Cleanliness Requirements. Doc# 6029-1227

3.a When the component is ready for shipment after completion of fabrication, all applicable hardware internal surfaces and parts shall be dry and visually clean (e.g. free of dirt, loose corrosion products, grease, oil, machining particles, and other foreign material). A thin adherent oxidation film from heat treatments or welding, a light superficial rust film on carbon or alloy steel, and a few discrete lint fibers (less than one fourth inch In length) are acceptable.

b. Internal surfaces and parts, which cannot be cleaned after assembly shall be cleaned and inspected prior to the assembly operation that precludes further cleaning. During subsequent assembly operations, such parts shall be protected from entry of dirt, grit, cutting oils, and other foreign material. However, flushing may be used to clean after assembly where it Is demonstrated to be effective for the hardware geometry and material to be removed.

c. A visual inspection of internal surfaces and parts through remaining hardware openings shall be performed prior to Shipment to verify compliance with paragraph 3.a above. Following this inspection, all hardware openings not covered by permanent closures shall be scaled with temporary cleanness covers or captivated plugs made of rigid rubber, rigid plastic, or metal. Except for polytetrafluoroethylene (Teflon), covers or plug materials shall not contain sulfur or other halogens In their chemical structure. For example, fluorocarbon (e.g. Viton) or chlorocarbon (e.g., chloroprene [Neoprene)) rubber or plastic shall not be used for these covers or plugs. Internal parts, if packaged separately, shall be sealed in plastic bags or other suitable packaging that maintains cleanliness.