

Standard Operating Procedure Bending Procedure for Rigid PVC	SOP No. 5.035
--	------------------

DCR No.: 03051
Revision No.: 1

Effective: 07-07-00
Supersedes: 07-07-00
Revision Date: 8-29-03
Page No.: 1 of 3

- 1 Purpose
 - 1.1 To establish a standard procedure for bending rigid polyvinyl chloride (PVC).
- 2 Scope
 - 2.1 The procedure applies to any rigid PVC.
- 3 Responsibility
 - 3.1 Therma's foreman is responsible for ensuring that the journeymen are performing the following procedures.
- 4 Procedures
 - 4.1 Obtain the following required equipment/ materials prior to bending PVC.
 - 4.1.1 PVC Heater
 - 4.1.2 Bending Table
 - 4.1.3 Plugs
 - 4.1.4 Water
 - 4.1.5 Rags
 - 4.1.6 Isopropyl alcohol (IPA)
 - 4.2 When marking piping for bends, use felt tip pens only. This color will be removed by using IPA.
 - 4.3 Layout blocks on the bending table.
 - 4.4 Plug the ends of the pipe to be bent.
 - 4.5 Heat the pipe using the PVC heater.
 - 4.6 When the pipe softens, form the bends using the bending jig.

THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION OF THERMA CORPORATION. ALL INFORMATION SHALL (A) BE RETAINED IN CONFIDENCE; (B) NOT BE REPRODUCED IN WHOLE OR IN PART; AND (C) NOT BE USED OR INCORPORATED IN ANY PRODUCT EXCEPT UNDER EXPRESSED WRITTEN AGREEMENT WITH THERMA CORPORATION.

Revision No.	SOP No.	Page
1	5.035	2 of 3

- 4.7 Cool the form with water and rags.
- 4.8 Remove plugs and wipe off construction lines with IPA.
- 5 Review and Approval
 - 5.1 Upon completion of the procedure, the journeyman shall submit their results to the Therma's foreman for review and approval.

Revision No.	SOP No.	Page
1	5.035	3 of 3

Document Approval

Jim McGovern
Plastic Fabricator

8-28-03
Date

Steve Rusconi
Engineering, Vice President

8-28-03
Date

Debra
Quality Assurance Manager

8-28-03
Date

THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION OF THERMA CORPORATION. ALL INFORMATION SHALL (A) BE RETAINED IN CONFIDENCE; (B) NOT BE REPRODUCED IN WHOLE OR IN PART; AND (C) NOT BE USED OR INCORPORATED IN ANY PRODUCT EXCEPT UNDER EXPRESSED WRITTEN AGREEMENT WITH THERMA CORPORATION.