

SKL-4C WATER BASED PENETRANT

GENERAL DESCRIPTION

SKL-4C is a water based, water washable red penetrant. It appears dark purplish red under visible light and fluorescent orange under black light to give it a dual range inspection capability. SKL-4C can be diluted infinitely with water, but the recommended dilution is 1:1.

Warning! Penetrants attack and even dissolve many kinds of plastic pipe. Polyvinyl chloride (PVC) pipe is especially vulnerable, and can crumble after only a few days of exposure. Even diluted penetrant rinsings attack it rapidly. ABS plastic pipe is nearly as sensitive. When installing plumbing to handle penetrant rinsings, use metal pipe.

APPLICATIONS

SKL-4C is designed for use on ceramics and as a leak test penetrant.

COMPOSITION

SKL-4C is composed of surface active agents, dye and water.

TYPICAL PROPERTIES (Not a specification)

Typical Properties	SKL-4C
Color	Dark Purplish Red
Flash Point	None
Density	8.5 LB/GAL
Viscosity @ 38° C	8 cs
VOC	275 g/l
NPE Free	Yes

METHOD OF APPLICATION

SKL-4C may be applied by dipping, brushing, flow on, or conventional spray. *Test part must be cleaned and dried before penetrant application.*

PENETRATION - DWELL TIME

The generally accepted minimum penetration time is 10 minutes, although specific process specifications may require longer dwell times.

TEMPERATURE

SKL-4C should be used at temperatures between 50° F – 125° F. Lower temperatures thicken the penetrant and longer penetration times are necessary. High temperatures should be avoided since this can lead to the breakdown of the dye resulting in color fade.

PENETRANT REMOVAL

SKL-4C is easily removed by water rinsing. Because SKL-4C is water soluble, care must be taken to avoid over washing, thereby depleting the discontinuities of penetrant. On smooth surfaces, a towel moistened with water may be used to wipe away surface penetrant for maximum sensitivity.

RECOMMENDED DEVELOPERS

A developer is used to maximize the sensitivity and to provide a white contrasting background against which the red indications can be readily seen. Two types of developer can be used:

SKD-S2: SKD-S2 is a *non-aqueous developer* which is generally applied to yield a white background to contrast with the red penetrant.

ZP-5B: ZP-5B is an *aqueous water suspendible developer* which is applied before the parts are dried. Care should be taken to dry parts as quickly as possible to prevent the aqueous developer from washing the penetrant from discontinuities.

PACKAGING

5 Gal. Pail, 55 Gal. Drum.

COVERAGE

(1) Gal. covers approximately 800 square feet.