**Penetrant Testing Process Guide**

### Method A: Water Wash Fluorescent

1. Preclean
   - Cleaner options: SKC-S*
2. Apply Penetrant
3. Dwell
   - 10–30 minutes (in some cases longer)
4. Rinse
   - 50–100°F / 10–38°C at <40 psi / 2.75 bar
5. Apply Aqueous Developer
6. Dwell
   - 10 min–4 hr maximum
7. Inspect

### Method B/D: Post Emulsifiable Fluorescent

1. Preclean
2. Apply Penetrant
3. Dwell
   - 10–60 minutes
4a. Rinse
   - 50–100°F / 10–38°C at <40 psi / 2.75 bar
4b. Apply Emulsifier
5. Rinse
6. Apply Developer
7. Dry
   - 160°F / 71°C maximum
8. Inspect

### Method C: Solvent Removable, Fluorescent, and Nonfluorescent

1. Preclean
   - Cleaner options: Daraclean
2. Apply Penetrant
   - Penetrant options: ZL-27A*, ZL-37*, ZL-60D*, SKL-SP2*, or SKL-WP2*
3. Dwell
   - 10–30 minutes
4. Remove Excess Penetrant
   - Spray SKC-S* cleaner onto a clean, dry lint-free cloth. DO NOT apply cleaner directly onto the part or test area.
5. Apply Aqueous Developer
6. Dwell
   - 10 min–2 hr maximum
7. Inspect

### Five Tips for Penetrant Testing

1. Check required specifications before beginning penetrant inspection.
2. Certifications, SDS, PDS, and instructions are available at www.magnaflux.com
3. Verify that parts to be penetrant tested are clean and dry before applying penetrant.
4. Magnaflux offers PeneCert Testing Service for in-process penetrant materials. Contact Magnaflux Customer Service for details at support@magnaflux.com
5. Magnaflux penetrant products are available in kits for convenience and portability.

* Available in Aerosol Cans