



WORK INSTRUCTION

Tube Cleaning procedure for Ferrous & Nickel Base Alloys

REVISION: 00

PROCEDURE NO.: WI-8.2.4.32

DATE EFFECTIVE: 05/22/09

A. **Scope:**

To remove all residue and foreign matter inside the tube prior to filling

B. **Materials and Equipment**

Manually operated or power driven equipment

Stainless or rust free steel wire

Clear Methyl Ethyl Ketone (MEK)

Isopropanol (Isopropyl Alcohol, 99%)

Cotton patches made from white, clean, lint free rags.

C. **Procedure:**

NOTE: Use MEK to clean wire and pulleys prior to use until no residue evident.

- 1) Insert wire into tube. Wet a patch with MEK and fasten it to wire. Patch must be large enough to be a snug fit with inside diameter of tubing.
- 2) Run patch through tubing.
- 3) Repeat with clean MEK wetted patches until patch remains free of residue
- 2) Run a clean dry patch through tubing. Patch must be a snug fit with inside diameter of tubing.
- 3) Run two patches in succession through tubing. Patches must be soaked with Isopropyl Alcohol.
- 4) Run a clean dry patch through tubing. Patch must be a snug fit with inside diameter of tubing. The patch must remain clean and dry; if not, repeat as necessary.
- 7) Remove stainless steel wire. Cap ends of tubing.

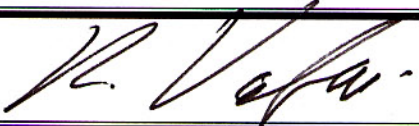


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AUTHORIZATION

POSITION	HELD BY	AUTHORIZATION SIGNATURE OR INITIALS
Prepared By: Product Engineering Manager	Ron Vafai	
Senior Management Representative/ Management Representative:	Abe Joseph	