



## DR-64 Cleaner-Remover

### Technical Data Sheet

**Description:** DR-64 Cleaner-Remover is used in the penetrant process to remove excess penetrant from part surfaces. It is a manual wipe on and wipe off material and is recommended for small areas. DR-64 may also be used for generally cleaning oily, dirty surfaces. DR-64 is especially suitable for cleaning prior to the application of inspection penetrants. Complies with low sulfur and low halogen requirements.

#### Chemical Properties

Color:	Colorless Liquid
Volatility:	100%
Odor:	Petroleum Odor
Boiling Point:	132°F (56°C)
Specific Gravity:	0.79

#### Companion Products

BY LUX, DP-40, DP-50, DP-51, DP-52, DP-54, FP-22B, HM-1, HM-2D, HM-220, HM-3A, HM-406, HM-412, HM-430, HM-440, HM-602, HM-604, HM-607, HM-704, HM-707, RC-29, RC-50, RC-65, RC-77, RC-88

#### Packaging

One Gallon Cans	55 Gallon Drums
Five Gallon Cans	

#### Storage/Shelf Life

Keep away from moisture and sunlight.  
Temperature limit: 40°F to 125°F (0-50°C)  
Keep the container closed when not in use.  
Shelf life from invoice date: Bulk Container – 60 months

#### Specifications

SAE AMS 2644 & QPL	
MIL-I-25135 Revisions C, D & E	ASME Code NDT, Sec V



## Special Features

1. Can be used as a pre-cleaner for penetrant inspection evaporates completely and rapidly.
2. VOC exempt
3. Miscible in water
4. Non-chlorinated material

## Instructions

**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:** Remove as much excess penetrant as possible using clean, dry rag or toweling. Remove remaining penetrant film by wiping with a rag or toweling that has been slightly moistened with **DR-64**. Use a minimal of **DR-64**; avoid flushing penetrant from flaws. Do not spray **DR-64** directly on the part surface when removing excess penetrant. Rough surfaces require more generous applications of **DR-64**.
4. **Drying:** Allow the surface to dry completely before applying developer.
5. **Developing:** Apply the developer by cloud, dusting, spray or dip using the appropriate developer. Flaw marks are visible under appropriate lighting almost immediately, but allow sufficient developing time to enhance the flaw visibility.
6. **Inspection:** Inspect parts under appropriate light.

## Health & Safety

**DR-64** is a flammable liquid. Use with adequate ventilation and away from sparks, fire or open flames. Avoid prolonged or repeated contact with skin. Do not take internally. Consult the SDS for more safety and health information.