 <p>15 rue des Frères Lumière – BP 136 78374 PLAISIR FRANCE Tél : 01.30.80.81.98 Fax : 01.30.80.81.99 WEB : www.sherwinbabbco.eu E-MAIL : sherwinbabbco@orange.fr</p>	<p><b>TECHNICAL</b></p> <p><b>DATA SHEET</b></p>	<p>Ref : TDS/ HM-1</p> <p>Page : 1/3</p> <p>Rev : 2    Date : 07/12</p>
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## FLUORESCENT PENETRANT HM-1



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

### **DESCRIPTION / APPLICATION(S):**

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

**Companion products :**      DR-60, N106A removers  
   N120, DR-62 cleaners  
   D-100, R60, D-90G, D-106 developers

### **SPECIFICATION(S) / STANDARD(S):**

- Conforms to      code(s) :      ASME  
   standard(s):      ISO 3452-2
- Homologation :    QPD – AMS 2644
- This product complies with REACH regulation.

### **PHYSICO-CHEMICAL PROPERTIES:**

- Aspect                    : green liquid
- Fluorescence         : yellow-green
- Flash point             : > 93°C
- Viscosity                : 3.7 mm<sup>2</sup>/s at 38°C
- Density                 : 0.872 ± 0.020 g/cm<sup>3</sup>
- Water tolerance       : > 5%
- Free of halogen and sulphur
- Compatible with all metals and certain plastics.

### **PACKAGING / TRANSPORT / STORAGE:**



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## TECHNICAL

## DATA SHEET

Ref : TDS/ HM-1

Page : 2/3

Rev : 2 Date : 07/12

- **Packaging:** 1, 5, 10 L can  
60, 200 L drum
- **Transport / Handling:** Refer to Material Safety Data Sheet (MSDS).
- **Storage / Shelf life:** Keep away from moisture  
Temperature range: 0°C à 50° C  
Keep packaging closed after taking out some of the product  
Can / drum: 60 months

### INSTRUCTIONS:

(These 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).

#### Application:

Apply HM-1 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 suffice. 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-1 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-1 is self developing. Nevertheless it is recommended to use a developer as listed above.

#### Inspection:

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

**HEALTH AND SAFETY:** Refer to Material Safety Data Sheet (MSDS).

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