



Pre-cleaning

RED / WHITE WITH DAYLIGHT / ARTIFICIAL LIGHT

FLUORESCENT WITH UV RADIATION

MR[®]- PRECLEANER

Mechanical or chemical preparation and pre-cleaning: Clean the surface to be tested (free of rust, scale, oil, grease, etc.). The defects must be open to the surface.



Penetrant

DRYING

MR[®]- PENETRANT RED

Water washable and/or solvent removable penetrant
Penetration time: Normally between 5 and 60 minutes
Application: Spraying, brushing, pouring over, dipping

MR[®]- PENETRANT FLUORESCENT

Water-washable and/or solvent-removable penetrant
Penetration time: Normally between 5 and 60 minutes
Application: Spraying, brushing, pouring over, dipping



Cleaning

INTERMEDIATE CLEANING

- Remove excess penetrant with a clean, lint-free cloth.
- Removal by rinsing, dipping, wiping with water and/or **with solvent**

CHECKING THE INTERMEDIATE CLEANING FOR RESIDUES OF THE PENETRANT

DAYLIGHT / ARTIFICIAL LIGHT ≥ 350 LX

UV RADIATION ≥ 1000 TO $5000 \mu\text{W}/\text{cm}^2$ AND < 20 LX

DRYING IF NECESSARY



Development

MR[®]- WET DEVELOPER
Solvent-based or water-based

MR[®]- DRY DEVELOPER or MR[®]- WET DEVELOPER
Solvent-based or water-based

OBSERVING THE DEVELOPMENT PROCESS (USUALLY TAKES 10 TO 30 MINUTES)



Inspection

DAYLIGHT / ARTIFICIAL LIGHT
Daylight or artificial light illuminance on the test surface min. 500 lx

UV RADIATION
Irradiation on the test surface 1000 to 5000 $\mu\text{W}/\text{cm}^2$ darkened room max. 20 lx

LOGGING, IF NECESSARY SUBSEQUENT CLEANING AND CORROSION PROTECTION MEASURES

