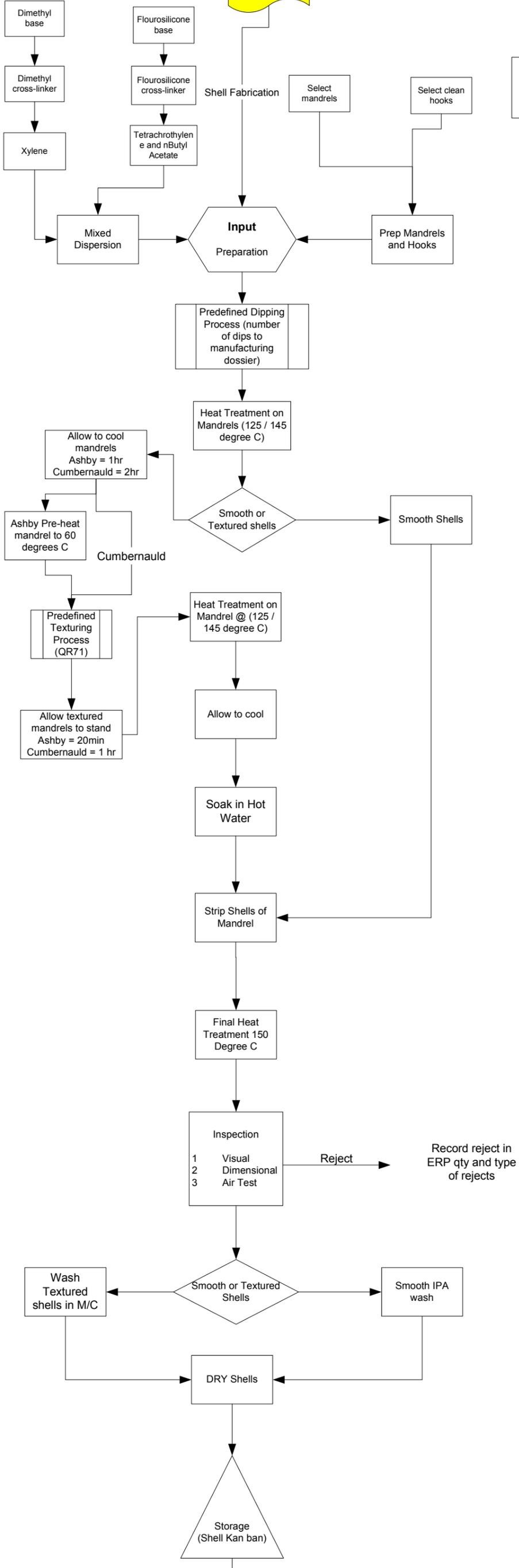
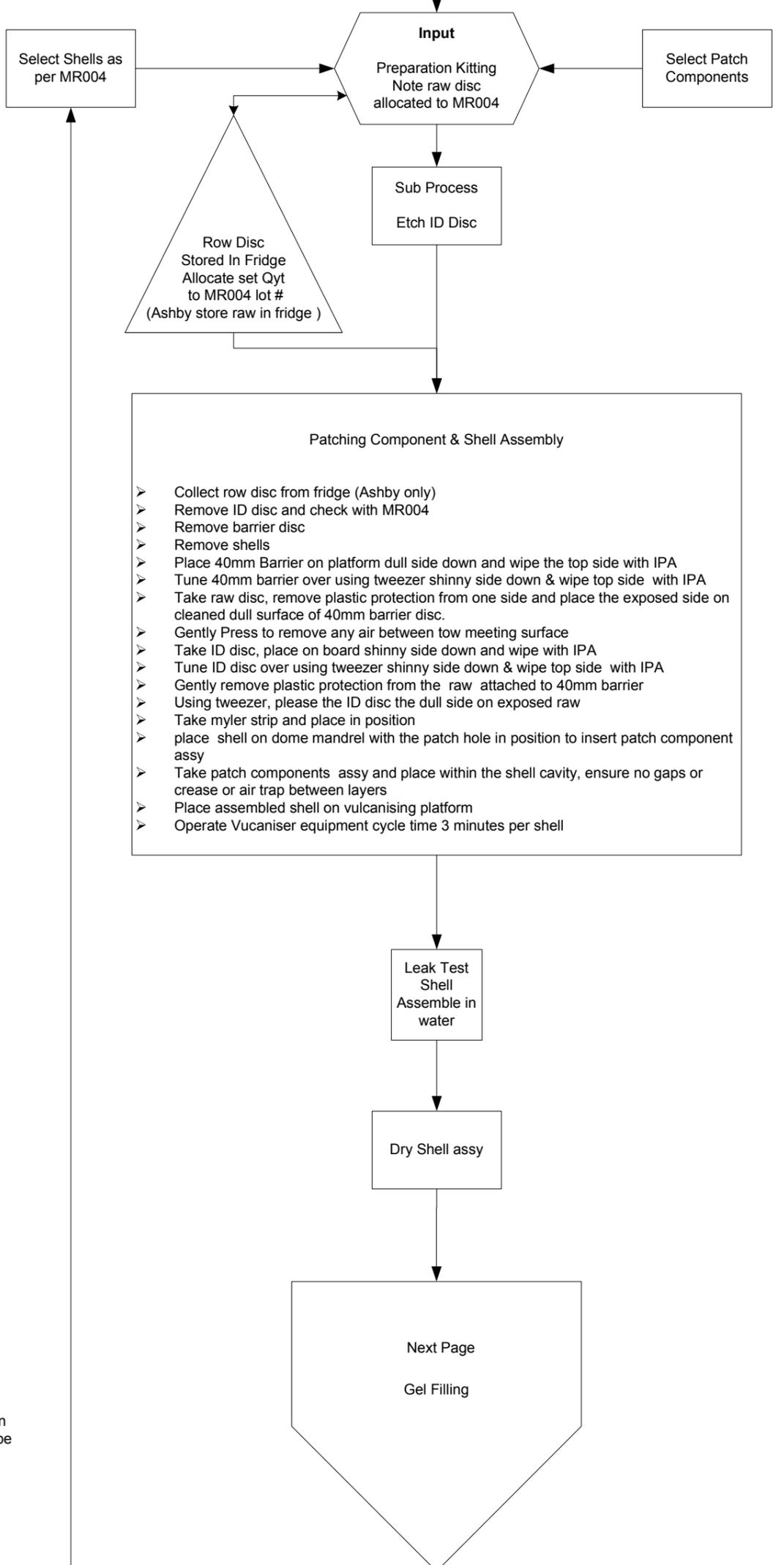


Issue MR003  
Shell  
Manufacturing

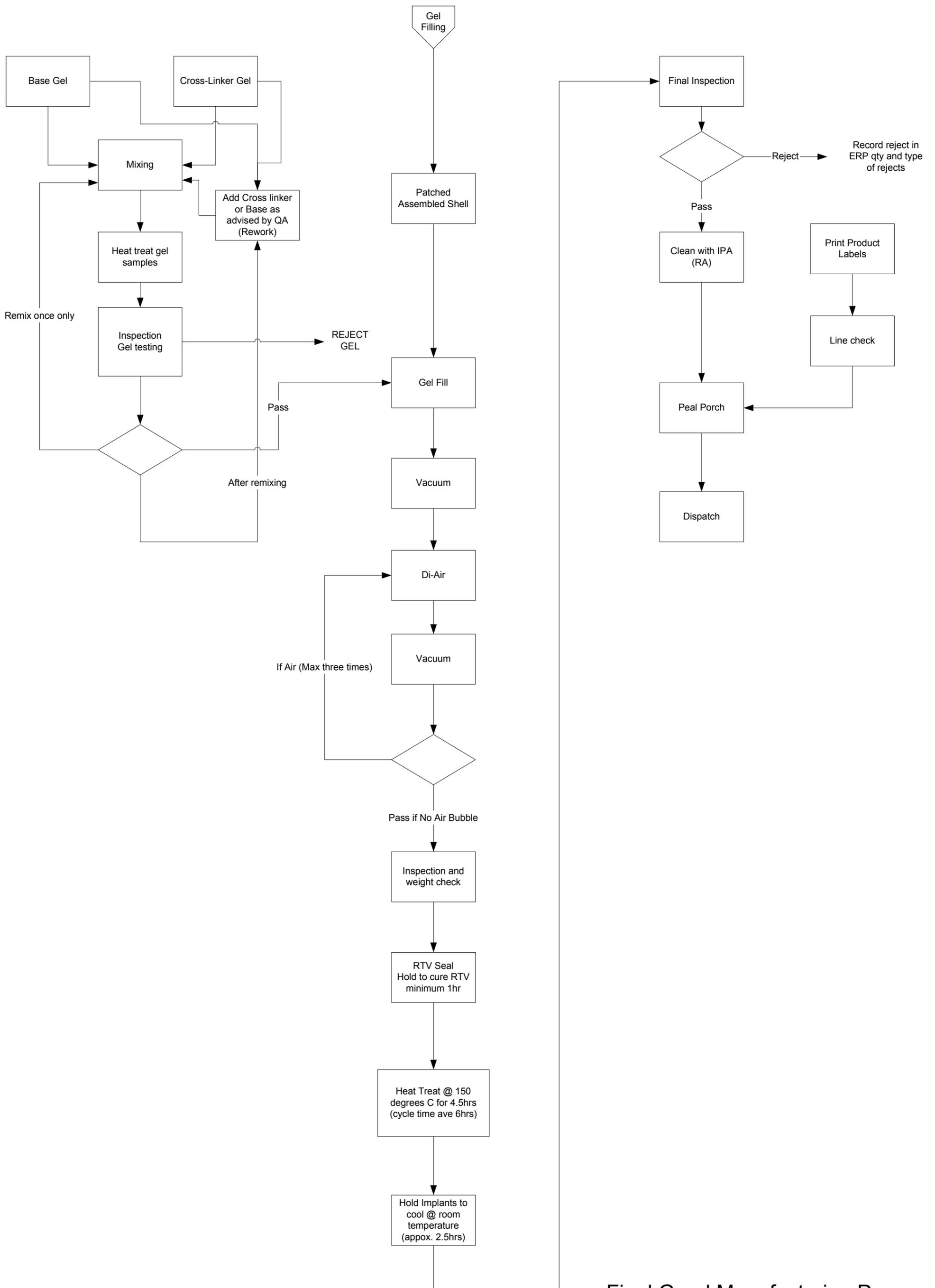


Issue MR004  
Finished Goods  
Manufacturing



- Patching Component & Shell Assembly**
- Collect row disc from fridge (Ashby only)
  - Remove ID disc and check with MR004
  - Remove barrier disc
  - Remove shells
  - Place 40mm Barrier on platform dull side down and wipe the top side with IPA
  - Tune 40mm barrier over using tweezer shiny side down & wipe top side with IPA
  - Take raw disc, remove plastic protection from one side and place the exposed side on cleaned dull surface of 40mm barrier disc.
  - Gently Press to remove any air between tow meeting surface
  - Take ID disc, place on board shiny side down and wipe with IPA
  - Tune ID disc over using tweezer shiny side down & wipe top side with IPA
  - Gently remove plastic protection from the raw attached to 40mm barrier
  - Using tweezer, please the ID disc the dull side on exposed raw
  - Take myler strip and place in position
  - place shell on dome mandrel with the patch hole in position to insert patch component assy
  - Take patch components assy and place within the shell cavity, ensure no gaps or crease or air trap between layers
  - Place assembled shell on vulcanising platform
  - Operate Vucaniser equipment cycle time 3 minutes per shell

Shell Assembly Manufacturing Process  
Prepared by Kanti Mistry (Ashby)  
22 April 2014



Final Good Manufacturing Process  
 Prepared by Kanti Mistry (Ashby)  
 22 April 2014