

NDT Supply.com, Inc.

7952 Nieman Road
Lenexa, KS 66214-1560 USA

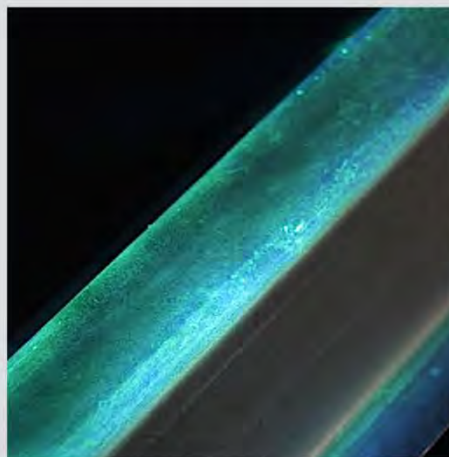


Penetrant Professor Approved



Find Cracks Fast

A Guide to Fluorescent Penetrant Inspection



Encuentre los Discontinuidades Rapidamente

Inspección con Penetrantes Fluorescentes

Phone: 913-685-0675
Fax: 913-685-1125

sales@ndtsupply.com
www.ndtsupply.com

Method "C" Instructions

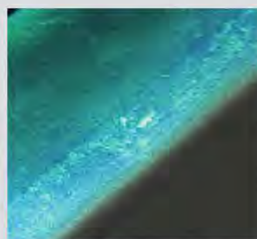
Use **Met-L-Chek® E-59A, R-503,** or **R-504** cleaner to remove oil, grease and other contaminants from test surface. Spray surface and wipe clean. Repeat as needed. Allow part to dry completely before applying penetrant.

Apply penetrant onto clean dry test surface which is at a temperature between 40°-125°F (4°-52°C). Allow a minimum penetration time of 10 minutes for specification work.

Use clean lint-free cloth to remove most of the surface penetrant. Dampen a clean cloth with **E-59, E-59A, R-503,** or **R-504** and wipe remaining penetrant from the surface. **Do not spray cleaner directly onto the surface as sensitivity will be impaired.**

Shake **Met-L-Chek® D-70** before using to re-suspend developer. Spray a thin even coating on the part surface. Avoid a wet runny coating. Allow 10 minutes for thorough indication development.

Inspect fluorescent penetrants in a darkened area under ultra violet UV-A illumination of at least 1000 μ W/cm².



Instrucciones del Método "C"

Use el limpiador de **Met-L-Chek® E-59A, R-503,** ó **R-504** para remover aceite, grasa, y otros contaminantes de la superficie. Aplique el limpiador a la superficie y con un trapo frote hasta que quede limpio. Repita tantas veces lo requiera. Deje que la parte seque completamente antes de aplicar el penetrante

Aplique el penetrante en la superficie limpia, que debe estar a una temperatura entre 4°C-52°C (40°F-125°F). Permita un tiempo mínimo de 10 minutos para que el penetrante entre en las discontinuidades de la superficie.

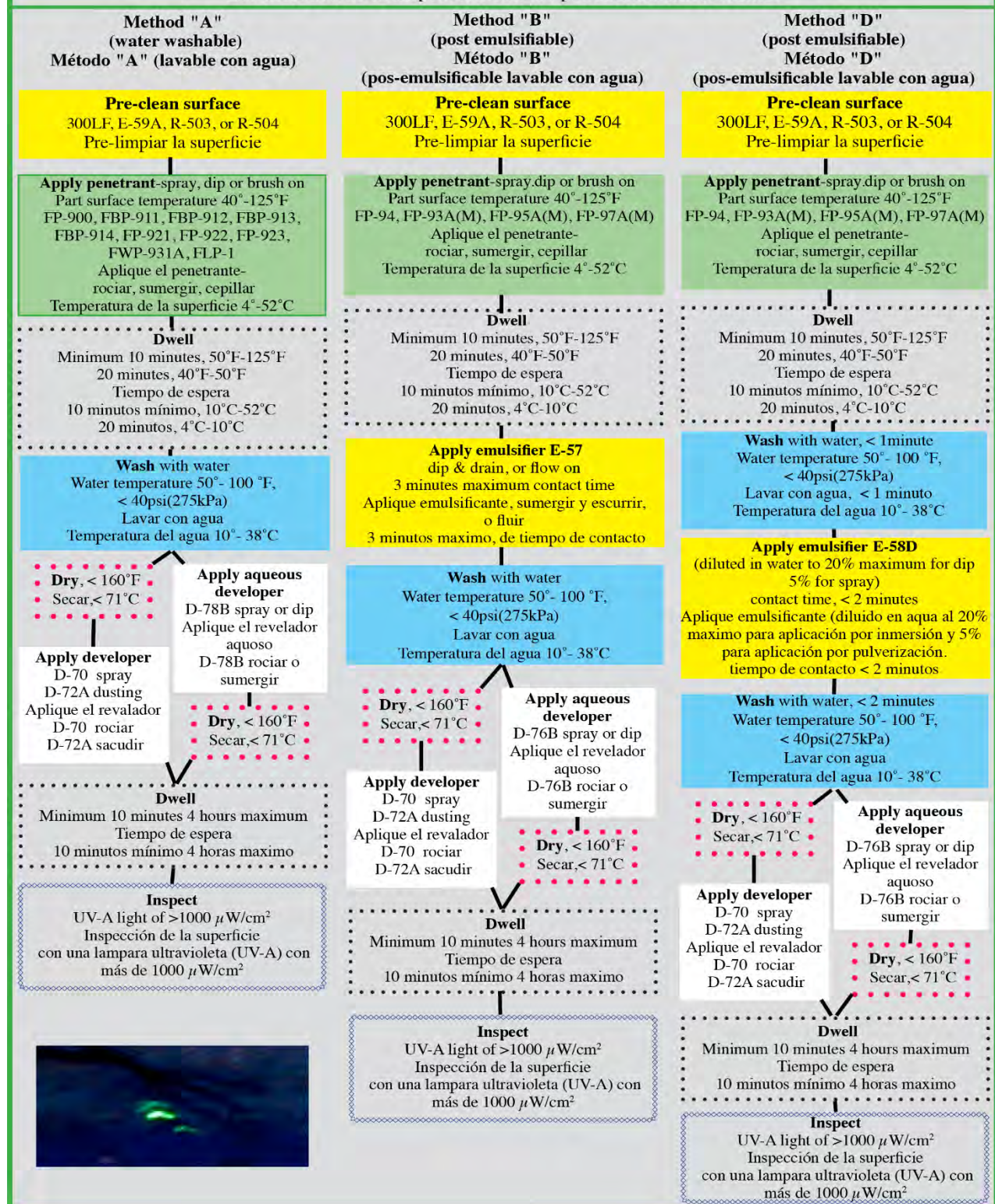
Use un trapo limpio para remover el exceso del penetrante. Humedezca un trapo con **E-59, E-59A, R-503,** o **R-504** y páselo nuevamente para quitar el restante. **No aplique el limpiador directamente a la superficie, puede disminuir la sensibilidad.**

Agítese bien el **Met-L-Chek® D-70** antes de cada uso. Aplíquese una capa uniforme y delgada en la superficie, evite que la capa se humedezca. Permitase 10 minutos para que el penetrante emerge de las discontinuidades.

Inspeccione los penetrantes fluorescentes en un medio oscuro con iluminación ultravioleta UV-A mejor de 1000 μ W/cm².



Fluorescent Penetrant Inspection Methods based on ASTM E-1417 Los métodos de la inspección con los penetrantes fluorescentes



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Met-L-Chek® Fluorescent Penetrant Materials per AMS-2644 and ASTM E-1417

Penetrant TYPE 1 – Fluorescent Dye

Sensitivity levels 1/2 – 4.

Removal Method A – Water washable, penetrants.

Removal Method B – Post-emulsifiable, lipophilic.

Removal Method C – Solvent-removable
class 1 – Halogenated.
class 2 – Non-halogenated.
class 3 – Special application

Removal Method D – Post-emulsifiable, hydrophilic

Developer Forms

“a” – dry powder.

“b” – water soluble.

“c” – water suspendible.

“d” – non-aqueous (solvent)

Penetrant	Type	Methods	Sensitivity	Form	Class	AMS-2644 OPL
FLP-1	1	A & C	NA	NA	NA	No
FP-900	1	A & C	1/2	NA	NA	Yes
FBP-911	1	A & C	1	NA	NA	Yes
FP-921	1	A & C	1	NA	NA	Yes
FWP-931A	1	A & C	1	NA	NA	Yes
FBP-912	1	A & C	2	NA	NA	Yes
FP-922	1	A & C	2	NA	NA	Yes
FBP-913	1	A & C	3	NA	NA	Yes
FP-923	1	A & C	3	NA	NA	Yes
FBP-914	1	A & C	4	NA	NA	Yes
FP-94	1	B, C, & D	1	NA	NA	Yes
FP-93A(M)	1	B, C, & D	2	NA	NA	Yes
FP-95A(M)	1	B, C, & D	3	NA	NA	Yes
FP-97A(M)	1	B, C, & D	4	NA	NA	Yes
Emulsifier	Type	Methods	Sensitivity	Form	Class	AMS-2644 OPL
E-57	1	B	1/2 - 4	NA	NA	Yes
E-58D	1	D	1/2 - 4	NA	NA	Yes
Cleaner/ Remover	Type	Methods	Sensitivity	Form	Class	AMS-2644 OPL
E-59	1	C	1/2 - 4	NA	2	Yes
E-59A	1	C	1/2 - 4	NA	2	Yes
R-503	1	C	1/2 - 4	NA	2	Yes
R-504	1	C	1/2 - 4	NA	2	Yes
300LF	NA	NA	1/2 - 4	NA	NA	No
Developer	Type	Methods	Sensitivity	Form	Class	AMS-2644 OPL
D-70	1	A, B, C, & D	1/2 - 4	d & e	NA	Yes
D-72A	1	A, B, C, & D	1/2 - 4	a	NA	Yes
D-76B	1	B, C, & D	1/2 - 4	b	NA	Yes
D-78B	1	A, B, C, D	1/2 - 4	c	NA	Yes

Met-L-Chek® means Quality (Calidad).

Met-L-Chek® penetrant inspection materials are approved to AMS-2644. They are certified to meet the requirements of AMS-2647, ASME Boiler and Pressure Vessel Code, ASTM E-165, ASTM E-1417, and NAVSEA 250-1500-1.

Met-L-Chek® means Expertise (Experiencia). Met-L-Chek® has been supplying the NDT field since 1952.

Met-L-Chek® means Value (Valor).

Met-L-Chek® es calidad, experiencia, y servicio; valor total.



FCF-F-2015

Authorized Distributor

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