

Ameritube LLC
1000 N. Hwy 77, Hillsboro TX 76645

Revision Level:
A

Procedure No.
SOP 903

Revision Date:
10/26/15

Page No. 1 of 2

Tube Cleaning

This Document expires one day after printing
Last Printed: October 30, 2015

Date

10/26/2015

Description Of Change

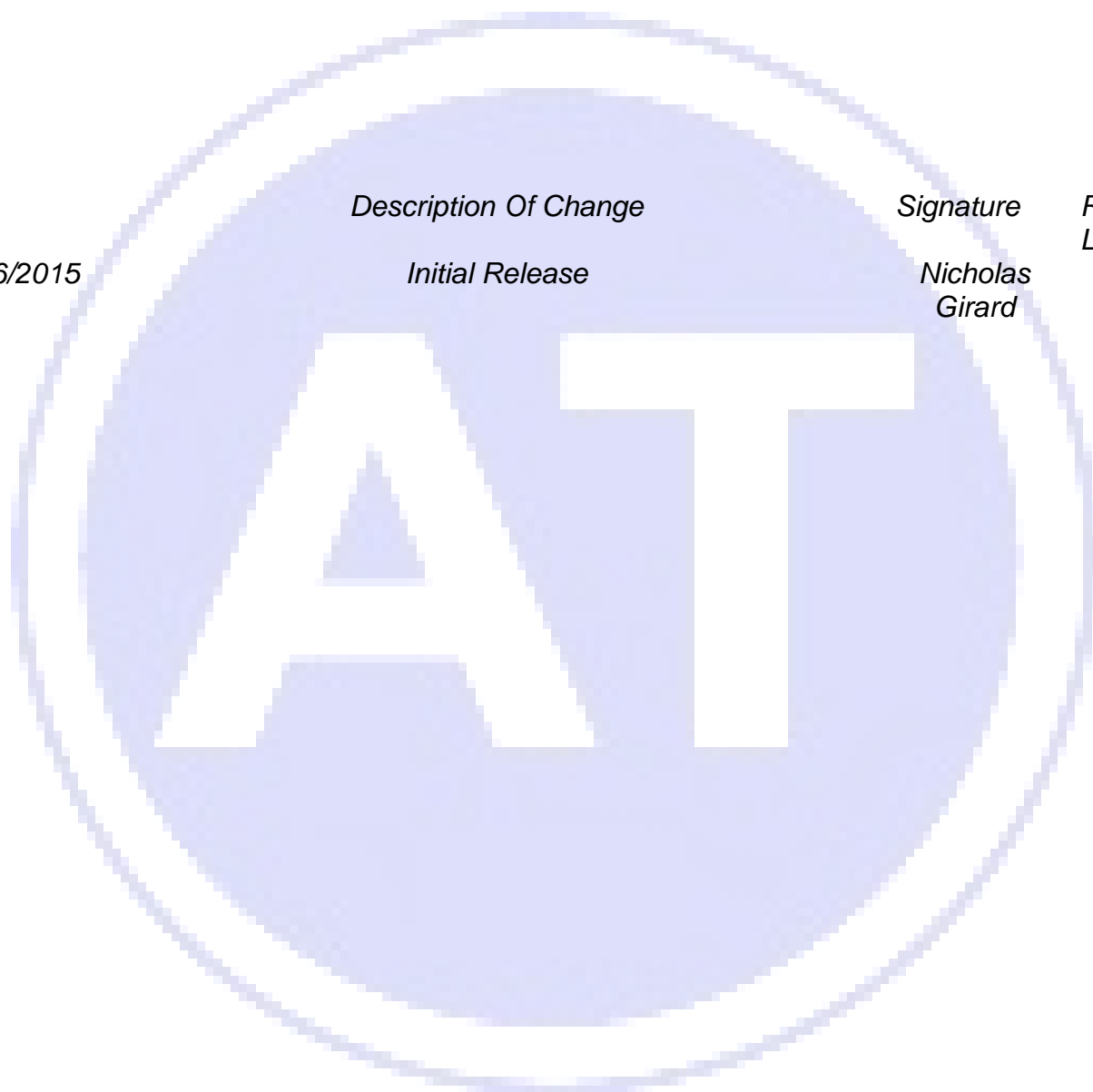
Initial Release

Signature

Nicholas
Girard

*Rev.
Level*

-



Procedure Approval:

Company Title:
Quality Manager

Date:
9/27/2013

Tube Cleaning

This Document expires one day after printing
Last Printed: October 30, 2015

1. Scope

The scope of this procedure is to provide instructions, and to assign tasks for initiating, requesting, implementing, and checking the effectiveness of tube cleaning using felt plugs. This procedure applies to the testing of materials for conformance to tube cleanliness stated in ASTM Standards for Metals Test Methods and Analytical Procedures SB-111.

- 1.1. These cleaning procedures provide for a thorough cleaning both inside and out using appropriate chloride-free solutions or solvents capable of removing all lubricant residues.

2. Procedure

- 2.1. Tube cleaning is conducted when the material is finished with hydrostatic testing in preparation for boxing, unless otherwise specified by customer purchase order.
- 2.2. The water used for cleaning and hydrostatic testing of the tubes during manufacture shall be potable water, provided by the City of Hillsboro Water Company.
- 2.3. Prepare the customers tubing for the necessary felt plugs used by properly cleansing the outside surface with applicable solvent soaked, oil-free towels.
- 2.4. "Bleed" air-lines of any condensation or residual fluids to ensure the effectiveness of this procedure.
- 2.5. Implement solvent-soaked felt plugs into finished tubing once cleaning of tube's exterior is complete and after purging air-compressed lines
- 2.6. Blow said felt plugs through each tube with dry, oil-free air. Oxide discolorations on the felt plugs are acceptable unless otherwise stated in Customer's Purchase Order.
- 2.7. As tubes complete this process, use oil-free towels to wipe away remaining liquid or residue & place used felt plugs into their appropriate container for disposal.
- 2.8. Upon completion, return cleaning equipment to their designated areas & dispose of remaining water/ contaminants appropriately.