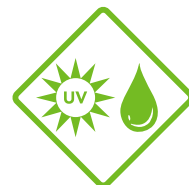


ZL-2C, ZL-27A, ZL-37

Post-Emulsifiable Fluorescent Penetrants



ZYGLO® ZL-2C, ZL-27A and ZL-37 are fluorescent post-emulsifiable penetrants designed to be removed from the test part surface by emulsifiers or solvent. Both Method B lipophilic emulsifier ZE-4B and Method D hydrophilic emulsifier ZR-10C can be used to remove these penetrants. With a UV-A light source, indications will appear as a bright green-yellow fluorescence.

Our post-emulsifiable fluorescent penetrants have a high flash point, and are designed to be used in open dip tanks.

BENEFITS

Improve indication detection

- Clear, bright indications are easier to detect due to high UV and thermal stability – even for small flaws and discontinuities
- Indications stand out more since background fluorescence is minimized; emulsifiers only remove surface penetrant without the risk of over-washing

Maximize penetrant inspection process control

- Prevents over-washing since these penetrants cannot be removed with water (unless combined with an emulsifier)
- PE penetrant system is less susceptible to human error since only surface penetrant is removed in the final rinse stage

Wide range of inspections

- Inspect a wide range of high-value components without fear of corrosion or specification non-conformance
- Meets all major industry and NDT specification requirements, including Aerospace Prime and OEM specs, AMS 2644 and ISO 3452

FEATURES

- Bright indications
- Minimal background fluorescence
- High flash point
- Available in medium, high and ultra-high sensitivity
- Immiscible with water, which protects against over-washing and allows the penetrants to separate easily from water.

APPLICATIONS

Defect location: open to surface

Ideal for:

- Castings
- Forgings
- Extrusions
- Welds
- Rough surface finish

Ideal for:

- Cracks
- Laps
- Seams
- Delamination
- Porosity

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COMPOSITION

A blend of petroleum distillates, oils, alkyl aryl phosphate and fluorescent dyes.

PRODUCT PROPERTIES

Form and colour	Green-yellow liquid
Corrosion	Meets AMS 2644
Sulphur content	< 300 ppm
Chloride content	< 300 ppm
Fluoride content	< 50 ppm

	ZL-2C	ZL-27A	ZL-37
Density (g/cm³)	0.89	0.93	0.95
Viscosity at 38°C (mm²/s)	6.0	9.2	13.5
AMS 644 sensitivity	Level 2 - Medium	Level 3 - High	Level 4 - Ultra-high

Like all Magnaflux materials, our post-emulsifiable fluorescent penetrants are closely controlled to ensure batch-to-batch consistency, optimum process control and inspection reliability.

SPECIFICATION COMPLIANCE

- AMS2644
- ASME BPVC-V
- ASTM E165/E165M-18
- ASTM E1417/E1417M
- EN ISO 3452-2 (ZL-27A and ZL-37)
- MIL-STD-2132
- Rolls Royce RRP 58003 (CSS 232)
- SAFRAN Pr 5000/In 5000
- Pratt & Whitney PMC 4352-2 (ZL-2C), PMC 4353-2 (ZL-27A), PMC 4354-2 (ZL-37)

USER RECOMMENDATIONS

NDT Method	Penetrant Testing, Fluorescent
Storage temperature	10°C to 30°C
Usage temperature	5°C to 55°C (aerosol -5°C to 50°C)
Flash point	> 93°C
AMS 2644 class	Type 1, Method B/C/D
Coverage	20 - 30m ² per litre (bulk product) 10 - 15m ² per aerosol
Pre-cleaner	SKC-S
Hydrophilic emulsifier	ZR-10C
Lipophilic emulsifier	ZE-4B
Dry developer	ZP-4B
Solvent-based developers	SKD-S2, ZP-9F
Water-based developers	ZP-14A, ZP-5B
UV lamp	EV6000, EV6500, ST700

INSTRUCTIONS FOR USE

Pre-clean the test part and allow to dry. The surface must be free from oil, grease and any other contaminant.

Apply the penetrant by immersion dip, brush, flow on, conventional or electrostatic spray. The test area must be completely covered with penetrant.

Allow contact time of 2 - 5 minutes minimum. 10 minutes should be adequate for most situations, although specific process specifications may require longer - check the controlling process specification (where applicable).

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INSTRUCTIONS FOR USE continued

If you're using a hydrophilic emulsifier, pre-rinse the test part with plain water before applying the emulsifier by spray (hydrophilic) or immersion (lipophilic). Leave for the required length of time then wash with a water spray.

The run-off from a pre-rinse can be treated to separate out the water, which can then be re-used for other pre-rinses. Dye penetrant process rinse waters should not be discharged to local authority waterways or sewers without some form of effluent treatment. We can advise on suitable equipment for this purpose; for more information, please contact us.

Dry the test part by placing in a controlled recirculating warm air dryer at a temperature of 50°C - 70°C.

Apply a developer to maximise the sensitivity of the penetrant and to provide a white contrasting background. There are three types of suitable developer:

Dry powder

Free-flowing, lightweight powders which are applied to the dry component by powder storm, dusting, electrostatic spray or puffer.

Solvent-based

Quick-drying materials which are applied to the dry component by spraying.

Aqueous or water-based

Apply before drying by dipping or spraying. NB: To maximise penetrant sensitivity, do NOT leave parts in aqueous developers for any length of time.

Inspect your test part using a suitable UV source. Any defect indications will fluoresce a bright green-yellow when exposed to UV(A) light at a peak wavelength of 365 nm.

If required, you can clean your test part after inspection. Developer residues can be removed either by wiping with a cloth or by a water and detergent wash. Penetrant residues can be removed by vapour degreasing or solvent soak.

PACKAGING AND PART NUMBERS



HEALTH AND SAFETY

Review all relevant health and safety information before using this product. For complete health and safety information, refer to the Safety Data Sheets, which are available at www.magnaflux.eu