

# SPECIAL PROCESS PROCEDURE

SURFACE PREPARATION - SOLVENT CLEANING  
SP-1

RUNNELS INDUSTRIES  
3590 ENTERPRISE AVE.,  
HAYWARD, CA. 94545

L140-E980106-00-D

**1.0 SCOPE**

- 1.1 This procedure covers the requirements for the solvent cleaning of steel surfaces

**2.0 DEFINITIONS**

- 2.1 Solvent cleaning is a method for removing all visible grease, soil, drawing and cutting compounds and other soluble contaminants from steel surfaces.
- 2.2 Solvent cleaning is intended to be used prior to the application of paint and in conjunction with surface preparation methods specified for the removal of rust mill scale or paint.

**3.0 REQUIREMENTS**

**3.1 Surface Preparation Before and After Solvent Cleaning**

- 3.1.1. Prior to solvent cleaning remove foreign matter (other than grease and oil) by sweep blasting.
- 3.1.2 After solvent cleaning, remove dirt, dust and other contaminants from the surface by blowing down with clean dry air.
- 3.1.3 Special attention shall be directed to obscure areas created by part geometry.

**4.0 Method of Solvent Cleaning**

- 4.1 Wipe the surfaces with rags wetted with solvent. Use clean solvent and clean rags for the final wiping.
- 4.2 Steam clean, using detergents and follow by fresh water wash to remove detrimental residues.

**5.0 Inspection**

- 5.1 All surfaces shall be inspected to ensure complete removal of oils and/or grease. Special attention shall be directed to inside corners and weld surfaces.

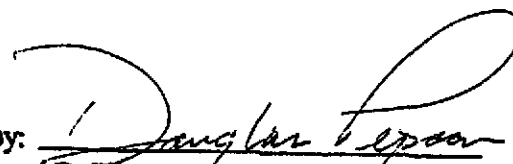
---

**Revision Control**

---

0      Original issue of procedure, 5/21/98

Reviewed and approved by:

  
D. Pepoon, V.P. of Operations