P0010
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Safety Note:
Certified Personnel only:

REMOVAL OF Al-Ti COATING AND RE-INSPECTION OF R/O SURFACE FOR "R" HALF

I PROTECTIVE COATING INSEPCTION

- The parting plane is inspected from above using back lighting source from below. A low microscope is used for this process.
- Notes should be taken which describe any places in protected area where the protective coating is missing.
- If protective coating defects are found, telephone Stanford to discuss the status.
- If no protective coating defects are found, proceed with ***procedure 1 number 212564***.

II COATING REMOVAL

- The protective coating is removed by placing the part in a bath of 50% phosphoric acid/50% DI water (preheated to 90°C).
- The part is left in the acid solution for approximately a minute or until the film clears.
- The part is left in the acid for an additional 30 seconds to ensure that all of the metal has been removed.
- The part is then rinsed in DI water for five (5) minutes.
- A note in the hardware folder should indicate "***coating removal complete***" along with the date and the name of the operator.

III INSPECTION

- The parting plane is inspected from both below and above the part. A low power microscope is used for this process.
- Notes should be taken which describe any damage to the previously protected region of the parting plane. The ***size*** of the largest chip and scratch should be recorded.
- The chamfer should also be inspected and the fractures beneath the parting plane using a low power microscope.
- The results of these inspections should be recorded in the appropriate hardware folder.