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|  <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>TECHNICAL</p> <p>DATA SHEET</p> | <p>Ref : TDS/ RC-65</p> <p>Page : 1/3</p> <p>Rev : 4 Date : 11/11</p> |
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POST-EMULSIFIABLE FLUORESCENT PENETRANT RC-65



MANUFACTURER : SHERWIN Inc (US) / NDT Europa (NL)

DESCRIPTION / APPLICATION(S) :

Post-emulsifiable high sensitivity fluorescent penetrant designed for inspection of critical parts, turbines blades, assemblies, welds.

Type I, method B, C, D, level 3 according AMS 2644 and level 4 according ISO 3452-2.


Companion products : Lipophilic emulsifier ER 85
Hydrophilic emulsifier ER-83A, ER-83B, ER-83C
Developer D-90G, D-100, D-106, R 60

SPECIFICATION(S) / STANDARD(S) :

- Conforms to code(s) : ASME
standard(s) : ISO 3452-2
specification(s): DASSAULT
EADS
SNECMA
ROLLS ROYCE
PRATT & WHITNEY
- Homologation : QPD – AMS 2644
- This product complies with REACH regulation.

PHYSICO-CHEMICAL PROPERTIES:

- Aspect : green liquid
- Fluorescence : green-yellow
- Flash point : > 93°C
- Viscosity : 5.7 mm²/s ± 10 % at 38°C

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- Very low halogen and sulfur content
- Compatible with all metals, ceramics, and certain synthetic substances.

PACKAGING / TRANSPORT / STORAGE :

.Packaging : 1, 5, 10, 25 L canisters.
60 L drum.
200 L drum.
300 mL spraycan.

.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
Canister / drum : 48 months
Spraycan : 60 months

INSTRUCTIONS :

Parts cleaning : use appropriate process/products as per applicable specifications

Application :

By spraying (electrostatic, pneumatic, aerosol), using a brush, or by immersion.

Dwell time :

10 to 30 minutes, depending on applicable specs. If dipping is used, allow the penetrant to drain from the part surface back to the penetrant tank.

Removal :

Two separate procedures apply:


- with pre-wash
- without pre-wash

Pre-wash :

RC-65 → Pre-wash → Hydrophilic emulsifier → Rinsing → Drying → Developer

Conventional post-emulsion method diagram :

RC-65 → Hydrophilic or lipophilic emulsifier → Rinsing → Drying → Developer
The first process will save considerable quantities of emulsifier.

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The emulsifier is applied by immersion or by spraying (see technical datasheet ER-83A, ER-83B, ER-83C or ER-85).

Rinsing off :

Use coarse plain water spray to remove all traces of emulsified penetrant
Air + water spray gun is a good alternative.
Washing is carried out under UV-A radiation, so as to ensure that no fluorescent background is left.

Drying :

A circulating oven (60 to 80°C ; 140°F to 176°F) is suggested; do not use compressed air. Infrared lamps and/or air guns are not advisable.

Development :

Although RC 65 is self-developing, using a developer enhances indications.

Inspection :

Inspect parts under appropriate UV-A lighting (mini 1000 $\mu\text{W}/\text{cm}^2$, if possible $\geq 1500\mu\text{W}/\text{cm}^2$) and dimmed visible light (less than 20 lux).

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

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