

METHOD STATEMENT FOR VULCANIZING

1. After following the daily procedures.
2. Carry out vulcanizing procedures to BS6593 1985.
 - (a) Mark bias worked out to one third of the belt width which is the angle of the vulcanizing machinery that will be used.
 - (b) Cut bias
 - (c) Overlap ends of belt, aligning them and transfer mark of bias onto other end
 - (d) Mark out step lengths which will be at least on 1250/5 ply 300mm, on 1600/5 ply 350mm
 - (e) Cut steps
 - (f) Remove steps by means of tirror
 - (g) Solution ends
 - (h) Re-build interply using cushion compound
 - (i) Join ends
 - (j) Fill in fillers with tread compound
 - (k) Put in press
 - (l) Cure for 35 minutes at 150 degrees centigrade (approximately 300 degrees Fahrenheit)
 - (m) Due to size of joint, multi-cure operations will be required. After curing has taken place allow the equipment to cool down to 70 degrees centigrade. Re-heat to 85 degrees centigrade
 - (n) Remove press and transfer to next stage of joint
 - (o) Repeat from (k) to (m)
 - (p) After final cure has been carried out, remove press, check joints and if everything is satisfactory, move onto next joint