

Performance you can trust

FLAWFINDER Dye Penetrant Spray

NDT Crack Detection System

Product Overview

FLAWFINDER Dye Penetrant is an aerosol applied dye which can be sprayed from any angle. Used as part of the FLAWFINDER NDT crack detection system.

FLAWFINDER non-destructive inspection system is designed to provide a fast reliable method for visual detection of cracks or flaws which would not normally be visible to the naked eye. Ideal for the inspection of welded joints, castings, forgings on many different materials.

A bright red indication will mark the flaw or crack.

Features and Benefits

- Highly visible red dye
- Multi-angle valve system
- Detection can be carried out under natural or electric light
- Easily removed by solvent or water washing
- Can be used materials such as steel, stainless steel, aluminum, ceramics, plastics, carbides, brass, copper and magnesium

Directions for Storage and Use

- Shake aerosol well before use
- Apply from a distance of 15-30cm
- As with all products of this type it is recommended that compatibility with painted or coated surfaces, plastics and rubber be tested prior to use
- The storage temperature should be kept below +50°C, and the storage area should be out of direct sunlight
- Shelf life is 5 years from date of manufacture

Specifications

Meets the requirements of **ISO 3452-2**

Pack Sizes

Pack size	Part Code
400ml	63151

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FM 12448



EMS 67596



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Application Method

Cleaning—Clean the area to be tested with FLAWFINDER Cleaner Spray and wipe thoroughly with a tissue or lint free cloth. Ensure the surface is clean, dry and free of contaminants. Repeat if necessary. After a final wipe, allow time to dry before using FLAWFINDER Dye Penetrant.

Apply Penetrant—Spray the test area and allow a minimum of 10 minutes contact time. Extremely fine definitions may take up to 30minutes.

Remove Penetrant—Once the contact time has elapsed, the excess penetrant should be removed with a dry cloth, repeat if necessary. The remainder should be removed with a cloth pre-moistened with cleaner. Care is to be taken at this stage not to flush out the penetrant with cleaner as this will impair sensitivity. Repeat this procedure until surface penetrant is removed.

Develop—Shake the can well. Apply a thin film of FLAWFINDER Developer to the test area. Too much developer will mask indications. Leave for 10minutes to draw up the retained penetrant from any flaws or cracks. Larger cracks will show immediately, minute flaws or cracks may take a few minutes to develop the best indications.

Inspection—Suspect areas should be examined under natural or electric light for signs of flaws and cracks. Cracks will show up as lines whilst porosity will appear as pin holes

If the results are inconclusive repeat the process taking greater care when removing the excess penetrant.

Property	Result
Appearance	Deep red
Propellant	LPG
Solvent	Blend of hydrocarbons
Odour	Characteristic

Values quoted above are typical and do not constitute a specification.

Safety Data Sheets

Safety data sheet sheets are available for download from our website www.ocol.com or may be obtained from your usual ROCOL contact.

The information in this publication is based on our experiences and report from customers. There are many factors out of our control or knowledge which affects the use of our products, for which reason it is given without responsibility.

Issue:2 Date 05-14

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