

# 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:

<b>Substrates:</b>		Stainless Steel			
<b>Contaminants:</b>		Cutting/Tapping Fluids, Lubricating/Lapping Oils, Metal fines, Oil			
<b>Company Name:</b>	<b>Product Name:</b>	<b>Conc.:</b>	<b>Efficiency:</b>	<b>Effective:</b>	<b>Observations:</b>
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.