

### Approvals and conformities

ASME  
ISO 3452-2  
QPD-AMS 2644

**MANUFACTURER: SHERWIN (USA) / NDT Europa (NL)**

### DESCRIPTION / APPLICATION(S):

Type 1, method A & C, level 1, according to AMS 2644 and ISO 3452-2, water washable fluorescent penetrant designed for detecting surface defects

**Companion products :** D-90G dry developer  
D-100, R60, D-106 developers

### DIRECTIONS FOR USE

These describes 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.

#### Application :

Apply HM-2D only to clean, dry surfaces by spraying, flowing, brushing or dipping.

#### Dwell-Time :

A 10 minute dwell time is suggested, although in many cases five minutes will be enough. When particularly tight cracks are suspected, or the part is especially critical, the dwell time may be extended to 30 minutes, or longer.

**Do not soak the part.** To increase sensitivity, as well as conserve material, allow the penetrant to drain from the part surface back into the penetrant tank.

#### Removal :

Use a quick, ambient temperature water wash at tap pressure to rinse HM-2D from the part surface. To avoid washing entrapped penetrant from surface flaws, do not use high water pressures and temperatures, or prolonged washing and scrubbing.

**Drying :**

A recirculating oven set no higher than 70°C is suggested. Leave part in oven just long enough to evaporate surface moisture. Drying is improved by using pressurized air to disperse and remove as much excess water as possible before placing part in oven.

**Developing :**

HM-2D is self developing. Nevertheless it is recommended to use a developer as listed above.

**Inspection :**

Inspect parts under appropriate UV-A radiation and dimmed visible light, in accordance with ISO 3059 standard.

**TECHNICAL CHARACTERISTICS**

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No halogen nor sulphur content

Compatible with all metals, ceramics and some plastics

Water tolerance : >5%

Appearance .....	green liquid
Fluorescence .....	green-yellow
Flash point .....	> 93°C
Viscosity .....	3,7 mm <sup>2</sup> /s at 38°C

**PRECAUTIONS FOR USE AND STORAGE**

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**Transport / Handling:** Refer to Material Safety Data Sheet (MSDS)

**Storage :** Keep away from moisture

Temperature range: 0°C à 50°C

Keep packaging closed after taking out some of the product

1 Date : 07-07-2017 Written and checked by : F. Héron

**This technical data sheet replaces and cancels the previous one.**

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