

SK-816 Kit

Visible Dye Penetrant Testing Kit

SK Kits are a convenient collection of three Magnaflux dye penetrant testing consumable products that come in an easy-to-use aerosol form for Type 2 penetrant non-destructive testing.

Each penetrant testing kit comes with SKC-S, SKL-SP2, and SKD-S2.



SKC-S Cleaner & Remover

An NDT-approved solvent cleaner/remover for pre-cleaning before non-destructive testing and for removing excess surface penetrant from an inspection area before applying developer during liquid penetrant testing. This non-halogenated solvent remover can be used on a wide range of substrates to remove oils, greases and other contaminants. SKC-S dries quickly without leaving a residue.

Full data sheet available at: magnaflux.com/SKC-S

SKL-SP2 Solvent Removable Visible Red Dye Penetrant

A solvent removable penetrant for portability, especially for welding operations, and is post emulsifiable for greater resolution of flaw indications. It produces strong, vibrant indications due to the visible red color contrast and features outstanding penetrating characteristics. SKL-SP2 is highly reliable at locating surface open flaws and discontinuities and can be used on nonporous ceramics and similar materials.

Full data sheet available at: magnaflux.com/SKL-SP2

SKD-S2 Solvent-based developer

A bright white, non-aqueous developer, SKD-S2 creates an opaque white background for high-contrast penetrant testing and quickly draws penetrant out to create stronger, clearer indications for better inspection reliability and sensitivity. SKD-S2 helps speed up the inspection process by going on easily, drying quickly, promoting faster indication formation and minimizing post-inspection cleaning. It is ideal for machine shops, weld testing and field applications.

Full data sheet available at: magnaflux.com/SKD-S2

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BENEFITS

- A convenient and easy-to-use solution that provides everything needed for dye penetrant testing
- Simple 3-step process for preventative maintenance and control checks
- Vivid, high-contrast color
- Superior flaw resolution
- Excellent reliability
- AMS 2644 QPL approved

SPECIFICATION COMPLIANCE

- AECL
- AMS 2644
- ASME
- ASTM E1417
- ISO 3452
- NAVSEA 250-1500-1
- NAVSEA T9074-AS-GIB-010/271
- QPL SAE AMS 2644

USE RECOMMENDATIONS

NDT Method	Visible Penetrant Testing
Type	Type 2
Methods	B / C
Removal Type	Solvent Removable

HEALTH AND SAFETY

Review all relevant health and safety information before using this product. For complete health and safety information, refer to the product Safety Data Sheet, which is available at www.magnaflux.com.

APPLICATIONS

Ideal for:

- Automotive maintenance
- Machine shops
- Castings
- Ferrous and non-ferrous metals
- Leak testing
- Metalworking
- Non-porous ceramics
- Pressure vessels
- Welds

Defect examples:

- Cracks
- Flux inclusions
- Incomplete weld fusion
- Incomplete weld penetration
- Leaks
- Undercutting
- Weld porosity

PACKAGING

SK-816 Kit, 8 aerosol cans 01-5920-48

- SKC-S, 4 aerosol cans
- SKL-SP2, 2 aerosol cans
- SKD-S2, 2 aerosol cans

INSTRUCTIONS FOR USE

1. Pre-cleaning:

Spray the surfaces to be cleaned liberally with SKC-S then either wipe off or allow to air dry, or soak a clean cloth with the cleaner and wipe the part clean. Allow the part to dry thoroughly before applying the penetrant.

2. Apply Penetrant:

Spray or brush the part or section to be inspected so that surface is covered with penetrant. If penetrant pulls back in droplets stop and clean part again. (Refer to Step 1). Allow penetrant to remain on the part from 10-30 minutes. Longer penetration times may be needed for locating extremely fine or tight discontinuities.

3. Remove Penetrant:

Apply SKC-S to a cloth, wipe test surface and repeat as needed. Do not spray SKC-S directly on the part because penetrant indications may be removed.

4. Apply Developer:

SKD-S2 Should be applied by spray only, since dipping or brushing will cause excessive solvent action on the penetrant in discontinuities. SKD-S2 may be applied by aerosol, or conventional spray gun. SKD-S2 must be agitated during use to ensure the developer particles remain suspended during processing. Solvent-based developers like SKD-S2 should be sprayed in thin even layers, which just wet the surface. A heavy spray will cause excessive bleeding and running of indications; whereas too light a spray will result in slow indication development as well as possible loss in overall sensitivity due to limited solvent action. Allow developer to dry. Watch for large cracks to show up immediately. Smaller cracks may take a few minutes to develop the best indication.

5. Inspect Part:

Defects will be marked by a deep red indication. A line or dotted line marks a crack, lap, forging burst or cold shut. If wide and deep, the indication will grow and spread. Porosity, shrinkage, lack of bond, and leaks will appear as dots or local areas of color. These, too, will grow and spread if the defect is large or extensive.

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