

DATE 16 April 1964
SHEET 1 OF 1

TMC SPECIFICATION NO. S-827

LR
COMPILED

LB
CHECKED

TITLE: SAND BLASTING

OB APPROVED *RR*

The purpose of this specification is to outline a surface preparation, as a finish and/or to prepare for further finishing.

Applicable Metal:

This specification is primarily intended for use on copper (Commercial Refrigeration Tubing 030 wall).

Applicable Specifications Per Vendor

Materials Required:

Pfaffblast #120 grit
Trichloroethylene (Degreaser)
Alkaline Cleaner
Muriatic Acid (Neutralizer Rinse)
Sulphuric - Nitric Acid
(Bright Dip)

Source:

Geo. Pfaff Inc.
Any
Oakite or equivalent
Any
Any

Method

Degrease surface thoroughly, dip in cleaner then rinse in water followed by a dip in muriatic acid as a neutralizing rinse, again rinse in water, followed by a bright dip in Sulphuric-Nitric acid, the last rinse should be in hot water (160 - 190F). After last rinse, thoroughly air dry inside and out.

Surface is then sand blasted using a #120 grit at approximately 50 lbs. pressure. Make sure all slag and excess brazing is removed, surface should have a fine matte finish appearance.

APR 20 1964

Ref- Electro Plating Company

