

Ardrox 906

Water Washable Visible Penetrant

Type II (visible dye), Method A (water washable) and Method C (solvent removable), AMS 2644 approved inspection penetrant

PRIMARY APPLICATION

Ardrox 906 provides

- Low cost
- Crisp indications
- Low residual background
- Temperature stability

Ardrox 906 is used with non-aqueous developers (**Ardrox 9D1B** or **Ardrox NQ1**).

Note: Visible penetrants are not rated by sensitivity but are generally considered equivalent to Level 1.

CHEMICAL CHARACTERISTICS

Flash point.....>200°F (93°C) minimum, ASTM D113 (PMCC)
 Appearance..... deep red
 Sulfur content.....<1000 ppm
 Chloride content.....<1000 ppm
 Density 0.926 g/ml at 68°F (20°C)

APPROVALS

AMS 2644
 NAVSEA 250-1500-1
 ASME Pressure Vessel & Boiler Code

APPLICATION PROCEDURE

Ardrox 906 may be applied by aerosol, brush, tank immersion, conventional or electrostatic spray. The following typical process sequence illustrates the recommended method of use.

PRECLEAN/DRY

Completely remove all surface contamination (rust, paint residues, greases, scale, etc.). After cleaning, make sure that the component is completely dry and cool, 120°F (49°C) or lower, before applying the penetrant. Ardrox 9PR50 solvent-based products may be used as oil and grease cleaners/removers.

PENETRANT APPLICATION

Apply penetrant to the surface and leave on for a suitable dwell period. If the contact period exceeds 120 minutes, the penetrant should be reapplied to the surface.

AMS 2644, METHOD A, PENETRANT REMOVAL: WATER WASH

Water wash in accordance with the relevant specification or Code.

Use either one or a combination of manual spray or automatic spray tank rinses.

To accelerate drying time, use wash water at upper limit temperatures.

AMS 2644, METHOD C, PENETRANT REMOVAL: WIPE OFF

Wipe excess penetrant from surface with a clean cloth. Moisten a clean cloth with **Ardrox 9PR50** or **Ardrox PR1** and wipe surface free of penetrant residue. To maintain sensitivity, do not flood surface with cleaner/remover.

OVEN DRY, AIR RECIRCULATING

Maximum oven temperature: 160°F (71°C)

Use the minimum time necessary to thoroughly dry the components. Use clean, filtered, low-pressure compressed air to remove pockets of water before oven drying. If a drying oven is not available, accelerate drying time by blowing warm air across the part.

APPLY DEVELOPER

Apply non-aqueous developers **Ardrox 9D1B** or **NQ1** by spray; dwell time is the dry time plus two minutes.

INSPECTION

Components should be inspected under bright light (e.g. 100 ft candle). A pinkish developer film indicates incomplete surface penetrant removal. Severe penetrant residue will mask fine indications.

NOTES ON USE

Ardrox 906 is non-corrosive, safe to use on all metal alloys and meets AMS 2644 corrosion requirements.

Ardrox 906 will stain or soften some plastics, rubbers or ceramics; where appropriate, perform a compatibility test.

SAFETY AND HANDLING

Prior to handling and using any of the materials referenced in this document, the Material Safety Data Sheets should be read and understood by all personnel in contact with these materials.

KEEP OUT OF REACH OF CHILDREN

STORAGE

Dry indoor storage at temperatures between 40°F and 100°F is recommended, away from any incompatible materials referenced in the Material Safety Data Sheets. All containers should be tightly closed when not in use.

SHELF LIFE

The shelf life is 3 years (2 years for aerosols).

DISPOSAL

Any disposal of the materials referenced in this document should be in accordance with all applicable federal, state, and local regulations. The process solution can contain components other than those present in the materials as supplied. Analysis of process solutions may be required prior to disposal.

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