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1.0 PURPOSE

1.1. The purpose of the document is to define the SOP (Standard Operating Procedures) to be followed by ADVANEX EUROPE Ltd, in order to ensure that the degreasing process in the Cleanline 4-120 Aqueous Cleaning Line is carried out in a controlled and consistent manner.

2.0 SCOPE

2.1. The scope of this document covers the method used to process steel parts through the Cleanline 4-120 degreasing procedure at Advanex Europe Ltd Bilborough site.

3.0 TERMS, DEFINITIONS & ABBREVIATIONS

3.1. AQUA 22 – Mykal Industries Ltd. Aquasolv Ultrasonic Cleaner-Plus.

4.0 HEALTH, SAFETY & ENVIRONMENTAL

- 4.1. Heat and water resistant gauntlets must be worn when processing parts through the line.
- 4.2. Within the factory area safety footwear is mandatory.
- 4.3. Within the factory area the wearing of safety glasses is mandatory.

5.0 ASSOCIATED DOCUMENTS

- 5.1. Water Authority Consent to Discharge Document.
- 5.2. Procedure Hazardous Waste (Document Number AEU00062).
- 5.3. Spillage of Chemicals (Document Number AEU00007).

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6.0 PROCEDURE

6.1. General Instructions.



Figure 1 – Cleanline 4-120 Aqueous Cleaning Line at AEUB.

- 6.1.1. **Degreasing.** Following the process flow as shown in the diagram, 6.2 Process Flow. Move baskets as directed in diagram 6.2 from each tank then another basket containing product of the same batch can be placed in the tank just emptied.
- 6.1.2. **Batch Control.** One empty bath must be between different components types or batches of the same component when being processed through the Cleanline 4-120 Aqueous wash plant.

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6.2. Process Flow.

Basket Preperation • Parts to be loaded into baskets according to Control Plan / Works Order Instructions.

Degrease

- Aqua22 (5-10% of tank volume) & Towns Water Solution.
- •Tempreture set to 60°C on digital controler.
- Parts to be submerged into the solution for a minimum of 10 minutes with ultrasonic aggitation.

1st Rinse

- Parts to be submerged in towns water for a minimum of 10 minutes.
- •Tempreture set to 60°C on digital controler.

2nd Rinse

- Parts to be submerged in towns water for a minimum of 10 minutes.
- •Tempreture set to 60°C on digital controler.

Drier

- Parts placed in drier until fully dry.
- •Tempreture set to 60°C on digital controler.

Empty

- Empty the basket of parts.
- Place the parts into the work in progress containers.

Basket

• Wipe around the edges of the tanks, remove any stray springs and close lids where possible.

Task Completeion

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