

CLEANING LABORATORY EVALUATION SUMMARY

SCL #: 2007

DateRun: 10/16/2007

Experimenters: Jason Marshall, Shweta Bansal

ClientType: Chemical Company

ProjectNumber: Project #1

Substrates: Aluminum

PartType: Coupon

Contaminants: Cutting/Tapping Fluids

Cleaning Methods: Immersion/Soak

Analytical Methods: Gravimetric

Purpose: To evaluate supplied products on first contaminant using immersion cleaning

Experimental Procedure: Four products were diluted to the requested levels and heated to 135 F on a hot plate. In addition, water was used as a control solution. Eighteen preweighed Aluminum 6061 T6 coupons were coated with Cinster cutting fluid using a handheld swab. Coupons were weighed a second time to determine the amount of cutting fluid added.

Three coupons were immersed in each solution and cleaned for five minutes using minimal stir-bar agitation. Coupons were rinsed in either DI water or tap water heated to 135 F. One product was rinsed in room temperature tap water as requested. All coupons were dried for 10 minutes in an oven at 140 F. After drying, coupons were weighed a third time and product cleaning efficiencies were calculated.

Requested Procedure:

A. General Process
Soaking for 5 minutes at 135 degrees F and rinsing for 5 minutes at a temperature selected in procedure B below. During the soaking and rinsing the solution should be gently stirred to simulate effect of typical continuous flow filtering in both cleaning and rinse tanks. Then dry thoroughly in drying oven of type that is typically used in precision cleaning applications. The rinse water should be changed after each set of 3 tests to prevent contaminant buildup.

B. FPC testing.
Mix FPC 100-add 7 oz of concentrate to 123 oz of filtered tap water when both are at room temperature. Then run process of A above with rinse tank at room temperature and repeat with rinse tank at 135 degrees F.

C. Other products
Use process A above. at dilutions shown but rinsing with DI water instead of tap water for the Metalnox M6440.

Products to Evaluate
Metalnox M6440 @ 10% solution
Extreme Simple Green Aircraft Cleaner@10% solution.
Gemtec Aircraft cleaner @ 15% solution.
Kleen Tec 715@ 1 part concentrate to 11 parts water

Results: All products removed over 99% of the Cinster cutting fluid. The table lists the amount of soil added, the amount remaining and the calculated efficiencies.

| Cleaner | Initial wt | Final wt | % Removed |
|----------------|------------|----------|-----------|
| Metalnox M6410 | 0.3181 | 0.0013 | 99.59 |
| | 0.2965 | 0.0004 | 99.87 |
| | 0.3933 | -0.0007 | 100.18 |
| SC Aircraft | 0.3779 | 0.0009 | 99.76 |
| | 0.5367 | 0.0004 | 99.93 |
| | 0.2224 | 0.0007 | 99.69 |
| KT 715 | 0.4900 | 0.0012 | 99.76 |
| | 0.4155 | 0.0012 | 99.71 |
| | 0.3697 | 0.0012 | 99.68 |
| FPC 100 | 0.3241 | 0.0003 | 99.91 |
| | 0.2903 | -0.0001 | 100.03 |
| | 0.2494 | 0.0008 | 99.68 |
| Water | 0.2390 | 0.0012 | 99.50 |
| | 0.0950 | 0.0011 | 98.84 |

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|--------------------|--------|--------|--------|
| | 0.3424 | 0.0007 | 99.80 |
| FPC 100 cold rinse | 0.2705 | 0.0007 | 99.74 |
| | 0.2496 | 0.0000 | 100.00 |
| | 0.3332 | 0.0006 | 99.82 |

Summary:

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|-------------------------------------|---|---------------|--------------------|-------------------------------------|----------------------|
| Substrates: | Aluminum | | | | |
| Contaminants: | Cutting/Tapping Fluids | | | | |
| Company Name: | Product Name: | Conc.: | Efficiency: | Effective: | Observations: |
| Kyzen Corporation | Metalnox M6440 | 10 | 99.88 | <input checked="" type="checkbox"/> | |
| Gemtek Products | SC Aircraft & Metal Cleaner Super Concentrate | 10 | 99.79 | <input checked="" type="checkbox"/> | |
| Klean Tec | KT 715 | 8.3 | 99.71 | <input checked="" type="checkbox"/> | |
| Environmental Solution Products Inc | FPC 100 | 5.4 | 99.87 | <input checked="" type="checkbox"/> | |
| Water | Water | 100 | 99.34 | <input checked="" type="checkbox"/> | |
| Environmental Solution Products Inc | FPC 100 | 5.4 | 99.85 | <input checked="" type="checkbox"/> | cold rinse |

Conclusion:

The same testing process will be conducted using the second supplied contaminant.