

James Walker	Cured Extruded Products	Date: Feb 17, 2020 Reaffirmed 2023	Rev: 1	Page: Page 1 of 2	Document No: QPD36 A Approved by: Extrusion Manager
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REASON FOR UPDATE: Document Review

ASSOCIATED DOCUMENTS: FMP Ref: [FMP 12](#) OPI Ref: [OPI 21](#), OPI 63

1. **PURPOSE**

1.1 To provide a procedure for cured extruded products aka finish extrusion

2. **SCOPE**

2.1 This document applies to all those involved with cured extruded products.

3. **RESPONSIBILITY**

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

4. **PROCEDURE**

Stage	Action Points
Material Check	1. Is the material in specification and shelf life?
Initial Sample Quality Check	2. Check the temperature profile provided on the paperwork or use OPI63 for correct temperature profile of the rubber. 3. At start of the process do the initial dimensional check to ensure that the die is correct and provides the correct extrudate sizes. 4. Use of JW Standards 200.001, 200.022 or 200.112 as relevant. 5. Damaged Die to be reported to Extrusion Manager/ Team leader for evaluation and repair.
Production	6. Ensure safe feeding of rubber strips into extruder – do not use metal tools to assist.
Continuous Quality Check	7. Continuous dimensional and visual check should be carried out by extruder operator. 8. No material to be autoclaved before dimensional and visual check. 9. Any doubts to be referred to Quality department. 10. Damaged Die to be reported to Extrusion Manager/ Team leader for evaluation and repair. 11. Stamp the Discrete Job after completing the extrusion process and checking the extrudate.
Autoclave Operation	12. See OPI 21 for curing of rubber extrusion using an Autoclave or oven. 13. Fill in the autoclave book with the detail to ensure traceability.

The electronic format is the official master version. Verify hard copies against the electronic version.

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	14. Labels/discrete job to be stamped confirming autoclaving completed by the operator.
Post-Autoclave	15. Complete any additional operations e.g. clean, post cure, etc. 16. Discrete job to be stamped confirming post cure process.
Final Quality Check	17. Dimensional and visual inspection to be done and recorded on the relevant sheet by the extruder operator. 18. Use of relevant JW Inspection Standards 200 series. 19. Inspection record sheet to be stamped by extruder operator. 20. Damaged Die to be reported to Extrusion manager/ Team leader for evaluation and repair.
Label as per Requirements	21. Book the job out. 22. Print required number of labels. 23. Attach the oracle label to the goods. 24. Check batch number is printed on the label, if not, hand writes them on.
Delivery	25. Place finished goods at correct location for collection as per the requirement.