

Flaw Guide Red Dye Penetrant GP

Flaw Guide Red (Visible) Penetrant GP is solvent removable colour contrast (Red) Penetrant, suitable for detection of extremely fine surface defects which are found in castings, forgings, welds in all kinds of ferrous & non ferrous metal working as well as on non porous ceramic materials. This Penetrant is not suitable for inspection of plastic components. The desired properties are well controlled to obtain reliable & uniform results during application.

Main Features

- Red Liquid gives bright defect indications under Day Light.
- Highly sensitive - detects 1 x 20 micron size cracks on Ni-Cr Panel
- Excellent Wetting ability - better coverage - Non Toxic -
- Non Corrosive - operator friendly-No objectionable smell
- Conform to the requirements of almost all the international specifications such as ASME (B&PV) Sec V, ASTM-E-165, AMS 2644, ASTM-1417, EN-571-1, IS 3658/12889 EN-ISO 3452-2 etc. for Liquid Penetrant Testing
- The aerosol cans contains Non CFC Environmental Friendly Hydrocarbon as propellant.
- Excellent area coverage and hence most economical
- Halogen and Sulphur controlled well within acceptable limits of most of the International Specifications



Recommended Test Procedure

1. Pre Cleaning : Clean The surface thoroughly by Flaw Guide Cleaner to free from oil, grease, rust, dirt etc. which otherwise may prevent entry of the Penetrant in to the defect. For excessive oil or grease, suitable cleaning process may be used.
2. Apply Flaw Guide Red Penetrant GP either by Spraying, dipping or brushing method and allowed to remain on the surface for minimum period of 10 minutes. The recommended surface temperature of the job to be between 5 to 55 Deg. C. In case of lower temperatures, the penetrant time i.e. Dwell Period may be suitably increased to take care of increase in viscosity of penetrant material on the surface of the job.
3. Remove the Penetrant by wiping the surface with lint free cloth and subsequently by cloth soaked with Flaw Guide Cleaner GP. Excessive Cleaning to be avoided which otherwise can affect the sensitivity of the test.
4. Apply Flaw Guide Developer GP (Non Aqueous Developer) uniformly by spraying. The developer adsorbs the Red Penetrant liquid which has entered in the defect & show the red defect indications, if any. The bright white background provide contrast to enhance the visibility and hence the sensitivity. Powder Developers or Water Base Developers can also be used instead of Non Aqueous Developer, if recommended.
5. Inspect the components under test after 7 minutes of application of Developer and note the defects, if any. In case of Water base Developers the component is required to be dried suitably prior to inspection. The Day light intensity during inspection need to be as recommended by the specification so as to view the defects properly.