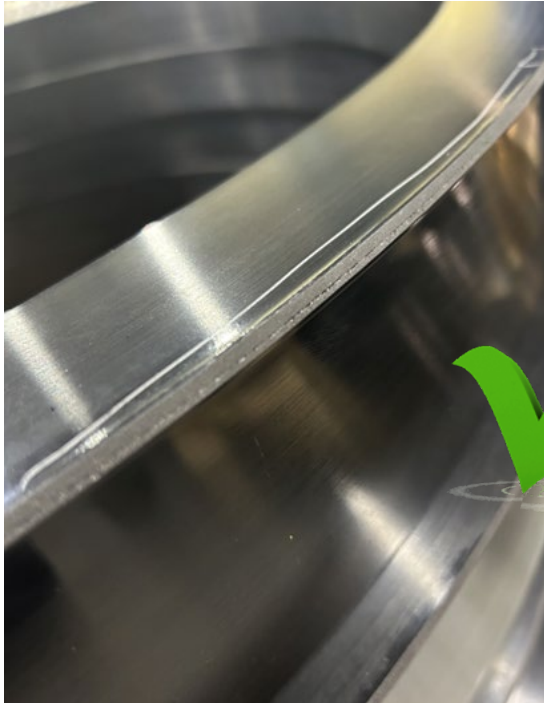


Image 4



Image 5

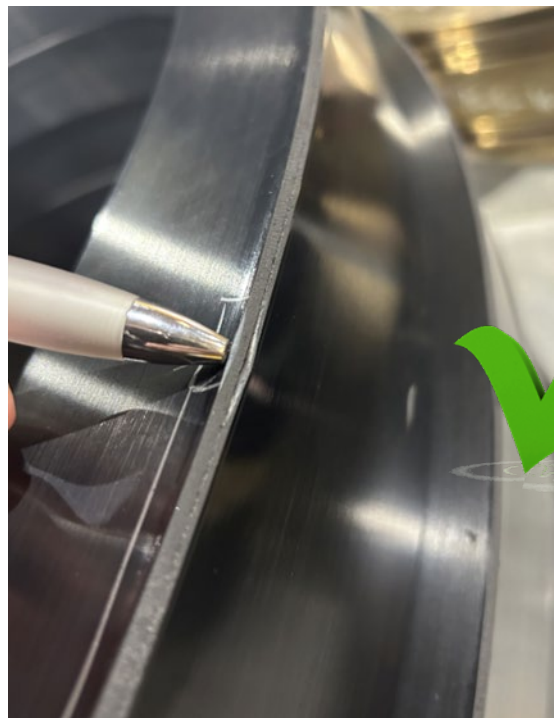


Image 6



Image 7

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Image 8: chamfer applied – severe evidence of back grinding remains **ACCEPTABLE**

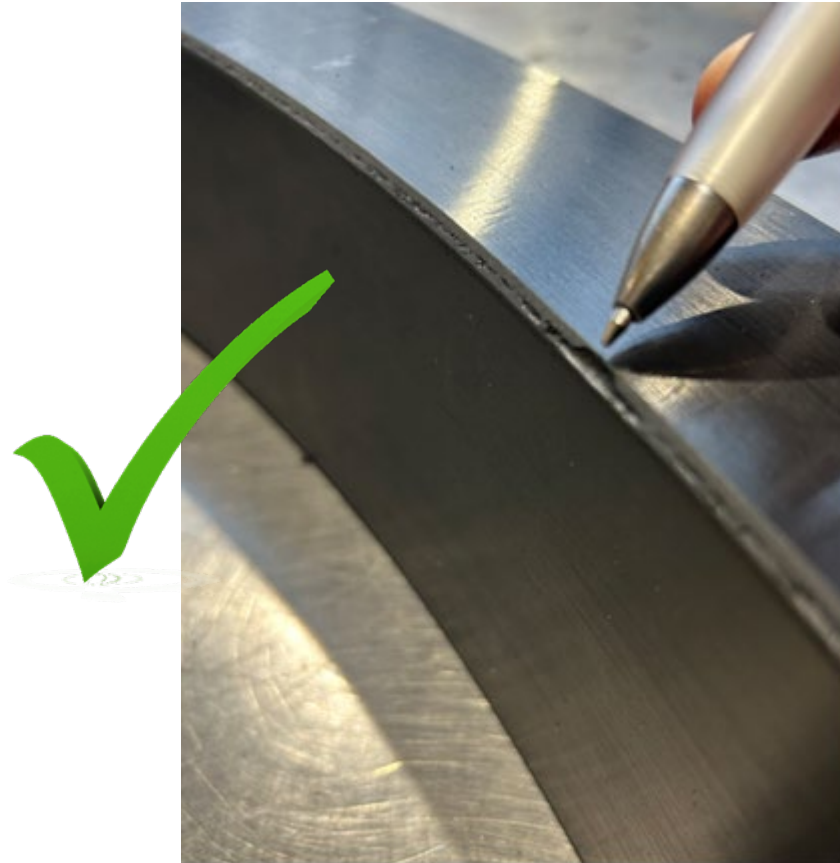


Image 8

Summary

As per Images 2-7, evidence of backrind is permissible after an applied MAX 6mm chamfer.

As per images 8, backrind is still severe after MAX 6mm chamfer is applied. Acceptance has been given by the customer.

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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It is common for FLOWMARKS / CREASES to present on the seal, customer have acknowledged and agreed a level of acceptance. See photographs for pass fail criteria.

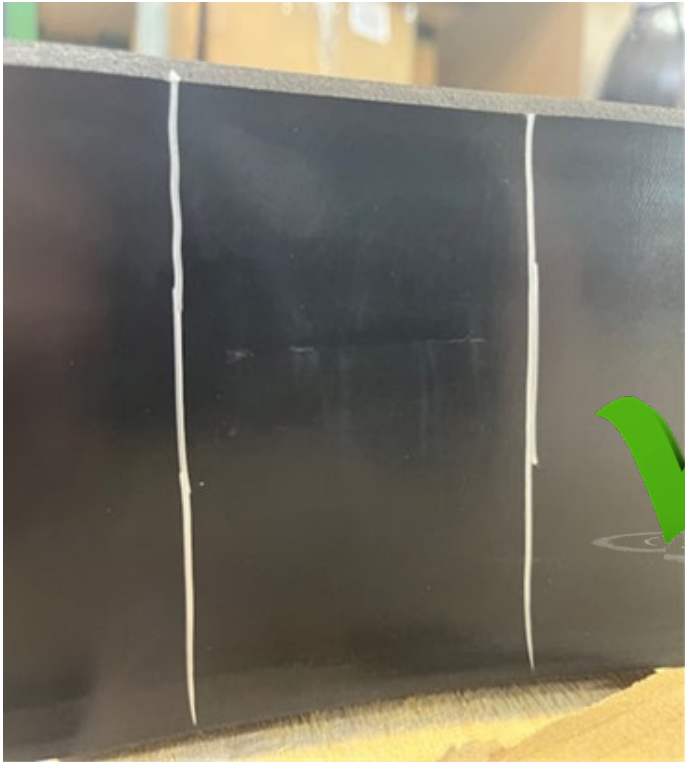


Image 9

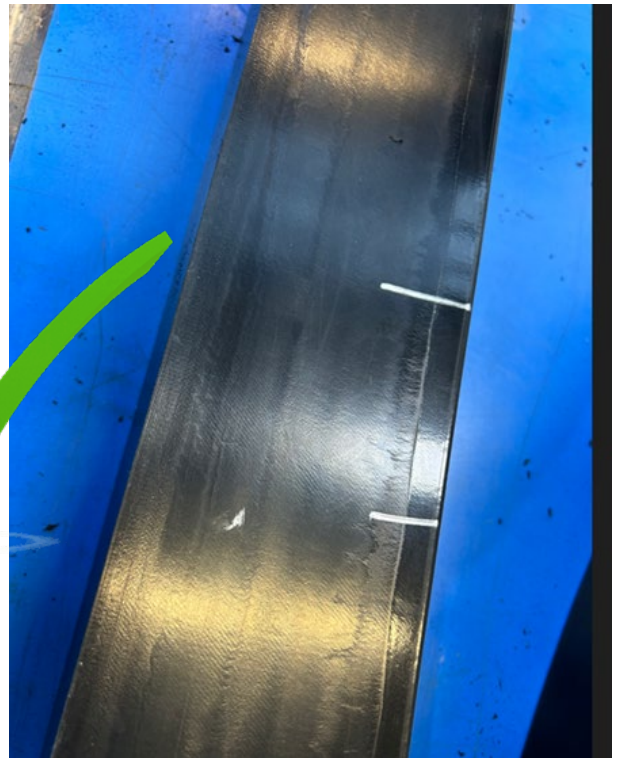


Image 10



Image 11



Image 12

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Image 13



Image 14



Image 15

Summary

As per Images 9-12, evidence of creasing and flow marks is permissible, providing it has been manipulated in a way that the crease doesn't open up to a split. **SPLITS are not permissible.**

As per images 14-15, Crease imperfection approximately 1 – 1.5 mm. This level of imperfection is **rejectable** however It is permissible to dress these imperfections.

If an imperfection on image 15-17 can be dressed to the level of imperfection on a 11-14 image, This is then acceptable.

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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It is common for NON FILL to present on the seal, customer have acknowledged and agreed a level of acceptance. See photographs for pass criteria.



Image 16



Image 17

Summary

As per Images 16-17, evidence of non-fill imperfections is permissible, approximate length varying between 2 – 5 mm.

These types of imperfections are to be left as moulded and not cleaned up unless customer advises otherwise.

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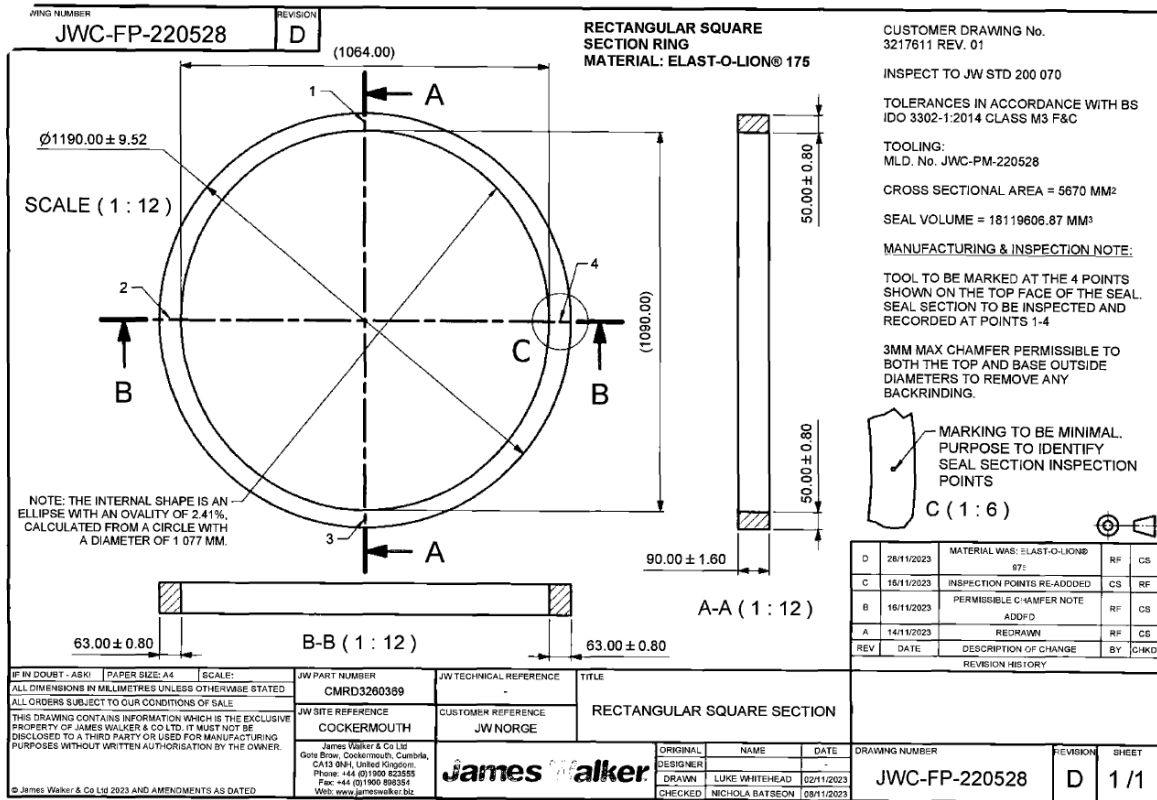


Image 18: Finished Part CMRD3260369 JWC-FP-220528