

# Product Data Sheet

**SPOTCHECK®**

## SKL-WP2 Visible Dye Penetrant

Classification: Type 2, Method A (Water Washable)  
Type 2, Method C (Solvent Removable)

General Description: Spotcheck SKL-WP2 is a red visible dye, low odor penetrant. SKL-WP2 exhibits outstanding penetrating characteristics, which provide for increased reliability of discontinuity identification. SKL-WP2's water wash removability in Method A applications eliminates the need for solvent removers or emulsifiers to remove excess surface penetrant. *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 it rapidly. ABS plastic pipe is nearly as sensitive. When installing plumbing to handle penetrant rinsings, use metal pipe.

Applications:

<b>Weld Inspection</b>	<b>Gross Casting Cracks</b>
<b>Shrinkage cracks</b>	<b>Porosity</b>

Composition: SKL-WP2 consists of non-volatile penetrating oils, surface active agents (emulsifiers) and dye.

Typical properties (Not a specification):

Color:	Dark purplish red
Flash Point	200°F PMCC (93°C Minimum)
Viscosity:	7.2 – 8.8 cs @ 100°F
Density:	7.3 lb/gal @ 60°F (0.88 gm/cc)
Corrosion:	Meets requirements of AMS-2644

Method of Application:

Immersion, flooding, brushing, conventional spray, aerosol spray

Penetration/Dwell Time:

The generally accepted minimum penetration time is 10 minutes. Some specifications may require longer dwell times.

Temperature: 40°F to 125°F

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Penetrant Removal:

Method A: SKL-WP2 is generally removed by water spray. The wash temperature envelope is 50° to 100°F. (Use of water removal of SKL-WP2 below 32°F is impractical because of freezing).

Method C: SKL-WP2 can be removed by SKC-S solvent cleaner/remover. Moisten a cloth or paper towel with cleaner/remover and wipe excess penetrant from the surface. Do not flood part surface with cleaner/remover as this could impair sensitivity.

Recommended Developers:

SKD-S2 Solvent-based developer or ZP-5B Water suspendible developer

A developer must be used to maximize the sensitivity of the SKL-WP2 penetrant. Developers produce a white contrasting background for the red indications.

**Note!** SKD-S2 *must* be applied by spraying. *Dipping or brushing will destroy indications.* Also, the test surface must be dry before application.

ZP-5B is best applied by dipping. ZP-5B is applied to wet surfaces; then dried.

Specification Compliance:

AMS 2644, Boeing PS 21202, MIL-STD-271, ASME B&PV Code, Section V, MIL-STD-2132, NAVSEA 250-1500-1, AECL, ASTM E 165, Boeing BAC 5423 PSD 6-46 or 8-4, ASTM E 1417, General Electric P50YP107

Packaging:

Case of 4 - one-gallon containers, 5 gallon pails, 55 gallon drums, aerosols

Coverage: 1 gallon covers approximately 1,200 square feet.

1 aerosol can (16 ounce by volume) covers approximately 65 square feet.