

# Crack Testing Spray

# 70-98

### DESCRIPTION

Verification system in 3 steps to find cracks and porosities. Military approbation MIL L-25135e  
DIN EN ISO 3452-2

### UTILISATIONS

#### Verification procedure

- 1) The surface to be verified needs to be cleaned with the 70-9801 Cleaner (Blue) or with the 70-15 (Rapid Cleaner) if the surface is heavily soiled or greasy
- 2) Vaporize the 70-9802 Contrast (Red) over the surface to be tested let the product stand (See time table below to know how long)
- 3) Clean the surface, spray the 70-9801 again over the treated surface and then wipe with a dry clean cloth
- 4) Vaporize the 70-9803 Developer (White) on the now dry and clean surface. Now all cracks and porosities shall appear with a red colour

### EXPOSURE TABLE: Surface test 15 to 30°C.

Fer et alliages d'acier : endurance, fissures de chaleur et fissures thermales.

Steel alloyed and Non-Alloyed	Ruptures and breaks related to heat or grinding	10 – 15 minutes
Cast	Separations	3 – 20 minutes
	Porosities and cracks	3 – 5 minutes
Forged pieces	Cracks	10 – 20 minutes
Laminated pieces	Coatings	10 – 20 minutes
Aluminium pieces	Cracks and porosities	10 – 20 minutes
Free cutting alloys Cutting tools	Cracks and mixing flaws	– 5 minutes

For temperatures of 5°C to 15°C it is necessary to allow more exposure times. Generally this process can be used at temperatures going from -10°C to 100°C. For use at temperatures lower than 5°C or higher than 30°C ask for special directions.

### Leak test on containers and tanks:

Apply the 70-9802 Contrast (red) to one side of the wall and the 70-9803 Developer (white) on the other side. For very thick walls apply the Contrast and Developer 2-3 times as necessary

After 10-30 minutes red marks will appear above the white Developer revealing

Flaws, cracks and porosities

All products in the crack testing are considered non-dangerous goods.

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