

Class B Solid Stack Parts Wash Process

This document captures how the LHO SUS Solid Stack was cleaned and baked as CLASS B. Jan 2010. Jeff Bartlett/B. Bland

1. Setup Large Parts Washer with a 2% Citrajet (4 gallons Citrajet to 200 gallons DI water) at 120F.
2. Place Solid Stack parts on LPW basket so they are not overlapping or touching each other and cannot move during the wash cycle.
3. Run a 10-minute wash cycle with a 2-minute drain.
4. Run a 10-minute rinse cycle with a 2-minute drain, in DI water with a starting temperature of 120F.
5. After the rinse cycle (be sure to wait for the 2-minute drain cycle to end) give the parts a final wand rinse with clean DI water to remove any leftover soap film.
6. Dry parts by hand and place on LABO cart.
7. Cover parts with foil until cart is ready to be placed into LABO for bake.

Notes: We took five FTIR samples (2 from the cart and 3 from the parts) before the bake. We will take after bake FTIR samples from the same locations.

These parts were air baked at 120C for 48hours in the large air bake oven, with a 4 hour cool down to 75C, and then a final cool down to 23C.