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PENETRANT FLUORESCENT HM-3A



MANUFACTURER: SHERWIN Inc. (USA) / NDT-Europa (NL)

DESCRIPTION / APPLICATION(S):

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

Companion products: DR-60, N106A removers
N120, DR-62 degreaser
D-100, D-106, D-90G developer

SPECIFICATION(S) / STANDARD(S) :

- Conforms to code(s) : RCC-M
 standard(s): ISO 3452-2
 specification(s): ALLISON
 SAFRAN
 EADS
 BOEING, LOCKHEED, GENERAL ELECTRIC
 DASSAULT
 PRATT & WHITNEY (medium)
 CFMI Code produit CP 33.03
 ROLLS-ROYCE (OMAT : 653F)
- Homologation : PMUC (French acronym for : Products and Equipments allowed for use in power plants operated by EDF-French Electricity Board)
- Homologation : QPL – AMS 2644
- This product complies with REACH regulation.

PHYSICO-CHEMICAL PROPERTIES:

- Aspect : green liquid
- Fluorescence : green-yellow
- Flash point : > 93°C
- Viscosity : 6.6 mm²/s ± 10% at 40°C
- Very low halogen and sulfur content.
- Compatible with all metals, ceramics and certain synthetic substances.

PACKAGING / TRANSPORT / STORAGE :

- **Packaging :** 1, 5, 10, 25, 60L can
200L drums
1000L container
Spraycan 300mL
- **Transport / Handling:** Refer to Material Safety Data Sheet (MSDS).
- **Storage / Shelf life:** Keep away from moisture
Temperature range: 5°C à 50°C
Keep packaging closed after taking out some of the product.
Can / drum / Spraycan / Container : 60 months

INSTRUCTIONS:

Before any application, it is essential to remove all the dirt that clog defects, using a suitable method.

Penetrant application :

Sprayed (electrostatic, pneumatic, spray), brushed, dipped.

In the latter case, it is advantageous to soak the parts for 1/3 of the contact time, the remaining 2/3 for drainage.

Total contact time: 5 to 30 minutes depending on the case.

Penetrant removal:

By washing with water at room temperature to a pressure of 30 to 200 kPa.

It is recommended to use the lowest pressure possible.

The washing is carried out under UV-A light in order to ensure that there are no fluorescent background.



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Drying:

By circulating hot air (60-80°C), the use of a blow of compressed air, infrared lamp or hot air gun is strongly discouraged.

Development:

Although the HM-3A is self-bleeding, the use of a developer increases the ease of detection.

Inspection:

It has to be done in a dark area (illuminance below 20 lux) and under sufficient UV-A illumination (mini 1000 $\mu\text{W} / \text{cm}^2$, possibly greater than or equal to 1500 $\mu\text{W} / \text{cm}^2$).

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

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