EB-3: STANDARD CLEANING PROCEDURES

All components shall be processed according to the following guidelines:

After machining and gross cleaning operations are complete, all parts shall be cycled through a Two-Stage Vapor degreasing system that will be charged with *ENSOLV* cleaning fluid. Stage One of the degreaser is the vapor zone and the cleaning fluid shall be kept at its boiling point. The degreaser shall have sufficient heat capacity to insure that Stage One remains boiling at all times during operation. Stage Two of the degreaser is the immersion zone and the liquid shall be kept between 142° F and 146° F at all times during operation. Stage Two shall also be equipped with 40 kHz sweep frequency ultrasonic energy emitters and submerged spray jets. The geometry and relative cleanliness of the parts being cleaned shall dictate which of these two cleaning aids shall be employed.

The parts shall be placed in baskets and progressively moved through 5 stations within the degreaser using a conveyor that is outfitted with a programmable controller. The controller shall be set so that the linear speed of the parts between the stations does not exceed 11 feet per minute. The controller shall also be programmed to insure that each basket will remain at each station for a minimum of 45 seconds. The total cycle time, in the degreaser, for each basket of parts shall be no less than 7 minutes.

After the parts are removed from the degreaser they will be inspected for signs of remaining contamination. The parts must be free of grease, oils and other contaminants as judged by visual, olfactory, and tactile inspection.