

SAFE WORK PROCEDURES
Extruder Qualifying

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| Facility: Field | Written By: Kevin Donnelly | Approved By: Kevin Donnelly | Date Created: May 15, 2009 | Date of Last Revision: May 15, 2009 |
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| Hazards Present: | Personal Protective Equipment (PPE) or Devices Required: | Additional Training Requirements: |
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| <ul style="list-style-type: none"> • Electric shock • MSI • Burns | <ul style="list-style-type: none"> • Gloves • Safety Footwear • Hard hat | <ul style="list-style-type: none"> • In house Extruder Training • Lift/Material Handling |

Safe Work Procedures:

1. Start up extruder (See Extruder Shut Up and Shut Down Safe Work Procedure)
2. Cut 2 strips of product to be welded, 4' – 5' long and 10" wide.
3. Leister them together with a minimum of a 2" overlap (See Leister Safe Work Procedure)
4. Grind (sand) the path to be extruded. (See Grinding Safe Work Procedure)
5. Engage extruder trigger for a short period to push the semi solidified plug of extrude from the teflon shoe.
6. Discard plug.
7. Place Teflon shoe on the beginning of grinding path.
8. Pull trigger to start extrude, hold the trigger for the full path of the extrude.
9. Slowly push extruder forward ensuring an even and consistent bead exits the rear of Teflon shoe.
10. At the end of the sanded area lift extruder from sheet.
11. Allow the extrude bead to cool (5-10 minutes).
12. Use the coupon cutter to cut 7 coupon (bones) test strips. (See Coupon Cutter Safe Work Procedure)
13. Use the Tensiometer (See Tensiometer Safe Work Procedure) to check for adequate fusion of the 2 test strips.
14. If the coupons pass the Tensiometer test, the extruder is ready for field welding.

Guidance Documents/Standards/Applicable Legislation/Other:

Guidance Documents:

- Operators Manual
- Manitoba Workplace Safety and Health Regulation, M.R. 217/2006:**
- 2.1 Safe Work Procedures
 - 6.1 Personal Protective Gear
 - 8 Musculoskeletal Injuries (MSI)
 - 16.4 Machine and Tool Safety

This Safe Work Procedure will be reviewed any time the task, equipment, or materials change and at a minimum every three years.