

# Flaw Guide

## Red (Visible) Penetrant SP

(Solvent Clean Type Customised Red Penetrant )

Flaw Guide Red (Visible) Penetrant SP is solvent removable colour contrast penetrant is 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 customized to meet specific requirements of the customer &/or specification. The desired properties are well controlled to obtain the reliable & uniform results during application.

Flaw Guide Red Penetrant SP will meet the requirements of most of the International specifications such as ASME (B&PV) Sec V, ASTM-E-165, AMS 2644, ASTM-1417, EN-571-1, EN-ISO 3452-2 (Sensitivity Level 2), IS 3658/12889 for Liquid Penetrant Testing apart from specific requirements of the customers. Halogen & Sulphur contaminants are controlled well below their acceptable limits.

### 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 SP 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 NP/GP. Excessive Cleaning to be avoided which otherwise can affect the sensitivity of the test.
- 4.** Apply Flaw Guide Developer NP/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.

Supplied in Bulk packings of 5, 20 ltr containers