

# Technical Data



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## FLAWFINDER Cleaner Spray NDT Crack Detection System

### Product Overview

FLAWFINDER CLEANER SPRAY is an aerosol applied cleaner used as part of the NDT crack detection system for pre-use cleaning, also for the easy removal of FLAWFINDER DYE PENETRANT and FLAWFINDER DEVELOPER Sprays.

The FLAWFINDER non-destructive inspection system is designed to provide a fast reliable method for visual detection of cracks or flaws which would not normally be visible to the naked eye. Ideal for the inspection of welded joints, castings, forgings on many different materials.

**A bright red indication will mark the flaw or crack.**

### Features and Benefits

- Rapid and effective cleaning agent.
- Non-chlorinated solvent.
- Multi-angle valve system.
- Leaves no residue.

### Directions for Storage and Use

- Shake aerosol well before use
- Apply from a distance of 15-30cm
- As with all products of this type it is recommended that compatibility with painted or coated surfaces, plastics and rubber be tested prior to use
- The storage temperature should be kept below +50°C, and the storage area should be out of direct sunlight
- Shelf life is 5 years from date of manufacture

### Specification

Meets the requirements of **ISO 3452-2**

### Pack Sizes

| Pack Size | Part Code |
|-----------|-----------|
| 300ml     | 63125     |

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## FLAWFINDER Developer

### NDT Crack Detection System

#### Product Overview

FLAWFINDER Developer is an aerosol applied white powder that is designed to draw the penetrant out of a flaw to enhance the definition. It is used to facilitate detection when used in conjunction with the NDT crack detection system.

FLAWFINDER is designed to provide a fast reliable method for visual detection of cracks or flaws which would not normally be visible to the naked eye. Ideal for the inspection of welded joints, castings, forgings etc...

**A bright red indication will mark the flaw or crack.**

#### Features and Benefits

- Highly visible white powder for strong definitions
- Multi-angle valve system
- Detection can be carried out under natural or electric light
- Easily removed by rinsing with water
- Can be used on most materials including steel, stainless steel, aluminium, cast iron, ceramics, plastics, carbides, brass, copper and magnesium
- Acts as an anti-glare spray when 3D scanning
- Convenient and easy to use

#### Product Overview

- Shake aerosol well before use
- Apply from a distance of 15-30cm
- The storage temperature should be kept below +50°C, and the storage area should be out of direct sunlight
- Shelf life is 5 years from date of manufacture

#### Typical Applications

- Threaded connections on drilling rods in industries such as crude oil, mining, public works, quarries etc.
- Engines, boilers, furnaces, generators etc.
- Gas flow or continuous electrode nozzle heads.
- Valves and fittings in the chemical and petrochemical industries.
- In the automotive industry for use on exhaust connections, cams, joints, brakes etc.
- Ideal for spraying components prior to 3D scanning when inspecting or reverse engineering.

#### Specification

Meets the requirements of **ISO 3452-2**

#### Pack Sizes

| Pack size | Part Code |
|-----------|-----------|
| 400ml     | 63135     |

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## FLAWFINDER Cleaner Spray NDT Crack Detection System

### Application Method

**Cleaning**—Clean the area to be tested with FLAWFINDER CLEANER SPRAY and wipe thoroughly with a tissue or lint free cloth. Ensure the surface is clean, dry and free of contaminants. Repeat if necessary. After a final wipe, allow time to dry before using FLAWFINDER Dye Penetrant.

**Apply Penetrant**—Spray the test area and allow a minimum of 10 minutes contact time. Extremely fine definitions may take up to 30minutes.

**Remove penetrant**—Once the contact time has elapsed, the excess penetrant should be removed with a dry cloth, repeat if necessary. The remainder should be removed with a cloth pre-moistened with cleaner. Care is to be taken at this stage not to flush out the penetrant with cleaner as this will impair sensitivity. Repeat this procedure until surface penetrant is removed.

**Develop**—Shake the can well. Apply a thin film of FLAWFINDER Developer to the test area. Too much developer will mask indications. Leave for 10minutes to draw up the retained penetrant from any flaws of cracks. Larger cracks will show immediately, minute flaws or cracks may take a few minutes to develop the best indications.

**Inspection**—Suspect areas should be examined under natural or electric light for signs of flaws and cracks. Cracks will show up as lines whilst porosity will appear as pin holes.

If the results are inconclusive repeat the process taking greater care when removing the excess penetrant.

| Property   | Result                                |
|------------|---------------------------------------|
| Propellant | CO <sub>2</sub>                       |
| Solvent    | Blend of non-chlorinated hydrocarbons |
| Odour      | Characteristic                        |

Values quoted above are typical and do not constitute a specification.

### Safety Data Sheets

Safety data sheets are available for download from our website [www.rocol.com](http://www.rocol.com) or may be obtained from your usual ROCOL contact.

The information in this publication is based on our experience and reports from customers. There are many factors outside our control or knowledge which affect the use and performance of our products, for which reason it is given without responsibility.

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## FLAWFINDER Developer NDT Crack Detection System

### Application Method

**Cleaning**—Clean the area to be tested with FLAWFINDER Cleaner Spray and wipe thoroughly with a tissue or lint free cloth. Ensure the surface is clean, dry and free of contaminants. Repeat if necessary. After a final wipe, allow time to dry before using FLAWFINDER Dye Penetrant.

**Apply Penetrant**—Spray the test area and allow a minimum of 10 minutes contact time. Extremely fine definitions may take up to 30minutes.

**Remove penetrant**—Once the contact time has elapsed, the excess penetrant should be removed with a dry cloth, repeat if necessary. The remainder should be removed with a cloth pre-moistened with cleaner. Care is to be taken at this stage not to flush out the penetrant with cleaner as this will impair sensitivity. Repeat this procedure until surface penetrant is removed.

**Develop**—Shake the can well. Apply a thin film of FLAWFINDER Developer to the test area. Too much developer will mask indications. Leave for 10minutes to draw up the retained penetrant from any flaws or cracks. Larger cracks will show immediately, minute flaws or cracks may take a few minutes to develop the best indications.

**Inspection**—Suspect areas should be examined under natural or electric light for signs of flaws and cracks. Cracks will show up as lines whilst porosity will appear as pin holes.

If the results are inconclusive repeat the process taking greater care when removing the excess penetrant.

| Property   | Result            |
|------------|-------------------|
| Appearance | Fine White Powder |
| Propellant | LPG               |
| Solvent    | Ketonic           |
| Odour      | Characteristic    |

Values quoted above are typical and do not constitute a specification.

### Safety Data Sheets

Safety data sheets are available for download from our website [www.ocol.com](http://www.ocol.com) or may be obtained from your usual ROCOL contact.

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# Technical Data

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## FLAWFINDER Dye Penetrant Spray

### NDT Crack Detection System

#### Product Overview

FLAWFINDER Dye Penetrant is an aerosol applied dye which can be sprayed from any angle. Used as part of the FLAWFINDER NDT crack detection system.

FLAWFINDER non-destructive inspection system is designed to provide a fast reliable method for visual detection of cracks or flaws which would not normally be visible to the naked eye. Ideal for the inspection of welded joints, castings, forgings on many different materials.

**A bright red indication will mark the flaw or crack.**

#### Directions for Storage and Use

- Shake aerosol well before use
- Apply from a distance of 15-30cm
- As with all products of this type it is recommended that compatibility with painted or coated surfaces, plastics and rubber be tested prior to use
- The storage temperature should be kept below +50°C, and the storage area should be out of direct sunlight
- Shelf life is 5 years from date of manufacture

#### Features and Benefits

- Highly visible red dye
- Multi-angle valve system
- Detection can be carried out under natural or electric light
- Easily removed by solvent or water washing
- Can be used materials such as steel, stainless steel, aluminum, ceramics, plastics, carbides, brass, copper and magnesium

#### Specifications

Meets the requirements of **ISO 3452-2**

#### Pack Sizes

| Pack size | Part Code |
|-----------|-----------|
| 400ml     | 63151     |

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## FLAWFINDER Dye Penetrant

### NDT Crack Detection System

#### Application Method

**Cleaning**—Clean the area to be tested with FLAWFINDER Cleaner Spray and wipe thoroughly with a tissue or lint free cloth. Ensure the surface is clean, dry and free of contaminants. Repeat if necessary. After a final wipe, allow time to dry before using FLAWFINDER Dye Penetrant.

**Apply Penetrant**—Spray the test area and allow a minimum of 10 minutes contact time. Extremely fine definitions may take up to 30 minutes.

**Remove Penetrant**—Once the contact time has elapsed, the excess penetrant should be removed with a dry cloth, repeat if necessary. The remainder should be removed with a cloth pre-moistened with cleaner. Care is to be taken at this stage not to flush out the penetrant with cleaner as this will impair sensitivity. Repeat this procedure until surface penetrant is removed.

**Develop**—Shake the can well. Apply a thin film of FLAWFINDER Developer to the test area. Too much developer will mask indications. Leave for 10 minutes to draw up the retained penetrant from any flaws or cracks. Larger cracks will show immediately, minute flaws or cracks may take a few minutes to develop the best indications.

**Inspection**—Suspect areas should be examined under natural or electric light for signs of flaws and cracks. Cracks will show up as lines whilst porosity will appear as pin holes

If the results are inconclusive repeat the process taking greater care when removing the excess penetrant.

| Property   | Result                |
|------------|-----------------------|
| Appearance | Deep red              |
| Propellant | LPG                   |
| Solvent    | Blend of hydrocarbons |
| Odour      | Characteristic        |

Values quoted above are typical and do not constitute a specification.

#### Safety Data Sheets

Safety data sheet sheets are available for download from our website [www.rocol.com](http://www.rocol.com) or may be obtained from your usual ROCOL contact.

The information in this publication is based on our experiences and report from customers. There are many factors out of our control or knowledge which affects the use of our products, for which reason it is given without responsibility.

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