

## MAGNAVU® ALKALINE CLEANER DIP & SPRAY FORMULAS

### General Description:

MAGNAVU® is an alkaline cleaner formulated to meet major specifications, to have optimum performance at a minimum concentration, and to be "Environmentally Friendly."

MAGNAVU® Cleaner has been tested in both the pre-cleaning and post-cleaning phases of NDT. It was determined that if a part is thoroughly rinsed after cleaning, it will have no effect on the processing of the part. If a part is not rinsed prior to processing, it can affect the ability to find the defect and the brightness of the indications.

### Composition:

MAGNAVU® is comprised of alkaline builders, surfactants, a corrosion inhibitor, a pH adjuster, and a coupler. MAGNAVU® is available in both dip formula and spray formula for all application needs.

### Typical Properties: (not a specification)

	Dip Formula	Spray Formula
Color	Blue	Light Amber
Odor	Mild	Mild
Ph	11.5	11.0
Total Alkalinity	2.5%	2.5%
% Active	18.5%	10.5%

### Bath Preparation & Tank Life:

To keep foaming to a minimum when preparing a tank of MAGNAVU® cleaner, begin by first charging the tank with the required amount of water and then adding the required amount of MAGNAVU®. Foaming is kept to a minimum by adding in this order. Both MAGNAVU® dip and spray cleaners were formulated for minimum foaming when agitated or sprayed. However, cleaning equipment may vary and foaming may occur. In case of excessive foaming, Magnaflux anti-foam agent ZAF-2 may be added to the bath at 0.1 - 0.5% concentration.

Effectiveness of the cleaner bath should be maintained by monitoring concentration and the amount of soils present. When oils start to float on the surface, the bath is saturated and oils can be skimmed off to extend the life of the bath. The concentration of the tank can be maintained by using a hand-held refractometer. A TDS (Total Dissolved Solids) meter is recommended for concentrations less than 5%. Concentration charts are provided (see pages 3 and 4). It is recommended that the bath be changed every three weeks during normal use and the concentration monitored daily. Spray bath may have to be changed more frequently if recycled.

PROCESS PARAMETERS

	Dip Application	Spray Application
Concentration	5 - 20%	1 - 5%
Time	15 Minutes	2 - 5 Minutes
Mechanics	Ultrasonic or Agitated Immersion	Expendable or Recycled. Spray Between 30-80 psi
Heat	Ambient - 160°F	140° - 180°F
Drying	Parts Should Be Dry Prior to NDT	Parts Should Be Dry Prior to NDT

DIP APPLICATION

SPRAY APPLICATION

Soil	DIP APPLICATION			SPRAY APPLICATION		
	Concentration	Temp.	Time	Concentration	Temp.	Time
Shop Dust	5 - 10%	Ambient - 120°F	15 Minutes	1 - 2%	140° - 160°F	1 - 2 Minutes
Cutting Oils, Mineral Oil, Coolants	10 - 20%	120° - 160°F	15 Minutes	2 - 4%	160° - 180°F	2 - 4 Minutes
Lub. Greases, Carbon Deposits (soot)	10 - 20%	145° - 160°F	15 Minutes	3 - 5%	160° - 180°F	3 - 5 Minutes

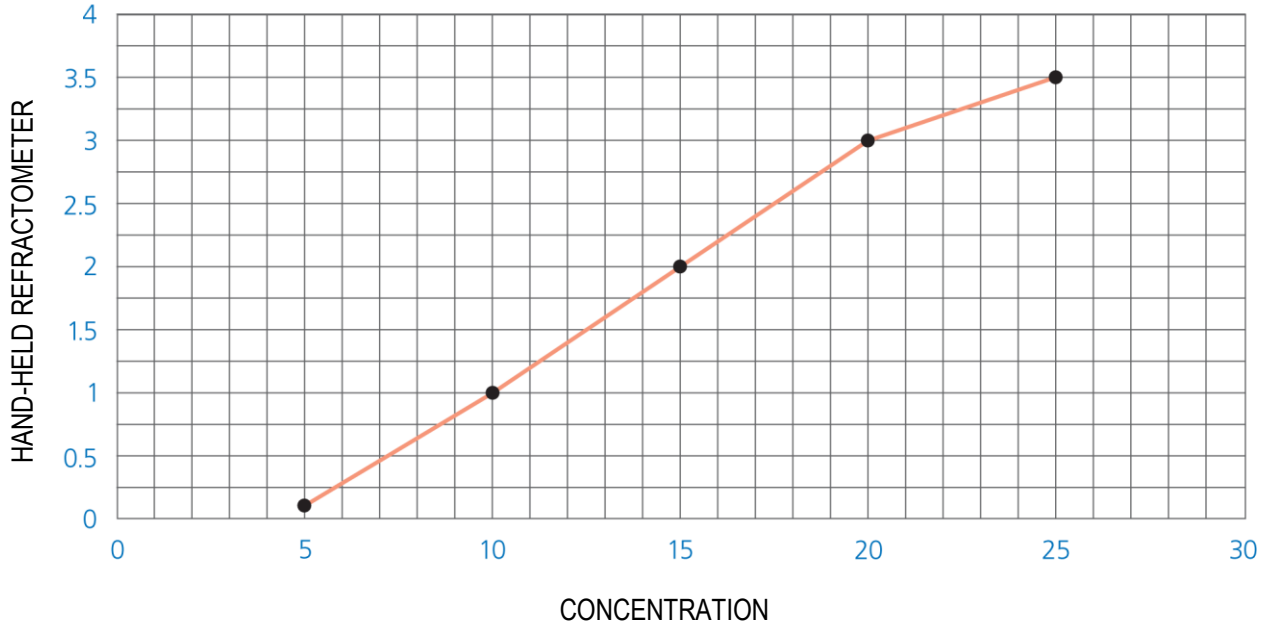
**Packaging:**

MAGNAVU® Dip – 5 Gal. Pail, 55 Gal. Drum.

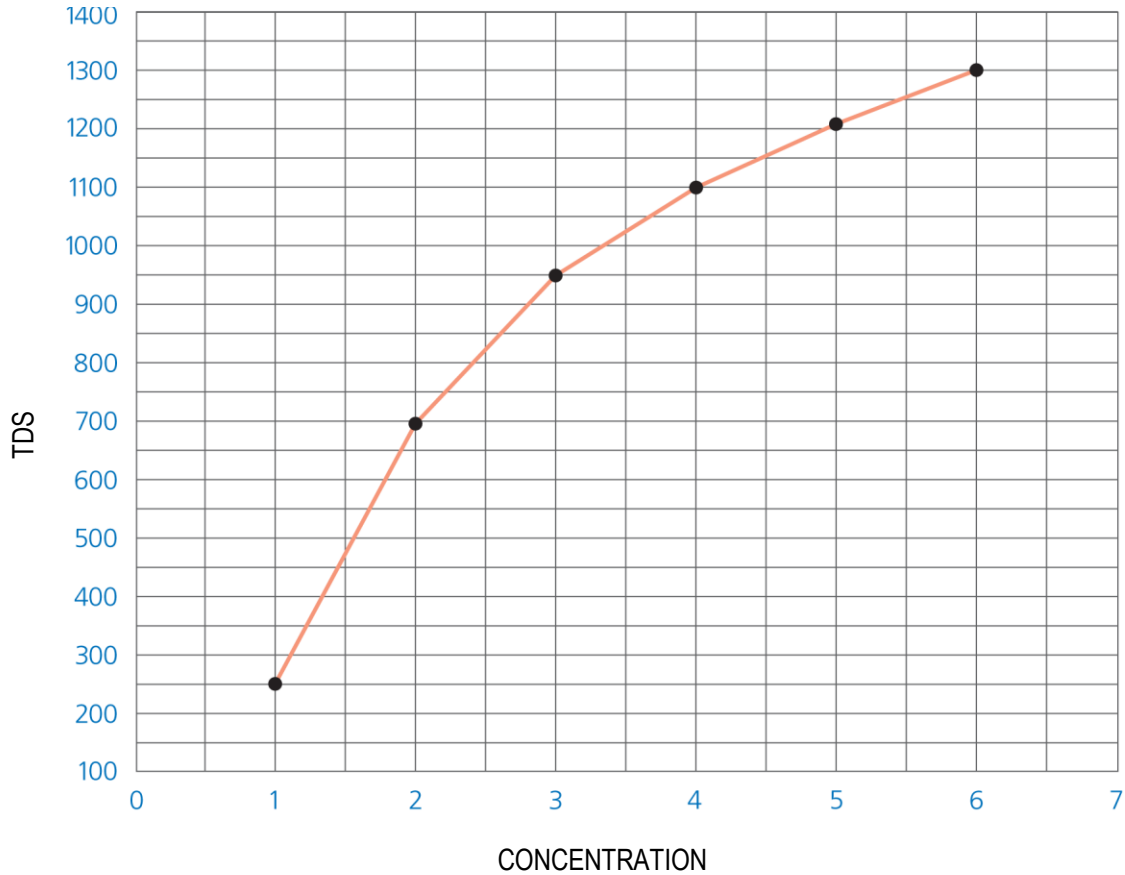
MAGNAVU® Spray – 55 Gal. Drum.



MAGNAVU® DIP APPLICATION  
CONCENTRATION CONTROL HAND-HELD REFRACTOMETER



MAGNAVU® SPRAY APPLICATION  
CONCENTRATION CONTROL TDS METER



Skim or filter the tank before doing the following procedure: 1) Run TDS on a sample of plain water used for diluting the spray cleaner. This will be the control. 2) Run TDS on a sample of the spray cleaner solution. 3) Subtract the control reading from the sample reading. This will be the number used to determine concentration. 4) Use the graph above to figure concentration.

