 <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/ <b>PR-27</b></p> <p>Page : 1/3</p> <p>Rev : 7 Date : 12/2012</p>
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## RED DYE PENETRANT PR-27



**MANUFACTURER : SHERWIN INC (USA) /NDT EUROPA (NL)**

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

Type II, Method A (waterwashable) and Method C (solvent removable), level 1 red dye penetrant as per ISO 3452-2 standard. Easy to wash.

**Rhodamine-free, Azo III A2 amine (diazo) free.**


**Companion products :** Cleaner / Remover N 120, DR-60, N106A, DR-62  
Non aqueous wet developer D-100, R60, D-106.

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

- Conforms to code(s) : ASME, RCC-M  
standard(s) : ISO 3452-2, ASTM E 1417
- This product complies with REACH regulation.

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

- Aspect : purple-red liquid
- Flash point : > 60°C
- Very low content in sulphur and halogens
- Compatible with any metal and some synthetic materials

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### PACKAGING / TRANSPORT / STORAGE :

- **Packaging :** 500 mL spraycan  
1, 5, 10, 25 L can  
60, 200 L drums
- **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 / Spraycan : 60 months

### INSTRUCTIONS :

Surface must be free of contaminants, **even inside flaws**. Use adequate methods to remove oxides, paints, oil, water, etc...

Prior to applying penetrant, wipe out with degreaser N120 and rags or cleaning rags N120. Allow 2 minutes for complete evaporation.

#### Application :

Apply penetrant by any adequate means (spraying, brushing, flowing, dipping, etc...)

#### Dwell time :


20 minutes are recommended. Dwell time may be shortened down to 10 minutes when only large cracks are sought for, or extended up to several hours for tight cracks.

#### Excess of penetrant removal :

This is a delicate operation. Remove the excess penetrant from the surface, being careful not to remove the penetrant trapped in the defects.

Rinse under low pressure (50 to 200 kPa), with the nozzle of gun 30 to 40 cm from the part, during the shortest time possible, until the red background disappears. If a red background remains on particularly coarse parts, clean it off with a N106A wipe or DR-60, then rinse again within 30 seconds. If you can't or don't want to use water, carry out the following procedure (and not any other).

- Wipe off the excess of penetrant from the surface using clean rags.
- Using rags lightly moistened with N106A or DR60, wipe again.
- As a final step, wipe with clean, dry rags.

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**Developer :**

After complete drying apply one of the mentioned developers as a thin, even coat by spraying only.

Wait for 10 to 30 minutes before inspection.

**Inspection :**

Parts shall be inspected as per ISO 3059 standard requirements.

Inspection is better off when using a “cool white” light, colour temperature being more than 4500K and colour rendition index more than 80 or light with an illuminating index of D65. It is recommended NOT TO USE undervoltaged incandescent bulbs, as it often happens with battery-operated units, this giving a yellowish light.

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

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