 <p>15 Rue des Frères Lumière – BP 136 78374 PLAISIR FRANCE</p> <p>Pho : +33(0)1.30.80.81.98 Fax : +33(0)1.30.80.81.99 WEB : www.babbco.fr E-MAIL : sherwinbabbco@orange.fr</p>	<p>TECHNICAL DATA SHEET</p>	<p>Ref : TDS/HM-3A</p> <p>Page : 1/3</p> <p>Rev : 4 Date : 11/09</p>
--	--	---

PENETRANT FLUORESCENT HM-3A



MANUFACTURER: SHERWIN Inc (USA) / NDT-Europa (NL)

DESCRIPTION / APPLICATION(S):


Type 1, method A, level 2, according AMS 2644 and ISO 3452-2, water washable fluorescent penetrant designed for detecting surface defects. (medium sensitivity)

.Associated products : DR 60, DR 62 removers
N 120 degreaser / N 106 A
D 100, D90G developer
R 62 quick-drying developer

SPECIFICATION(S) / STANDARD(S):

<p>- Conform to</p> <p>in accordance with AMS 2644</p> <p>sensitivity)</p>	<p>code : RCC-M</p> <p>standards : ISO 3452-2</p> <p>specifications: ALLISON: level 2 TURBOMECA: LC 418, class W2 SNECMA: DMC 0010, sensitivity S2 AIRBUS-EADS Mc DONNEL/DOUGLAS: grade 3 ROLLS ROYCE: RPS 702-TSD 594 BOEING, LOOKHEED, GENERAL ELECTRIC:</p> <p>DASSAULT: Type I, Method A, Level II PRATT & WHITNEY: PMC N° 4350-3 (high</p> <p>CFMI: product code CP 33.03</p>
--	--

- Approved **SAE-AMS 2644-QPL 2644**
PMUC-approved (Produits et matériaux utilisables en Centrales, i.e. Products and Materials that can be Used in Nuclear Plants)

 <p>15 Rue des Frères Lumière – BP 136 78374 PLAISIR FRANCE</p> <p>Pho : +33(0)1.30.80.81.98 Fax : +33(0)1.30.80.81.99 WEB : www.babbco.fr E-MAIL : sherwinbabbco@orange.fr</p>	<p>TECHNICAL DATA SHEET</p>	<p>Ref : TDS/HM-3A</p> <p>Page : 2/3</p> <p>Rev : 4 Date : 11/09</p>
--	--	--

PHYSICO-CHEMICAL PROPERTIES:

- Aspect: green liquid
- Fluorescence: green-yellow
- Flash point: > 93°C.
- Viscosity: 6.6 mm²/s ± 10 % at 40°C.
- Very low halogen and sulfur content
- Compatible with all metals and certain plastics.

PACKAGING / SHIPPING / STORAGE:

- . **Packaging :** 1-, 5-, 10-liter canisters
60-liter drum
200-liter drum
300-ml spray can
- . **Shipping / Handling :** refer to MSDS
- . **Storage / Shelflife :** keep away from moisture
Temperature limit : 0 à 50°C.
Keep the packaging closed after taking out some of the product

Canister / Drum : >48 months
Spray can : >60 months

INSTRUCTIONS : (These describe the basic process, but they may need to be amended by the user to comply with applicable specifications and/or inspection criteria provided by the contracting agency).

1. Application :

Apply HM-3A only to clean, dry surfaces by spraying, flowing, brushing or dipping.


2. Dwell-Time :

A 10 minute dwell time is suggested, although in many cases five minutes will suffice. When particularly tight cracks are suspected, or the part is especially critical, the dwell time may be extended to 30 minutes, or longer.

Do not soak the part. To increase sensitivity, as well as conserve material, allow the penetrant to drain from the part surface back into the penetrant tank.

3. Removal :

Use a quick, ambient temperature water wash at tap pressure to rinse HM-3A from the part surface. To avoid washing entrapped penetrant from surface flaws, do not use high water pressures and temperatures, or prolonged washing and scrubbing.

 <p>15 Rue des Frères Lumière – BP 136 78374 PLAISIR FRANCE</p> <p>Pho : +33(0)1.30.80.81.98 Fax : +33(0)1.30.80.81.99 WEB : www.babbco.fr E-MAIL : sherwinbabbco@orange.fr</p>	<p>TECHNICAL DATA SHEET</p>	<p>Ref : TDS/HM-3A</p> <p>Page : 3/3</p> <p>Rev : 4 Date : 11/09</p>
--	--	---

4. Drying :

A recirculating oven set no higher than 160°F (71°C) is suggested. Leave part in oven just long enough to evaporate surface moisture. Drying is improved by using pressurized air to disperse and remove as much excess water as possible before placing part in oven.

5. Developing :

HM-3A is self developing. Nevertheless it is recommended to use a developer as listed above.

6. Inspection :

Inspect parts under appropriate UV-A radiation and dimmed visible light, in accordance with ISO 3059-2001 standard.

HEALTH AND SAFETY: refer to MSDS

The figures provided in this datasheet are given in all good faith to our customers, out of the sole concern to inform them and help them in their research and verifications. There is no formal or implicit guarantee as to the use of this document.

Consequently, BABB CO may not be held liable for damages for any nature whatsoever arising from the publication of this document. Likewise, none of the information it contains should be construed as an authorization or recommendation to use products that may violate protected industrial property rights.