

ELMET TECHNOLOGIES LLC - SPECIFICATION

DEPARTMENT: **QUALITY**

PAGE: 1 of 2

SPECIFICATION: **S-22-032** REVISION: (F)

TITLE: **PAINTING MOLYBDENUM PARTS - FLOWDOWN CLAUSES
& STANDARDS**

CONTROLLED COPIES: **NONE**

1. PURPOSE / SCOPE

Documented requirements for painting molybdenum parts. These are general requirements. Other specific requirements may be included in the Elmet Purchase Order.

2. PROCEDURE AND DOCUMENTATION

2.1. Material: Molybdenum 99.95% Pure per ASTM B386. Parts are delivered to the painter in clean, dry condition.

2.2. Each sample coupon and part will be processed in accordance with each part drawing and Engineering Parts List, per the Elmet Purchase Order.

2.3. Certificate of Compliance (C of C) to be provided with each order must include the following:

- (1) Purchase Order number
- (2) Part number or Work Order number
- (3) Test results
- (4) Test Standard the part was inspected to
- (5) Sample identification (maintain identification provided by Elmet tag for each part)

2.4. C of C to be submitted to quality@elmettech.com. Hard copy to be included inside shipping box with the parts.


2.5. Parts shall have all masking materials removed and packaged in sealed original packaging as received, or in a sealed poly bag. This bag then shall be enclosed in a second sealed poly bag with desiccant to prevent oxidation. Poly bags shall be uncoated, no oils or desiccant in contact with parts. Sealing of bags may be by heat sealing, ziplock style closure or tape that fully covers the folded bag opening. Wrapping the painted parts with clean paper prior to enclosing in packaging is acceptable.

ELMET TECHNOLOGIES LLC - SPECIFICATION

DEPARTMENT: **QUALITY** PAGE: 2 of 2
SPECIFICATION: **S-22-032** REVISION: **(F)**
TITLE: **PAINTING LOCKHEED MOLYBDENUM PARTS - FLOWDOWN CLAUSES & STANDARDS**
CONTROLLED COPIES: **NONE**

5. REVISIONS AND APPROVALS

REV	DATE	ORIGINATOR	CHANGES
-	04/19/17	D.Drinan	Initial Issue
A	06/19/17	D. Drinan	Added clause 8, specimen retention
B	05/01/18	D. Drinan	Made generic for multiple paint specs
C	09/17/2020	D. Drinan	Major re-write to update procedure
D	11/11/2020	D. Drinan	Clarified packaging 2.5
E	11/13/2020	D. Drinan	Removed reject details 2.3
F	12/7/2022	S. Brousseau	Revised 1, 2.3.1, 2.3.2. & 2.3.4

APPROVER	SIGNATURE
D. Drinan	 Digitally signed by Dan Drinan