

SPECIFICATION**FE3312****M947****1 of 1**

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Program - Project - Job: SNS-FE MEBT
Mechanical Transport Systems
Chopper Target

Title: **Cleaning of the Molybdenum TZM Face Plate and Back Plate Prior to Furnace Brazing**

1.0 Scope

This specification describes the requirements for cleaning the Molybdenum TZM face plate and back plate before they are furnace brazed together.

2.0 Cleaning Procedure

- 2.1 909 cleaner (mild caustic soap) for 15 minutes.
- 2.2 Rinse in de-ionized (DI) water.
- 2.3 HF acid for two minutes.
- 2.4 Tap water rinse.
- 2.5 Electropolish for two minutes:
 - 2.5.1 6 volts 128°F
 - 2.5.2 HCl 50% Dip
- 2.6 909 cleaner.
- 2.7 DI water rinse.
- 2.8 DI water rinse.
- 2.9 Hot water, 160°F rinse
- 2.10 Nitrogen Airdry

3.0 Additional Requirements

- 3.1 The two parts must be placed into the furnace within two hours of being cleaned.