

# 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. *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 may also be used on ceramics. 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 10 minutes. Longer penetration times may be necessary depending upon application.

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Temperature: 50° F to 125° F

## 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