



RC-65

POST-EMULSIFIABLE FLUORESCENT PENETRANT

Technical Data Sheet

Approvals and conformities

ASME
DASSAULT AVIATION
EADS
ISO 3452-2
PRATT & WHITNEY
QPD-AMS 2644
ROLLS ROYCE
SAFRAN

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, R60

DIRECTIONS FOR USE

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

Application :

1/3

12018-07-31F. Héron

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.

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 W/cm², if possible > 1500 W/cm²) and dimmed visible light (less than 20 lux).

TECHNICAL CHARACTERISTICS

Very low halogen and sulfur content

Compatible with all metals, ceramics, and certain synthetic substances.

Appearance green liquid
Fluorescence green-yellow
Flash point > 93°C
Viscosity 5.7 mm²/s \hat{A} ± 10 % at 38°C

PRECAUTIONS FOR USE AND STORAGE

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

This technical data sheet replaces and cancels the previous one.

The above details have been compiled to the best of our knowledge. They have, however, an indicative value only and we therefore make no warranties and assume no liability in connection with any use of this information, particularly if a third party's rights are affected by the use of our products. The above information has been compiled based upon tests carried out by SOCOMORE. All data is subject to change as Socomore deems appropriate. The data given is not intended to substitute for any testing you must conduct in order to determine the suitability of the product for your particular purposes. Please check your local legislation applicable to the use of this product. Should you need any further information please contact us.