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## **Oxygen Cleaning Procedure**

### *1.0 Scope:*

This Procedure covers the general requirements for cleaning, inspection and packaging of items for Oxygen service. This procedure shall be carried out in a clean area of the shop (In Plant Cleaning).

### *2.0 Tools and Equipment:*

All tools and equipment, including test equipment shall be cleaned, examined under black light and re-cleaned (if necessary) prior to use.

### *3.0 Cleaning:*

- a) Disassemble item to be cleaned.
- b) Pre-wash all components with mineral spirit to remove excess oils, grease cuttings etc.
- c) Dry all components with clean lint free cloth.
- d) Final wash with degreaser and dry.

### *4.0 Inspection:*

- a) Examine all components visually, under bright light to detect the presence of visible grease or oil film and particulate matter, such as filings, chips, loose adherent rust or mill scale. If any contamination is observed, the item must be re-cleaned.
- b) Examine all cleaned surfaces in darkness or subdued light using ultra violet (black) light.
- c) If a bluish-white fluorescent blotch, smear, smudge or film is present, re-clean the item and re-inspect.
- e) Fluorescent specks due to lint and mildly fluorescent stains from cleaning residues are acceptable, except in excess.

- 5.0 *Assembly:*  
After all parts pass inspection, dry assemble the parts using care not to re-contaminate the components.
- 6.0 *Testing:*  
Test assembled item(s) for seat and gasket leak, with clean dry air or clean dry Nitrogen after cleaning.
- 7.0 *Packaging:*  
a) After an item(s) passes leakage test, wrap or bag open ends with clean plastic and tape to secure plastic in place.  
b) Place flange covers cover plastic wrapped ends and secure with tape.  
c) Bag items(s) with plastic or if too large to bag, wrap plastic over protected ends and tape in place.
- 8.0 *Identification:*  
Cleaned and protected item(s) to be identified as cleaned with a tag secured to the item tag to read: ***“Cleaned for Oxygen Service”***.
- 9.0 *Certification:*  
Certificate issued stating ***“All items cleaned for Oxygen service.”***