



SHERWIN
INCORPORATED

DUBL-CHEK
PENETRANT
PROCESS



LTP 85

LOW TEMPERATURE RED DYE PENETRANT

Technical Data Sheet

Description : Type II, Method C (solvent removable) penetrant, used at temperatures below 32°F (0°C).

Chemical Properties

Color: Red Liquid
Viscosity: 0.68 cSt @ 100°F
Flash Point: 2°F (-16°C)
Specific Gravity: 0.79

Companion Products

DR-62 Remover
D-106 Developer is recommended,
D-100 Developer can be used above 23°F (-5°C)

INSTRUCTIONS

Surface must be free of contaminants, **even inside flaws**. Use adequate methods to remove oxides, paints, oils, water, etc. Prior to applying penetrant, wipe out with cleaner DR-62 and rags.

- 1. Application:** Apply penetrant by any adequate means, spraying, brushing, flowing, dipping, etc.
- 2. Dwell time :**
For very low temperature 5°F to -22°F (-15°C to -30°C), 40 minutes,
Between 32°F and 5°F (0°C and -15°C) 30 minutes.
- 3. Removal:** This is a delicate operation. Remove the excess penetrant from the surface, being careful not to touch the penetrant tapped in the defects. Remove as much excess LTP-85 as possible using a clean, dry rag or toweling. Remove remaining penetrant film by wiping with a rag or toweling that has been slightly moistened with DR-62. Use a minimum of solvent; avoid flushing penetrant from flaws. Do not spray solvent directly on the part surface when removing excess penetrant. Rough surfaces require more generous application of solvent. **NEVER SPRAY DIRECTLY DR-62 ON PARTS.**

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4. **Drying:** Allow the surface to dry completely before applying developer. It may take several minutes.
5. **Developing:** Apply the D-106 developer by spray. Flaw marks may not be visible immediately, allow sufficient developing time.
6. **Inspection:** The lower the temperature the longer the dwell time may be needed, up to 60 minutes before inspection. Inspection is better off when using a "cool white" light. It is recommended not to use under voltage incandescent bulbs, as it often happens with battery operated units, this giving a yellowish light.

HEALTH AND SAFETY : Refer to Material Safety Data Sheet (MSDS).

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