

**CON-SERV INC**  
**STANDARD OPERATING PROCEDURE**

S.O.P. NO 1011

EFFECTIVE DATE: January 1, 1979

DESCRIPTION:

Q.C. APPRVD: *R.P.*

Manufacturing steps for fabrication of typical slide bearings

SHT. 1 OF 1

REVISED DATE: October 28, 1996

| STEP | PROCEDURE   | COMMENTS  |
|------|---|---|
| 1.   | Prepare steel per appropriate S.O.P. depending on gauge and type.   |   |
| 2.   | Prepare adhesive per appropriate S.O.P., either standard or hi-temperature.   |   |
| 3.   | Prepare the tape for bonding using the appropriate S.O.P.   |   |
| 4.   | Apply the adhesive either to the steel or the etched surface of the tape as is appropriate for the size and number of bearing plates. Apply with a toothed trowel blade so that a thin (5 to 10 mils) layer of adhesive is uniformly spread over the entire bondable surface. | In summer conditions a flat blade may be appropriate.                                       |
| 5.   | Place steel and tape together and slide into bonding press.   |   |
| 6.   | Set bonding pressure appropriate as follows: 1000 psi. gauge for 24" x 48" sheet.   | If the area is less, reduce the gauge pressure according directly proportional to the area. |
| 7.   | Close pre-heated press on the steel and tape.   | Check for slippage of the tape.   |
| 8.   | Cure the adhesive per the S.O.P.  |   |

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CK'D BY \_\_\_\_\_

RESUBMIT APPROVED

BY \_\_\_\_\_ DATE 01-05-07

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