

# PRODUCT DATA SHEET

**SPOTCHECK®**

## SKL-4C WATER BASED PENETRANT

### General Description:

Spotcheck SKL-4C is a water based, water washable, biodegradable, red penetrant. SKL-4C is dark purplish red under visible light and fluorescent orange under black light to give it a dual range inspection capability. SKL-4C can be diluted infinitely with water but is generally recommended at 1:1 dilution. SKL-4C can be used as a liquid oxygen compatible penetrant, but is not certified as to its LOX compatibility. *Warning!! Penetrants attack and even dissolve many kinds of plastic pipe. Polyvinyl chloride (PVC) pipe is especially vulnerable, and can crumble after only a few days of exposure. Even diluted penetrant rinsings attack plastic rapidly. ABS plastic pipe is nearly as sensitive. When installing plumbing to handle penetrant rinsing, use metal pipes.*

### Applications:

SKL-4C is designed for use where standard penetrant products may attack the test specimen chemically, such as plastics. SKL-4C is also used as a leak test penetrant.

### Composition:

SKL-4C consists of surface-active agents, dye and water.

### Typical properties (Not a specification)

<b>Color:</b>	Dark purplish Red
<b>Flash point:</b>	None
<b>Density:</b>	8.7 lbs./Gal.
<b>Viscosity:</b>	11 cs @ 100° F
<b>PH (1:1 in Water):</b>	7.0
<b>Sulfur content:</b>	Less than 1%
<b>Chloride content:</b>	Less than 0.2%

### Method of Application:

SKL-4C may be applied by immersion, brushing, flow on or spraying. Note! Test parts MUST be cleaned and dried before penetrant application.

### Penetration/Dwell Time:

The minimum recommended penetrant dwell time is 2 to 15 minutes. Longer penetration times may be necessary depending upon application.

**Temperature:** 50° F to 125° F

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## **Penetrant Removal:**

SKL-4C is easily removed by water rinsing. Because SKL-4C is water soluble, care must be taken to avoid over washing, thereby depleting the discontinuities of penetrant. On smooth surfaces, a towel moistened with water may be used to wipe away surface penetrant for maximum sensitivity.

## **Recommended Developers:**

A developer is used to maximize the sensitivity and to provide a white contrasting background against which the red indications can be readily seen.

- *SKD-S2 non-aqueous developer* is generally applied to yield a white background to contrast with the red penetrant. If the test part consists of material, which prohibits the use of non-aqueous developer, an aqueous developer may be used.
- *ZP-5B aqueous water suspendable developer* is applied before the parts are dried. Care should be taken to dry parts as quickly as possible to prevent the aqueous developer from washing the penetrant from the discontinuities.

**Available Container Sizes:** 5-gallon pails, 55-gallon drums

**Coverage:** 1 gallon covers approximately 800 square feet