

TECHNICAL DATA SHEET

DUBL-CHEK DR-64

Cleaner / Remover

Code 1505

DESCRIPTION

DUBL-CHEK DR-64 Cleaner / Remover can be used in the solvent remove penetrant process and to remove CP-2 white contrast paint from part surfaces. In the penetrant process it is a manual wipe on and wipe off material and is recommended for small areas. When removing CP-2 spray directly onto the surface and wipe. DR-64 may also be used for generally cleaning oily, dirty surfaces. DR-64 is especially suitable for cleaning prior to the application of inspection penetrants. Complies with low sulfur and low halogen requirements.

FEATURES & BENEFITS

- Every aerosol contains a direct spray tube for easy removal of white contrast paint
- Can be used as a pre-cleaner for penetrant inspection evaporates completely and rapidly
- Aerosols offer convenience and portability
- Can be used in the penetrant and magnetic particle inspection process

PHYSICAL PROPERTIES

Colour: Colorless Liquid
Volatility: 100%
Odour: Low petroleum smell
Temperature limit: 4°C to 50°C

SPECIFICATION COMPLIANCE

- SAE AMS 2644
- QPL-AMS-2644 listing
- MIL-I-25135 Revisions C, D & E
- ASME Code NDT, Sec V

ORDERING INFORMATION

Product Code	Packaging
1505/400	400ml (Aerosol)
1505/42	3.8 litres (1 gallon)
1505/51	18.9 litres (5 gallons)
1505/64	208 litres (55 gallons)



BATCH NUMBERS

Batch numbers can be found on the bottom of aerosol cans or labels of bulk containers. Certificate of Conformance documents are provided with the product or can be download from www.callington.com

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DIRECTIONS

Note: These instructions 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.

Penetrant Process

1. **Application:** Apply penetrant only to clean, dry surfaces by spraying, flowing, brushing or dipping.
2. **Dwell Time:** After application, allow the penetrant to drain from the part surface back into the penetrant tank to conserve material.
3. **Removal:** Remove as much excess penetrant as possible using clean, dry rag or towelling. Remove remaining penetrant film by wiping with a lint free rag or towelling that has been slightly moistened with DR-64. Use a minimal of DR-64; avoid flushing penetrant from flaws. Do not spray DR-64 directly on the part surface when removing excess penetrant. Rough surfaces require more generous applications of DR-64.
4. **Drying:** Allow the surface to dry completely before applying developer.
5. **Developing:** Apply the developer by cloud, dusting, spray or dip using the appropriate developer. Flaw marks are visible under appropriate lighting almost immediately, but allow sufficient developing time to enhance the flaw visibility
6. **Inspection:** Inspect parts under appropriate light.

Magnetic Particle Process

1. Clean the test surface and allow it to dry.
2. The longer CP-2 is stirred or agitated the more uniform the spray.
3. Apply a thin coat of CP-2 to the inspection area from a distance of approximately 150mm from the surface.
4. Wait approximately 20 seconds, depending of ambient temperature, for the paint to dry.
5. Magnetise the area to be inspected.
6. Ensure continuous agitation of the suspension fluid. If using an aerosol, shake vigorously before and during inspection.
7. Apply the suspension to the test part.
8. Allow the excess oil/water to run off the inspection area.
9. Inspect the surface under visible light.
10. Collections of particles will reveal discontinuities at the leakage fields.
11. Clean and repeat the process, changing the orientation of the magnetising direction.
12. DR-64 can be used to remove CP-2 after the process is completed.

STORAGE/SHELF LIFE

Keep away from moisture and sunlight. Keep the container closed when not in use. Shelf life: 36 months (3 years) from date of manufacture. Refer to NDT Shelf Life and Storage Recommendations.

HEALTH & SAFETY

DUBL-CHEK DR-64 is flammable and when packaged within an aerosol is extremely flammable. Use with adequate ventilation and away from spark, fire or open flames. Avoid prolonged or repeated contact with skin. Do not breathe gas, fumes, vapour or spray. Consult the MSDS for more Safety and Health information. Get medical attention if irritation develops and persists. Ensure that medical personnel are aware of the material(s) involved and take precautions to protect themselves

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Created 3rd September 2020 Date Printed 3/12/2020 2:31 PM