

CRACK DETECTION KIT CDK 10, CDK 20 & CDK 30

*Non Destructive Chemicals for Testing
of Metals and Welds*

Benefits :

- Help detection of microscopic cracks on metals that cannot be visibly located by naked eyes.
- Excellent source of non-destructive examination for surface flaws.
- Due to extremely low chlorine and sulphur contents products can be safely used on stainless steel, nickel, monel and other exotic materials.
- Can be conveniently used by airless spray or by hand pump.
- ▶ Products conform to requirement of *ASTM E-165, ASME Sec. V, IS 1365-1981, IS 3658 & IS 12889-1989.*
- ▶ **Products Approved by : BHEL.**

Applications :

- For detection of surface flaws on dies, moulds, tools, jigs and welds on pressure vessels subjected to pressures and thermal cycles.
- For forgings, castings, high and low temperature equipment.
- As a pre-test during welding layers to prevent ultimate failures in radiography.
- Non-destructive examination of finished components after welding, forging, upsetting, swaging, extruding cold and hot forming and after final heat treatment.
- Industries include Forging, Fabrication, Defence, Railways, Steel and many others.

METHOD OF USE :

- Step A** : Apply Cleaner CDK 10 and clean the surface thoroughly with good quality cotton waste or soft cloth. Apply Dye Penetrant CDK 20 on the surface and allow the penetrant to remain on the surface for a minimum of 10 mins. This dwell time will allow the CDK 20 to penetrate deep inside the discontinuities.
- Step B** : Remove excess penetrant from the surface with cotton waste. Apply minimum quantity of Cleaner CDK-10 and repeat cleaning with cotton waste/cloth.
- Step C** : Spray a thin uniform layer of Developer CDK-30. Allow the penetrant to bleed for 10 minutes. Surface defects like pinholes, cracks, porosities etc. will be visible as pink indication against white background after about 10 minutes.

Characteristics	Test Method	Unit	CLEANER CDK 10	DYE PENETRANT CDK 20	DEVELOPER CDK 30
Colour	Visual	-	Colourless	Deep Pink	White
Film Type	Visual	-	Evaporating	Wet	Dry
Density @ 27°C [typ.]	*CTM	gms/cc	0.78±0.02	0.83±0.02	0.90±0.02
Copper Strip Corrosion	ASTM D-130	-	1a (no corrosion)	1a (no corrosion)	1a (no corrosion)

*CTM=Corporate Test Method

MSDS available on request.

Due to continual upgradation of products above data is subject to change without notice
This supersedes our previously issued data sheets.

[REV.7 / 01.01.14]

Information and data given herein is offered in good faith as accurate, but without guarantee. Conditions of use and suitability of a product for a particular use is beyond our control; all risks of use of the product are therefore assumed by the user and WE EXPRESSLY DISCLAIM ALL WARRANTIES OF EVERY KIND AND NATURE.

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