



PR-25 PENETRANT ROUGE

Technical Data Sheet

Approvals and conformities

ASME
ASTM-E-1417
ISO 3452-2
RCC-M

MANUFACTURER: NDT-Europa (NL)

DESCRIPTION / APPLICATION(S):

Type II, Method A (waterwashable) and Method C (solvent removable) red dye penetrant, Level 2 as per ISO 3452-2 standard. High sensitivity, easy to wash.

Rhodamine-free, Azo III A2 amine (diazo) free.

Red dye penetrant with two dyes "Dubl-dye".

Companion products:

Cleaner: N120, cleaning rags N120, DR-62.
Remover: N106A, DR-60, cleaning rags N106A.
Non aqueous wet developer: D-100, R60, D-106.

DIRECTIONS FOR USE

Surface must be free of contaminants, **even inside flaws**. Use adequate methods to remove oxides, paints, oil, water, etc. Prior to applying penetrant, wipe out with cleaner N120 and rags or cleaning rags N120. Allow 2 minutes for complete evaporation.

Application:

Apply penetrant by any adequate means (spraying, brushing, flowing, dipping, etc.).

Dwell time:

20 minutes are recommended. Dwell time may be shortened down to 10 minutes when only large cracks are sought for, or extended up to several hours for tight cracks.

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Excess of penetrant removal:

This is a delicate operation. Remove the excess penetrant from the surface, being careful not to remove the penetrant trapped in the defects. Rinse under low pressure (50 to 200 kPa), with the nozzle of gun 30 to 40 cm from the part, during the shortest time possible, until the red background disappears. If you can't or don't want to use water, carry out the following procedure (and not any other).

- Wipe off the excess of penetrant from the surface using clean rags.
- Using rags lightly moistened with N106A or DR-60, wipe again.
- As a final step, wipe with clean, dry rags.

Developer:

After complete drying apply one of the mentioned developers as a thin, even coat by spraying only. Wait for 10 to 30 minutes before inspection.

Inspection:

Parts shall be inspected as per ISO 3059 standard requirements. Inspection is better when using a "cold white light" (industrial white light) or "intermediate white light" (cool white light). Colour temperature must be higher than 4500K. Colour rendition index more than 80 or light with an illuminating index of D65. It is recommended NOT TO USE undervoltaged incandescent bulbs, as it often happens with battery-operated units, this giving a yellowish light.

TECHNICAL CHARACTERISTICS

Low sulphur, fluorine, chlorine, bromine content
Compatible with any metal and some synthetic materials.

Appearance purple-red liquid
Flash point > 60°C

PRECAUTIONS FOR USE AND STORAGE

Transport / Handling:

Refer to Material Safety Data Sheet (MSDS).

Storage :

Keep away from moisture
Temperature range: 0°C à 50° C
Keep packaging closed after taking out some of the product

This technical data sheet replaces and cancels the previous one.

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