

COMMERCIAL CLEANING PROCESS AT THE MANUFACTURER'S FACILITY

1. COMMERCIALLY CLEAN:

"Commercially Clean" is defined as visually free of loose slag, water, rust, grit or other foreign solid particles; and containing no visual sign of oil, grease or hydrocarbons.

2. CLEANLINESS LEVEL:

All surfaces contacted by the process fluid shall be in a "commercially clean" condition prior to assembly and leakage testing as required by the applicable specification. Valves specified for service in cryogenic service require that all external surfaces subject to cryogenic temperatures be in a "Commercially Clean" condition prior to performing external leakage tests.

3. CLEANING METHOD AND AGENTS:

Cleaning agents and methods shall be at the option of the manufacturer. Cleaning shall be accomplished by any method, or combination of methods, which assures the "commercially clean" level is attained.

4. REJECTION

"Commercially Clean" valves as received from the manufacturer and upon visual inspection fail to meet the "Commercially Clean" requirements as defined in paragraph 1 and paragraph 2, shall be rejected by the purchaser and returned to the manufacturer.

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REMOVED "EXCESSIVE" FROM ITEM 1.
 ADDED "VISUALLY" AND "WATER" TO ITEM
 1. REPLACED "LIQUID HYDROGEN" WITH
 "CRYOGENIC SERVICE" IN ITEM 2. *RCB 7/15/87*
 (SEE HISTORY FILE FOR PREVIOUS REVISIONS) *7/20/87*

ISSUED/CEF
 JUL 21 1987
[Signature]

SYM	ZONE	DESCRIPTION	DATE	APPROVED	
REVISIONS					
SIGNATURES		DATE	 NATIONAL AERONAUTICS AND SPACE ADMINISTRATION NATIONAL SPACE TECHNOLOGY LABORATORIES NSTL STATION, MISSISSIPPI 39529		
DRAWN					
R. SWANSON		9/6/68			
CHECKED					
D. A. DiCerbo		9/6/68			
ENGINEER					
D. A. DiCerbo		9/6/68			
ISSUED			COMMERCIAL CLEANING PROCESS AT MANUFACTURER'S FACILITY		
ISSUED/CEF		9/11/68			
SUBMITTED					
R. Ciccarelli		9/6/68			
APPROVED			SIZE	DWG. NO.	REV.
R. G. Smith		9/11/68		54000-GC01	3
USED ON		AUTHORITY		SHEET	
54000-D001				1 of 1	