



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 - BMW GROUP
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 ISO 3452-2.

Companion products :

Lipophilic emulsifier ER-85
Hydrophilic emulsifier ER-83B, ER-83C
Degreaser/Cleaners DR-60, DR-62
Developer D-90G, D-100, D-106, R60

DIRECTIONS FOR USE

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

Application :

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

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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-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 > 1500 $\mu\text{W}/\text{cm}^2$) 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 6.5 mm²/s ± 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.

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