APPENDIX B. Basic Elements

Basic Element	Basic Element Step(s)
139	CLEAN PER FPS-3001, PARA. 3.1.1, AND ANODIZE PER MIL-A-8625, TYPE I, EXTERIOR SURFACES ONLY OF TUBING OR PARTS. TREATMENT NOT PERMITTED ON INSIDE SURFACES (OXYGEN SYSTEM).
140	CLEAN AND ANODIZE PER FPS-3033 OR FPS-3090 OR CLEAN PER FPS-3001, PARA 3.1.1, AND ANODIZE PER MIL-A-8625, TYPE I EXTERIOR SURFACES OF TUBING OR PARTS. TREATMENT IS OPTIONAL ON INSIDE SURFACES OF MACHINED PARTS, WELDED ASSEMBLIES WET WITH FLUID OR TUBING DETAILS.
141	CLEAN PER FPS-3001, PARA. 3.1.7, AND ANODIZE ALL SURFACES PER MIL-M-45202, TYPE I, CLASS C. (FOR MAGNESIUM).
142	CLEAN PER FPS-3001, PARA. 3.1.7, AND BRUSH CHROME PICKLE BARE AREAS PER MIL-M-3171, TYPE I. (FOR MAGNESIUM).
143	CLEAN AND CHROMIUM PLATE SPECIFIED SURFACES PER QQ-C-320, CLASS 2D, AND BAKE AFTER PLATING 8 HOURS MINIMUM. SUSTAINED TENSILE LOAD TESTS ARE NOT REQUIRED (220-240 KSI WITHOUT SIGNIFICANT SUSTAINED TENSILE LOADS OR DYNAMIC LOADING).
144	CLEAN SPECIFIED SURFACE WITH MIL-C-38736 CLEANER* OR FMS-2004. *NOTE: P6174 NON-AROMATIC CLEANER MAY BE USED IN LIEU OF MIL-C-38736 CLEANER. (REFERENCE CR 1345 FOR CO-PRODUCER USE.)
145	CLEAN PER FPS-3001, PARA. 3.1.2. (FOR TITANIUM ONLY).
146	CLEAN PER FPS-3001 PARA. 3.1.3(A) OR QQ-P-35, AND PASSIVATE ALL SURFACES PER FPS-3007 OR QQ-P-35 (METAL REMOVAL BY PASSIVATION SOLUTION NOT PERMITTED). (DO NOT USE FOR CASTINGS AND WELDED ASSEMBLIES WITH LAP JOINTS.) NOTE: THIS PROCESS MAY NOT REMOVE HEAT TINT OR DISCOLORATION RESULTING FROM THE AGING OPERATION.
147	CHEMICAL DESCALE AND PASSIVATE ALL SURFACES PER FPS-3020 (0.00075" METAL REMOVAL PERMITTED) (FOR ROUGH CRES FORGINGS, FORGED CRES BARS AND FOR HEAT TREATABLE CRES). (NOTE: FPS-1051 MAY BE USED IN LIEU OF FPS-3020. FULLY HEAT TREATED PARTS PROCESSED PER FPS-1051 MUST BE STRESS RELIEVED PER FPS-1051 REQUIREMENTS. CRES PARTS WHICH HAVE BEEN PRE-PENETRANT ETCHED PER FPS-3020 DO NOT REQUIRE ADDITIONAL PASSIVATION AFTER PENETRANT INSPECTION PROVIDED THERE ARE NO SUBSEQUENT MACHINING OPERATIONS.) NOTE:FOR SURFACES WHERE NO HEAT TREAT, OR MILL SCALE, OR FOR PARTS WHERE ALL SURFACES ARE MACHINED, QQ-P-35 MAY BE USED IN LIEU OF FPS-3020.
148	PREPARE ALL SURFACES AND PHOSPHATE TREAT PER FPS-3006, CLASS VIII, CASTINGS EXCEPTED.