

Special Cleaning of products

Introduction

This document specifies guidelines used by Badotherm to ensure product cleanliness requirements for use in oxygen systems. Application of the document is limited to wetted system components. This document must be used in conjunction with product catalogs, technical bulletins, and reports.

Specification requirements

Components shall be assembled, lubricated, tested, and packaged according to the practices described in this document.

- All components shall meet the requirements of Badotherm Standard Cleaning prior to processing products to this specification.
- Assembled products shall be lubricated with non-hydrocarbon lubricants, such as Krytox® NRT 8906, as described in the product catalog. Special lubricants can be provided on request.
- Finished products shall be packaged individually in a sealed plastic bag. The package shall be labeled with the text “Cleaned from oil and grease” or “cleaned for oxygen service” depending on the selection and product type. Do not open bag until ready for use.
- Bagged products shall be boxed for protection from contamination and damage during shipment and storage.

Cleaning, drying and inspection

Components are cleaned in multistep processes that ensure thorough cleaning, rinsing, draining, and drying. These processes combine:

- Ultrasonic agitation techniques
- Non-combustive drying for the removal of rinse waters from components without depositing residues
- Visual inspection performed with the aid of bright illumination.

Assembly and testing

- Cleaned components are protected from damage and contamination.
- Cleaned components are assembled in a clean, well-lighted work area. Assembly work areas, equipment, and methods are designed and maintained to protect cleaned components from contamination.
- As described in the product catalog, nonhydrocarbon lubricant is applied to threads, mating surfaces, O-rings, and seals to prevent galling, reduce friction, and promote proper sealing.
- Production tests of assembled products, as described in the product catalog, are done with clean, dry nitrogen or a degreasing fluid

Packaging and identification

End connections are covered with clean caps and plugs, as needed, to protect threads and other critical surfaces, and to maintain cleanliness.

- Finished products are packaged to protect them from contamination and damage.
- Each product is packaged individually in a sealed plastic bag.
- Bagged products are packed in boxes with suitable protective material.
- Boxes are identified with the part number, quantity, and packaging date code.

Referenced documents

Badotherm Documents

Standard Cleaning GIN 7010

GIN G7010 - 12 Februari 2020

Holland – Romania – India – Thailand – Dubai – USA

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