

Fluorescent Liquid Penetrant Testing

Method A Water Washable

Method B/D Post Emulsifiable

Method C Solvent Removable

1. Preclean with Aqueous Cleaner



2. Apply Penetrant
Dwell 10–30 min.



3. Rinse
50–100°F / 10–38°C at
<40 psi / 2.75 bar



Form a

Form b/c

4. Dry
140°F / 60°C



4. Apply Developer



5. Apply Developer
Dwell 10 min. – 4 hr.



5. Dry
140°F / 60°C
Dwell 10 min. – 2 hr.



6. Inspect



1. Preclean with Aqueous Cleaner



2. Apply Penetrant
Dwell for 10–30 min.



Method B

Method D

3. Apply Emulsifier



3. Rinse
50–100°F / 10–38°C at <40 psi / 2.75 bar



Apply Emulsifier



4. Rinse
50–100°F / 10–38°C at <40 psi / 2.75 bar



Form a

Form b/c

5. Dry
140°F / 60°C



5. Apply Developer



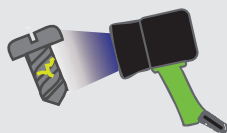
6. Apply Developer
Dwell 10 min. – 4 hr.



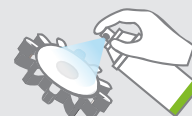
6. Dry
140°F / 60°C
Dwell 10 min. – 2 hr.



7. Inspect



1. Preclean



2. Apply Penetrant
Dwell 10–30 min.



3. Remove Excess Penetrant
Apply cleaner on cloth and then wipe the part



4. Apply Developer
Dwell 10–60 min.



5. Inspect

