

CLEANLINESS CRITICAL HYDRAULIC COMPT

1. HYDRAULIC COMPONENTS ON THIS ORDER HAVE BEEN DETERMINED TO BE "CLEANLINESS CRITICAL". THESE COMPONENTS ARE TO BE INSTALLED INTO THE HYDRAULIC SYSTEM AFTER SYSTEM FLUSHING.
2. CLEAN FABRICATED PARTS AFTER FINAL MACHINING AND BEFORE FINAL ASSEMBLY EITHER BY HAND CLEANING OR ULTRASONIC CLEANING USING SOLVENTS THAT DRY FILM-FREE.
3. COMPONENTS AND COMPONENT PARTS SHALL BE FREE OF FINIS, CHIPS, BURRS, SAND, MACHINING COMPOUND, DIRT, SCALE, RUST, AND OTHER FOREIGN MATERIALS.
4. THE ASSEMBLED COMPONENT SHALL BE CLEANED WITH PRESERVATIVE FLUID WHICH MEETS MIL-H-6083. THE METHOD OF CLEANING SHALL BE TO FLUSH OR CYCLE THE COMPONENT UNTIL FLUID WHICH HAS PASSED THROUGH THE COMPONENT MEETS THE FOLLOWING CRITERIA:

A. PARTICULATE LEVELS SHALL BE DETERMINED IN ACCORDANCE WITH THE METHODS AND PROCEDURES SPECIFIED IN MIL-STD-419 OR BY USING ANOTHER NAVSEA APPROVED METHOD. PARTICULATE MUST NOT EXCEED THE FOLLOWING MAXIMUM COUNT:

PARTICLE SIZE GREATER THAN	NO. OF PARTICLES PER 100 ML.
15 MICROMETERS	14,000
25 MICROMETERS	2,500
50 MICROMETERS	400

B. WATER CONTENT NOT TO EXCEED 0.05% BY VOLUME AND IS TO BE DETERMINED IN ACCORDANCE WITH THE METHODS AND PROCEDURES SPECIFIED IN ASTM-D-1744 OR AUTOMATIC MOISTURE COUNTER USING KARL FISHER REAGENT PRINCIPLE.

5. THE CLEANED COMPONENT SHALL BE PRESERVED BY DRAINING EXCESS CLEANING OIL AND BY SEALING ALL OPENINGS. MAINTAIN THE CLEANLINESS OF COMPONENTS BY COVERING OPENINGS WITH RIGID OR FLEXIBLE SHEET PLASTIC, RUBBER OR METAL, OR CAPS MADE FROM PLASTIC, RUBBER, OR METAL. COVERING SHEET AND CAPS CAN BE SECURED BY TAPE, WATER-PROOF TAPE TO PPP-T-60D, ELECTRICAL TAPE, TYRAPS, BOLTS, OR OTHER SUITABLE METHODS. ALL COVERINGS SHALL BE TO THE SAME STANDARD OF CLEANLINESS AS THE COMPONENT.
6. WHEN BRAZING OR WELDING IS NECESSARY TO REASSEMBLE THE COMPONENT OR PERFORM A WELD REPAIR, COMPLETE REMOVAL OF PRESERVATIVE FLUID AND DEGREASING IS REQUIRED ON THE EXTERIOR OF THE COMPONENT.
7. A TAG SHALL BE ATTACHED TO EACH COMPONENT SPECIFYING THE DATE OF PRESERVATION AND THE PRESERVATIVE USED. THE TAG SHALL BE SIGNED AND DATED BY THE SELLER'S REPRESENTATIVE.