

FlawGlo®

Product Data Sheet

SWP 139

Solvent Removable Red Dye Penetrant

SWP 139 is a Solvent Removable Red Dye Penetrant. It is a stable solution of petroleum distillates of high flash point, non-ionic surfactants and red dye. Due to this, it exhibits outstanding penetrating characteristics which provide for maximum reliability in locating surface-open flaws and discontinuities. SWP 139 can be used where a visible penetrant inspection system is required to detect surface breaking flaw.

Appearance:

- Red Mobile Liquid

Properties:

- Density (20°C): 0.87 g/ml
- Flash Point: Above 93°C
- Viscosity: 5 to 10 CST
- Processing Temperature: -10° to 52°C
- Suitable for detecting leaks in castings
- Compatible with any metal & many synthetic materials (compatibility with synthetic & ceramic materials must be checked before use)

Compliance & Specifications:

- ISO 3452-2
- ASTM E165
- ASME B&PV

Application:

- Shake the can vigorously until the marble rattles, and occasionally during use.
- Spray SWP 139 from 7 to 12 inches (18 to 30 cm) & at 45° angle to the test surface, ensuring complete coverage of test area.
- Leave the penetrant dye to dwell for at least 10 minutes. Remove the excess penetrant from the surface, using a lint free cloth and SC 190 cleaner. Make sure not to use the cleaner directly on the test job.
- Continue with SD 175 developer to detect the flaws.
- If clogging develops, turn the spray button 1/4 turn. If clogging persists, remove and clean the spray button. Do not insert a pin or any other object into the can opening. Now, gently place the spray button with a twisting motion, holding the top of the can and pointing the spray button opening away from you.

Shelf Life:

Recommended to use within 24 months, the product can be used for next 3 years if it satisfies spraying & performance parameters.

Pack Sizes: Aerosol Can (1box of 10 cans), each can with Net Qty 400 ml

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