

**CON-SERV INC**  
**STANDARD OPERATING PROCEDURE**

D.P. NO 1001

**DESCRIPTION:**

Preparation carbon steel sheet for bonding.

**EFFECTIVE DATE:** January 1, 1979

**Q.C. APPRVD.:** *RC*

**SHT. 1 OF 1**

**REVISED DATE:** October 28, 1996

STEP	PROCEDURE	COMMENTS
1.	Check sheet for excessive burrs from shearing. If present, deburr with file or disc sander.	
2.	Wipe both surfaces of sheet with clean rags soaked in a solvent or if small pieces, soak in a solvent and wipe dry. For either cold-rolled or hot-rolled sheet, no oil must be present on surface after this step.	
3.	Place pieces in dunk racks for etching.	
4.	Lower into pre-heated etching tanks. Tanks to be preheated to 100°F.	
5.	Etch sheets in tank for 45 minutes at 100°F.	
6.	Remove rack from etching tank and rinse plates thoroughly with hose spray clean water on all sides while still in rack.	
7.	Allow all plate surfaces to dry.	
8.	Prior to applying and adhesive, make a final wipe on bond side with a clean rag and a solvent. This will remove any finger oil or oxidation contaminants.	

RECEIVED  
 CK'D BY \_\_\_\_\_  
 DEC 15 2006  
 RESUBMIT APPROVED   
 BY \_\_\_\_\_ DATE 01-05-07