

TECHNICAL DATA SHEET

DUBL-CHEK DR-64

CLEANER / REMOVER

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.

Properties

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

Companion DUBL-CHEK Products

All DUBL-CHEK penetrant visible and fluorescent products.
BY LUX, DP-40, DP-50, DP-51, DP-52, DP-54, FP-22B, HM-1, HM-2D, HM-220, HM-3A, HM-406, HM-412, HM-430, HM-440, HM-602, HM-604, HM-607, HM-704, HM-707, RC-29, RC-50, RC-65, RC-77, RC-88
CP-2 - White Contrast Paint

Packaging

Aerosol (12 aerosols per carton)	Product Code: 1505/400
3.8L	Product Code: 1505/42
18.9L	Product Code: 1505/51
208L	Product Code: 1505/64

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 for further information.

Specifications

DR-64 meets the requirements of SAE AMS 2644 and is approved for the QPL-AMS-2644 listing.
MIL-I-25135 Revisions C, D & E ASME Code NDT, Sec V

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 downloaded from www.callington.com

Special Features

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.

TECHNICAL DATA SHEET

Instructions

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** contrast paint 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

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.

WARRANTY – All statements, information and data presented herein are believed to be accuracy and reliable but are not to be taken as a guarantee, expressed or implied, for which seller assumes legal responsibility and they are offered solely for your consideration, investigation and verification. Statements or suggestions concerning possible use of this product are made without representation or warranty that any such use is free of patent infringement and are not recommendations to infringe on any patent.
22 August 2007
