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TECHNICAL DATA SHEET

Ref: HM 704

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Rev: 1 Date: 05/05



MANUFACTURER : SHERWIN (USA)/NDT Europa (NL)
DISTRIBUTOR: NDT Consultants Limited (UK)

DESCRIPTION / APPLICATIONS:

Water-Washable FLUORESCENT PENETRANT designed for detecting surface defects.
Biodegradable penetrant, odorless and vapor-free

COMPANION PRODUCTS:

Developers : D 90G, D 100, R 60, R 62.

SPECIFICATIONS / STANDARDS:

SAE-AMS 2644- QPL 2644-1
Type I method A level 4,
EADS/AEROSPATIALE IGC 04.25.101
ROLLS ROYCE: RPS 702 -F1B
TSD 594-op 213 standard 1A3
GENERAL ELECTRIC, BOEING, LOCKHEED: in accordance with QPL
DASSAULT: IQ1-0.1.20 A
ASME Code

PHYSICO-CHEMICAL PROPERTIES:

Aspect: green liquid
Fluorescence: green-yellow
Flash point: > 93° C.
Very low halogen and sulfur content
Compatible with all metals and certain plastics.

PACKAGING / SHIPPING / STORAGE:

Packaging: 1-L, 5-L, 10-L canisters.
60-liter barrel.
200-liter barrels
Shipping / Handling: refer to MSDS
Storage / Shelflife: 48 months.

INSTRUCTIONS:

(These describe the basic process, but they may need to be amended by the user to comply with applicable specifications and/or inspection criteria provided by the contracting agency).

1. Application: Apply HM-604 only to clean, dry surfaces by spraying, flowing, brushing or dipping.

2. Dwell-Time: A 10 minute dwell time is suggested, although in many cases five minutes will suffice. When particularly tight cracks are suspected, or the part is especially critical, the dwell time may be extended to 30 minutes, or longer. Do not soak the part. To increase sensitivity, as well as conserve material, allow the penetrant to drain from the

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part surface back into the penetrant tank.

3. Removal: Use a quick, ambient temperature water wash at tap pressure to rinse HM-604 from the part surface. To avoid washing entrapped penetrant from surface flaws, do not use high water pressures and temperatures, or prolonged washing and scrubbing.

4. Drying: A recirculating oven set no higher than 160°F (71°C) is suggested. Leave part in oven just long enough to evaporate surface moisture. Drying is improved by using pressurized air to disperse and remove as much excess water as possible before placing part in oven.

5. Developing: HM-704 is self developing. Nevertheless it is recommended to use a developer as listed above.

6. Inspection: Inspect parts under appropriate UV-A radiation and dimmed visible light, in accordance with ISO 3059-2001 standard.

HEALTH AND SAFETY: refer to MSDS.

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