

**Impregnation procedure specification SM3 & SM3/2**

- Load clean & dry components to be processed into process baskets, so as to avoid damage & to provide maximum drainage.
- Load into autoclave.
- Commence a dry vacuum process, minimum vacuum of 8m/bar must be achieved for a minimum period of five minutes.
- Introduce sealant from storage reservoir-submerging the components.
- Maintain wet vacuum, 8m/bar maximum for a minimum time of five minutes.
- Release vacuum.
- Subject components to a pressure application of 7 bar, for a minimum period of five minutes.
- Return sealant to storage reservoir.
- Remove components from autoclave to drain. Transfer to centrifuge for a minimum of three-minute spin.
- Transfer to cold-water wash and reciprocate for one-minute minimum.
- Transfer to cold-water rinse and agitate for thirty seconds minimum.
- Visually inspect to ensure removal of surface sealant.
- Submerge components into hot water cure bath maintained at 90-95 centigrade for a minimum of ten minutes.
- For a double impregnation (SM3/2) the above is repeated.
- Remove & inspect components.