SAFE WORK PROCEDURES
Extruder Field Welding

Facility:	Written By:	Approved By:	Date Created:	Date of Last Revision:
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Hazards Present:	Personal Protective Equipment (PPE) or Devices Required:	Additional Training Requirements:
• Electric shock • MSI • Burns	• Gloves • Safety Footwear • Hard hat	• In house Extruder Training • Lift/Material Handling

Safe Work Procedures:

1. After the Extruder has been qualified (See Extruder Qualifying), field extrusion welding may begin.
2. Leister them together with a minimum of a 2" overlap (See Leister Safe Work Procedure)
3. Grind (sand) the path to be extruded. (See Grinding Safe Work Procedure)
4. Engage extruder trigger for a short period to push the semi solidified plug of extrude from the teflon shoe.
5. Discard plug.
6. Place Teflon shoe on the beginning of grinding path.
7. Pull trigger to start extrude, hold the trigger for the full path of the extrude.
8. Slowly push extruder forward ensuring an even and consistent bead exits the rear of Teflon shoe.
9. At the end of the sanded area lift extruder from sheet.
10. Allow the extrude bead to cool (5-10 minutes).

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.