
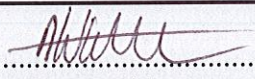


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## DOCUMENT APPROVAL

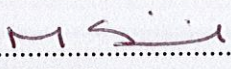
### Author's Signature:

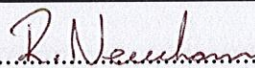
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| <b>Signature</b>  |  | <b>Date</b> | 25 APR 2018 |
| <b>Print Name</b> | Adrian Worthington  |             |             |
| <b>Title</b>      | Senior Operations Training Coordinator  |             |             |

### Reviewer's Signature:


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| <b>Signature</b>  |  | <b>Date</b> | 25 <sup>TH</sup> APRIL 2018 |
| <b>Print Name</b> | Mark Sinfield   |             |                             |
| <b>Title</b>      | Head of Production  |             |                             |

|                   |   |             |                           |
|-------------------|---|-------------|---------------------------|
| <b>Signature</b>  |  | <b>Date</b> | 25 <sup>TH</sup> Apr 2018 |
| <b>Print Name</b> | Rob Newham  |             |                           |
| <b>Title</b>      | Dual Site Operations Manager  |             |                           |

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| <b>Signature</b>  |  | <b>Date</b> | 02 May 2018 |
| <b>Print Name</b> | Gary Crawley  |             |             |
| <b>Title</b>      | Quality Assurance & Systems Manager   |             |             |

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## 1.0 PURPOSE

- 1.1. The purpose of the document is to define the SOP (Standard Operating Procedures) to be followed by ADVANEX EUROPE Ltd, in order to ensure that the flat shape is formed by the RMT HP12 Press is in a controlled and consistent manner.

## 2.0 SCOPE

- 2.1. For the purpose of this SOP, manufacturing only includes the forming operations of one bend.

## 3.0 TERMS, DEFINITIONS & ABBREVIATIONS

- 3.1. ERP – Enterprise Resource Planning

## 4.0 HEALTH, SAFETY & ENVIRONMENTAL

- 4.1. Within the factory area safety footwear is mandatory.  
4.2. Within the factory area safety glasses must be worn.  
4.3. Ear defenders must be worn in the designated area of the factory.  
4.4. Basket and bin weights must not exceed 12kg

## 5.0 ASSOCIATED DOCUMENTS

- 5.1. Machine Log and Daily Maintenance Record (Document Number AEU00674): used to record scheduled and any unplanned activity on a machine.

## 6.0 PROCEDURE

- 6.1. **Locate Required Tooling.** The drawing is located with the routing on the ERP system. Verify with the drawing, the radius required for the bend. Collect tool R 1/2MM from the racking on H Section.

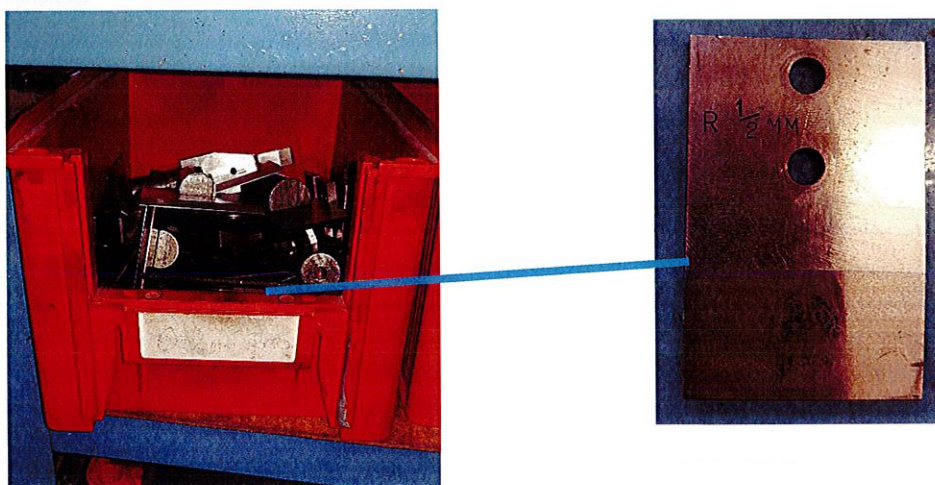



Figure 1: This tub is marked 0.2mm Rad found on H Section racking. Tool needed is highlighted to the right.



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6.2. **Fitting bend Tool.** Using two cap head screws, attach the bending tool to the press unit. Make sure that the tool is in line with the groove in the press table/ vice as shown in figure 2.

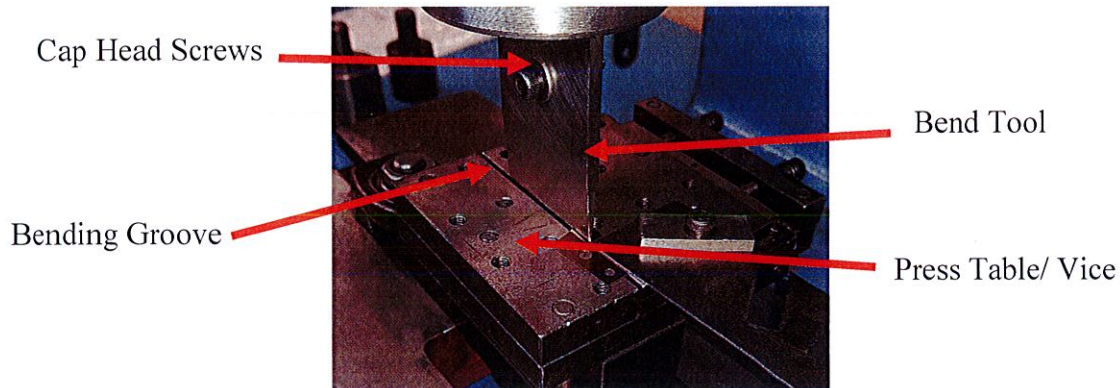


Figure 2: Bend tool fitted and in line with groove in press table/ vice.

6.3. **Setting Plate.** Figure 3 shows where the setting plate should be clamped to the press table/ vice. Position the setting plate so that when the component is pushed up to it and bent, the correct angle is created. **Always push the component into place with the two punched holes nearest you.** This will ensure the component is bent the same way each time.

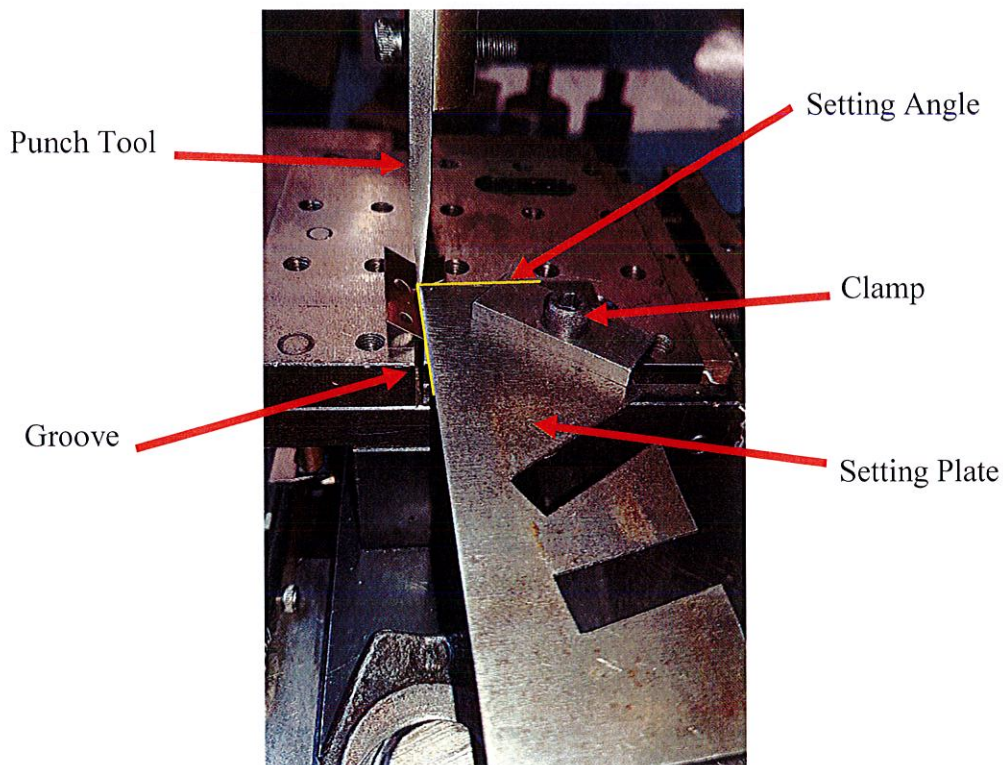



Figure 3: Setting plate shown in position to create the correct angle bent on the component.



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6.4. **Setting the Stroke.** On the right-hand side of the machine shown in figure 4, use the handle to add or remove the desired stroke needed. The compressed air needs to be released from the press before an alteration can be made (Figure 5). The information above the handle shows which way you should wind the handle to make your adjustment. The stroke should be set so that there is a gap less than 3mm. this is to ensure that you can't trap your fingers in the tool.

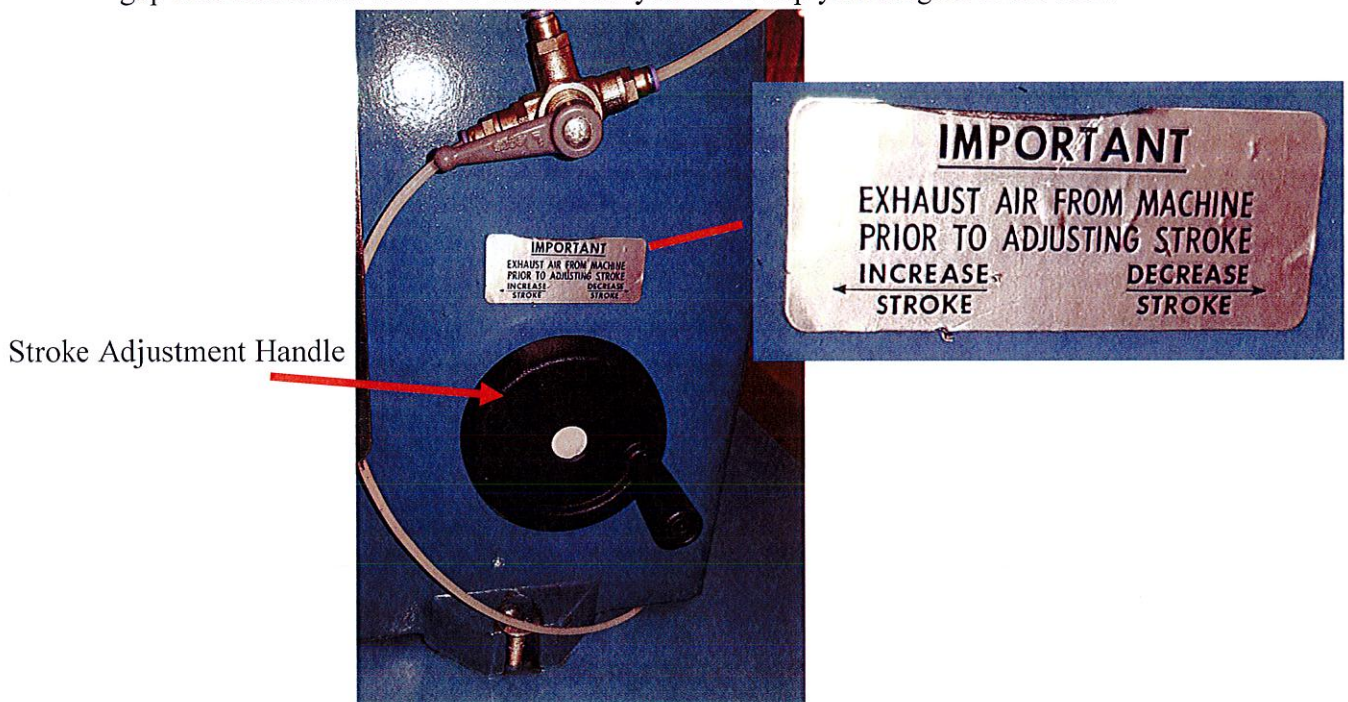


Figure 4: Shows the stroke adjustment handle and the information for adjustment.

6.5. **Exhaust Air From Machine.** In order to release the air from the press you need to turn the pressure release switch. The gauge will show you when all the air has been expelled out.

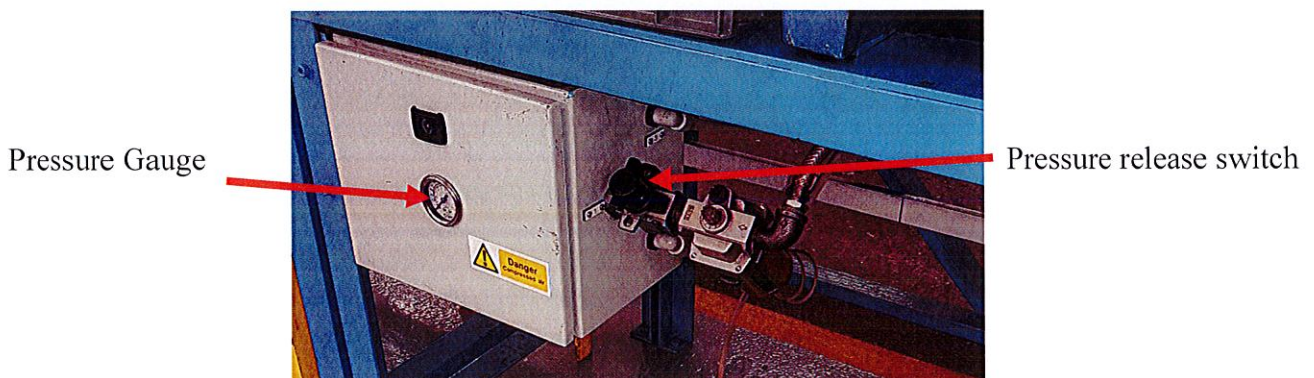



Figure 5: Compressed air gauge and pressure release switch.



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**6.6. Tool Adjustment.** In order to achieve the correct bend angle on the component, you will have to adjust the height of the bending tool. Firstly, release the air from the machine (Refer back to step 6.5). Loosen the four cap head screws and wind the adjustment screw in between them to set the height. (Figure 6) Remember to tighten the four cap head screws after adjustment.

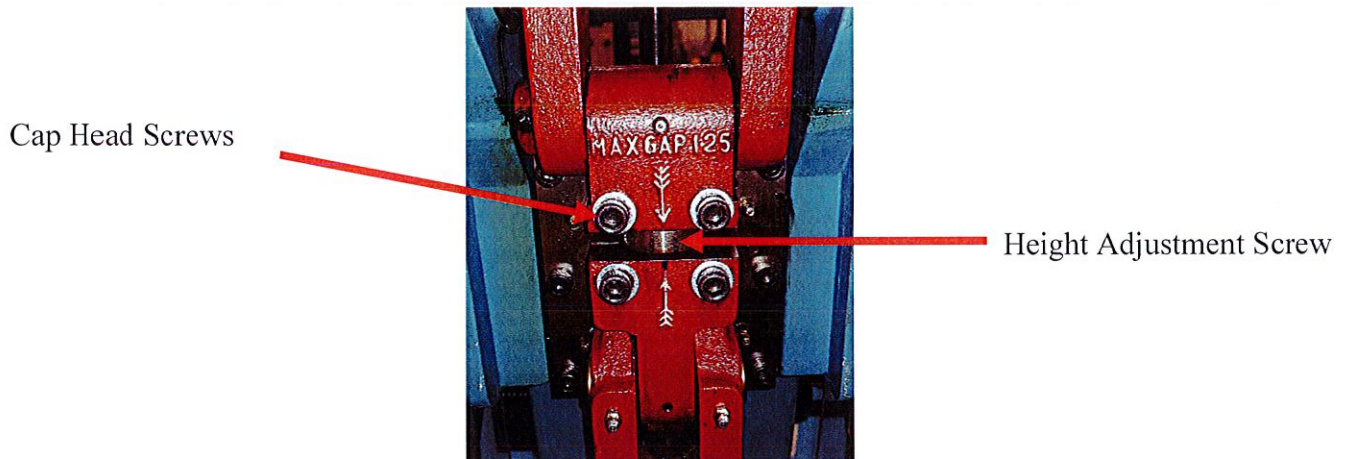


Figure 6: Tool Height Adjustment.

**6.7. Check Settings.** With the compressed air still off you can check that the tooling will not crash by manually pushing the tool up and down. Take the hood off the top of the press to show the pivot arm. Pushing on this point will move the tool to the upper and lower limits. Figure 7.

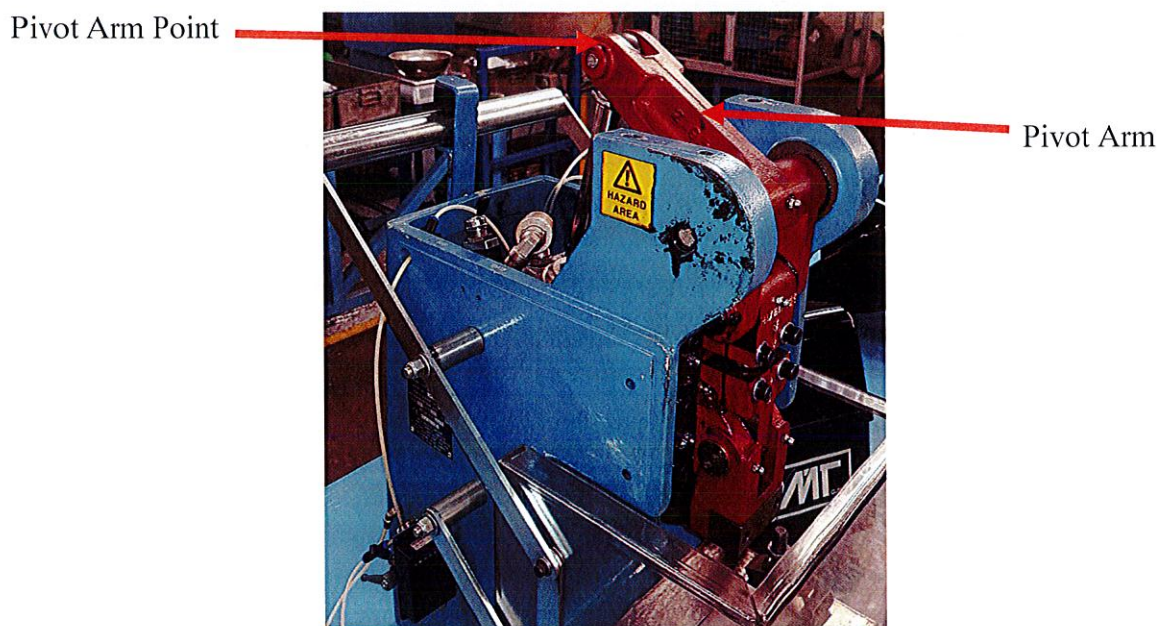



Figure 7: Showing the hood off the press top allowing access to the pivot arm.



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**6.8. Going over on power.** Replace the hood back on top of the press. Check all cap heads are tight. Turn the pressure release switch back on and check the pressure gauge is correct. Now you can use the foot pedal to power over the machine.



Foot Pedal



Press Hood Cover

**6.9.** Check the part to the drawing, if it is correct then you are ready to produce.