

Product **FLUXO R175** Reference **TDS182D** Date **01/02/2010** Page **1/2**



FLUXO R175

Non Aqueous Liquid Developer



Standards & Specifications	<ul style="list-style-type: none"> ✓ NF EN ISO 3452-2 and NF EN 571-1 ✓ RCC-M ✓ ASME - Boiler and Pressure Vessel CODE - Section V ✓ ASTM E 1417 ✓ ASTM E 165 ✓ Low in Sulphur & Halogens (Nuclear Quality)
Product	: Ready-to-use
Composition	: FLUXO R175 is a suspension of inert white developer particle in a flammable volatile organic solvent.
Properties	<ul style="list-style-type: none"> ✓ <i>Aspect</i> : White solid particles in a clear liquid ✓ <i>Density (20°C)</i> : 0,89 ✓ <i>Flash Point</i> : 12°C ✓ Compatible with any metal & many synthetic materials
Packaging	: Available in 10 litre drums - Aerosol 500ml NET
Shelf Life	: 60 months : Keep the packaging closed after taking out some of the product.
Use	: <i>Companion Materials</i> : : penetrant FLUXO P125 : remover FLUXO N130 : solvent FLUXO S190
Performance Test	: In order to test the evolution of the performances of detection of the FLUXO R175 in time, you can proceed with the reference block type 1 and 2, according to the method described in the standard NF EN ISO 3452-2 (standard part reference 1 & 2).

SREM Technologies can make any modifications

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INSTRUCTIONS

The successful application of penetrant is completely dependant on the ability of the penetrant to enter a defect which is open to the surface. All paint, organic compounds, oils, greases and any other contaminants must be removed completely before application of the penetrant. Use solvent **FLUXO S190**.

Application of Penetrant :

Use **FLUXO P125** in ready-to-use - Application by immersion, spraying, brushing, dipping, etc...

Dwell Time :

A 20 minute, or longer, dwell time is mandatory. Contact times are dependant on the component being tested. Dwell time may be shortened down to 10 minutes when only large cracks are sought for, or extended up to several hours for tight cracks. Allow the penetrant to drain from the part.

Removal :

Remove the excess penetrant from the surface, being careful not to remove the penetrant trapped in the defects. Rinse under low pressure (50 to 200 kPa), with the nozzle of gun 30 to 40 cm (12" to 16") from the part, during the shortest time possible, until the red background disappears.

If you can't or don't want to use water, remove the excess penetrant with solvent **FLUXO S190** or remover **FLUXO N130**.

Drying :

Begin drying procedure immediately after water wash.

Drying temperature of 70°C is normal for oven drying. Use pressurized air to disperse and remove as much excess surface water as possible before placing part in oven.

Developing :

Developers can be applied by spraying or dust storm cabinet. Inspection is normally carried out at least 10 minutes after developing.

Inspection :

Parts shall be inspected as per ISO 3059 standard requirements.



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