

TECHNICAL DATA SHEET

Instructions

Note: These instructions describe the basic process, but they may need to be amended by the user to comply with applicable specifications and/or inspection criteria provided by the contracting agency.

Penetrant Process

1. Application: Apply penetrant only to clean, dry surfaces by spraying, flowing, brushing or dipping.
2. Dwell Time: After application, allow the penetrant to drain from the part surface back into the penetrant tank to conserve material.
3. Removal: Remove as much excess penetrant as possible using clean, dry rag or towelling. Remove remaining penetrant film by wiping with a lint free rag or towelling that has been slightly moistened with **DR-60**. Use a minimal of **DR-60**; avoid flushing penetrant from flaws. Do not spray **DR-60** directly on the part surface when removing excess penetrant. Rough surfaces require more generous applications of **DR-60**.
4. Drying: Allow the surface to dry completely before applying developer.
5. Developing: Apply the developer by cloud, dusting, spray or dip using the appropriate developer. Flaw marks are visible under appropriate lighting almost immediately, but allow sufficient developing time to enhance the flaw visibility.
6. Inspection: Inspect parts under appropriate light.

Health & Safety

DUBL-CHEK DR-60 is flammable and when packaged within an aerosol is extremely flammable. Use with adequate ventilation and away from spark, fire or open flames. Avoid prolonged or repeated contact with skin. Do not breathe gas, fumes, vapour or spray. Consult the MSDS for more Safety and Health information.

Get medical attention if irritation develops and persists. Ensure that medical personnel are aware of the material(s) involved, and take precautions to protect themselves.

WARRANTY – All statements, information and data presented herein are believed to be accuracy and reliable but are not to be taken as a guarantee, expressed or implied, for which seller assumes legal responsibility and they are offered solely for your consideration, investigation and verification. Statements or suggestions concerning possible use of this product are made without representation or warranty that any such use is free of patent infringement and are not recommendations to infringe on any patent.
22 August 2007
