

CLEANING LABORATORY EVALUATION SUMMARY

SCL #: 1995
 DateRun: 07/11/1995
 Experimenters: Donald Garlotta, Jay Jankauskas
 ClientType: Adhesive Manufacturer
 ProjectNumber: Project #1
 Substrates: Stainless Steel
 PartType: Part
 Contaminants: Cutting/Tapping Fluids, Lubricating/Lapping Oils, Metal fines, Oil
 Cleaning Methods: Ultrasonics
 Analytical Methods: Visual, microscopic
 Purpose: Positions down for cleaning

Experimental Procedure: WR Grace Daraclean 283 at 10% will be used at 150 F for 15 minutes. The parts will then be rinsed in Tap water and then DI water, both for 5 minutes at 150 F. The parts will then be dried under air knives for two minutes and then in a convection oven for 60 minutes at 140 F. After drying, the parts will be examined under a microscope.
 Trial #2 will have the part's blind holes facing down coming directly in contact with the Ultrasonic waves.

Results: Trial #2- Looks a heck of a lot better, there appears to be absolutely no fines on the surface of the parts or the screw heads, but there are still a few fines left in the holes most of these are probably burrs. Burrs won't be solved with cleaning, this is a machining issue.

Summary:

Substrates:		Stainless Steel			
Contaminants:		Cutting/Tapping Fluids, Lubricating/Lapping Oils, Metal fines, Oil			
Company Name:	Product Name:	Conc.:	Efficiency:	Effective:	Observations:
Magnaflux	Daraclean 283	10		<input checked="" type="checkbox"/>	

Conclusion: Trial #2- To remove the remaining fines, the cleaning time should be bumped up to 20 minutes and a little rinse agitation should be used.