Standard Cleaning and Packaging (SC-10)

Specification SCS-00010 Revision B

Scope

Swagelok® Specification SC-10 defines the cleaning, lubrication, assembly, and packaging requirements for standard Swagelok products and describes the practices used to meet these requirements.

SC-10 covers basic industrial procedures. The system designer and user should review this specification to determine whether it meets the user's cleaning needs.

Specification Requirements

Products shall be cleaned to remove loose particles and cutting oils that typically remain on products and components following industrial manufacturing processes.

Assembled products shall be lubricated as required by product specifications.

Finished products shall be packaged and boxed for protection during shipment and storage. Packages shall be marked for identification.

Cleaning Practice

Components are cleaned to remove oil, grease, and loose particles. Carbon steel components are protected from atmospheric corrosion by plating, a conversion coating, or a light oil film. Brass components may be bright dipped to inhibit tarnish of exterior surfaces.

Cleaned components are packaged to protect them from damage during storage.

Lubrication, Assembly, and Testing Practice

Lubricants and coatings are applied to threads, mating surfaces, O-rings, and seals, in accordance with individual product specifications, to prevent galling, reduce friction, and ensure proper sealing. Lubricants and coatings are hydrocarbon or halocarbon-based compounds or silicones and may contain inorganic additives or leachable halogens.

Products are assembled from cleaned components in a clean, well-lighted area.

Unless otherwise required, production tests are performed by internally pressurizing with clean, dry air, nitrogen, or helium as required by product specifications. Liquid leak detectors are applied to exterior surfaces and dried after testing is complete.

Packaging Practice

Finished products are packaged to protect them from contamination and damage during shipping and storage.

Exposed male threads are capped when necessary for protection. Standard quantities of products are packed in cardboard boxes with suitable protective material.

Boxes are identified with the part number, quantity, and packaging date code.

Nuclear safety-related products are packaged in accordance with ASME NQA-1, except that fitting holes may not be plugged, waterproof packaging enclosures are not used, and certain box marking requirements are not met in all instances.

Referenced Document

ASME Standard [1]

NQA-1 Quality Assurance Program Requirements for Nuclear Facilities

1. ASME Information Central Orders/Inquiries, P.O. Box 2300, Fairfield, NJ 07007-2300; infocentral@asme.org.

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