

### TECHNICAL DATA SHEET

# DUBL-CHEK D-106

## *Non-Aqueous Developer*

**Code 1529**

#### DESCRIPTION

D-106 developer consists of refined white particles suspended in a solution of isopropyl alcohol and acetone. This suspension produces enhanced sensitivity for locating tight flaws. D-106 developer pulls flaw-entrapped penetrant to the part surface for display against a white background by solvent and capillary action. Complies with low sulfur and low halogen requirements.

#### FEATURES & BENEFITS

- D-106 lays on the surface in a thinner, more uniform, more absorbent coating
- Superior suspension properties. Long lasting flaw mark indications; less fading
- It is easily removed by light brushing or spray water rinse
- Works well on smooth or rough surfaces
- Can used on machined or coated surfaces
- Able to be used with both visible and fluorescent penetrants
- Evaporates very rapidly

#### PHYSICAL PROPERTIES

Colour: White Suspended Particles  
 Boiling Point: 180°F (82°C)  
 Flash Point: 53°F (11.7°C)  
 Odour: Petroleum Odour  
 Specific Gravity: 0.79

#### SPECIFICATION COMPLIANCE

- SAE AMS 2644
- QPL – Form D & E
- MIL-I-25135 Revisions E
- Lockheed Martin
- Boeing
- Honeywell
- Pratt & Whitney FPM
- General Electric
- ASME Code NDT, Sec V
- MTU
- Rolls Royce
- Turbomeca
- Airbus



#### ORDERING INFORMATION

Product Code	Packaging
1529/400	400ml (Aerosol)
1529/42	3.8 litres (1 gallon)
1529/51	18.9 litres (5 gallons)
1529/64	208 litres (55 gallons)

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### BATCH NUMBERS

Batch numbers can be found on the bottom of aerosol cans or labels of bulk containers. Certificate of Conformance documents are provided with the product or can be downloaded from [www.callington.com](http://www.callington.com)

### COMPANION PRODUCTS

All fluorescent non-water washable penetrants

### DIRECTIONS

**Note:** These instructions describe the basic process, but they may need to be amended by the user to comply with applicable specification and/or inspection criteria provided by the contracting agency.

1. **Application:** Apply penetrant only to clean, dry surfaces by spraying, flowing, brushing or dipping.
2. **Dwell Time:** A 10-minute dwell time is suggested, although in many cases five minutes will suffice. When particularly tight cracks are suspected, or the part is especially critical, the dwell time may be extended to 30 minutes, or longer. Allow the penetrant to drain from the part surface back into the penetrant tank to conserve material.
3. **Removal:** Use the appropriate washing method to remove the excess penetrant from the surface.
4. **Developing:** After agitating the D-106 suspension, evenly spray a light slightly wet coating of developer onto the dry surface of a part. An overly wet application lacks full developing action. Two or three light applications work better than a single heavy application. Too heavy an application may conceal indications. If D-106 is to be applied with a paint spray gun, the spray gun should have a vaporizing tip, the spray tank should be pressurized to 15-30 pounds of pressure and have a stirrer to keep the powder in suspension.
5. **Inspection:** Inspect parts under appropriate light intensity.

### STORAGE/SHELF LIFE

Keep away from moisture and sunlight. Temperature limit: 400F to 1250F (0-500C). Keep the container closed when not in use. Shelf life from invoice date: Bulk Container – 36 months / Aerosol Cans – 36 months

### HEALTH & SAFETY

D-106 is highly flammable, use in a well-ventilated area. Avoid prolonged or repeated inhalation of vapor and contact with skin. Do not take internally. Consult the MSDS for more safety and health information.

**WARRANTY** – All statements, information and data presented herein are believed to be accurate and reliable but are not to be taken as a guarantee, expressed or implied, for which seller assumes legal responsibility and they are offered solely for your consideration, investigation and verification. Statements or suggestions concerning possible use of this product are made without representation or warranty that any such use is free of patent infringement and are not recommendations to infringe on any patent.

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