

# 14A Redi-Bath™

## Water-Based Fluorescent Magnetic Particle Concentrate

14A Redi-Bath is a highly sensitive water-based magnetic particle suspension for locating very fine discontinuities in critical parts. A concentrated mixture of 14A with water conditioning agents, defoamers, and corrosion inhibitors. 14A Redi-Bath is intended for use in wet method magnetic particle inspection.

14A Redi-Bath is diluted with water for use then sprayed onto a magnetized part prior to inspection. It is used to detect cracks and seams, as well as inclusions, laps, tears and flakes. 14A Redi-bath can detect flaws that are open to the surface of the part, or slightly sub-surface. Parts tested can be forgings, welds, castings, and stamped or machined ferromagnetic materials, such as steel and other alloys of iron, nickel, and cobalt. Using 14A Redi-Bath may eliminate the need for an additional corrosion inhibitor step. The fluorescent particles in 14A collect where the magnetic field is interrupted, and glow under ultraviolet (UV) lighting.

### FEATURES

- Clear, bright indications under ultra-violet light
- High sensitivity
- Easy post-testing clean up
- Excellent fluorescent contrast for quick identification
- Excellent particle mobility
- Good dispersion stability
- Great concentration consistency
- Superior surface wetting
- Non-foaming
- Even surface coverage and higher probability of detection
- Good corrosion protection

### SPECIFICATION COMPLIANCE

- AMS 3044
- ASTM E709
- ASTM E1444
- ASME
- MIL-STD-2132
- MIL-STD-271
- NAVSEA 250-1500-1
- NAVSEA T9074-AS-GIB-010/271

### USE RECOMMENDATIONS

<b>NDT Method</b>	Magnetic Particle Testing, Fluorescent, Wet Method
<b>Suspension Vehicle</b>	Water
<b>Required Equipment</b>	Magnetizing device, UV light source
<b>Temperature Range<sup>†</sup></b>	32 to 120°F / 0 to 49°C
<b>Settling Volume</b>	0.10 – 0.40 mL

<sup>†</sup> Particle integrity and mobility may decline beyond these temperature limits.

## APPLICATIONS

**Defect location:** Surface and slightly subsurface

**Ideal for:**

- Very fine to fine discontinuities
- Machined parts
- Smooth surface finish
- Critical applications
- High volume testing
- After secondary processing
- Mixing with hard-water

**Defect examples:**

- Inclusions
- Seams
- Shrink cracks
- Tears
- Laps
- Flakes
- Welding defects
- Grinding cracks
- Quenching cracks
- Fatigue cracks

## PRODUCT PROPERTIES

<b>Appearance</b>	Liquid and fine particle solution
<b>Color in Visible Light</b>	Brown
<b>Color in UV Light</b>	Fluorescent yellow-green
<b>Odor</b>	Subtle amine
<b>Mean Particle Size*</b>	6 microns
<b>SAE Sensitivity**</b>	8 – 9

\* As determined by industry-typical method for measuring particle size

\*\* Representative of the number of indications on a tool steel ring as defined in ASTM E1444.

## PREPARATION INSTRUCTIONS

Dilute with water for use. Shake the bottle well to suspend particles; the concentrate must be uniformly mixed before the bath is prepared. Fill tank or container with water. Measure out the appropriate amount of 14A Redi-Bath and add to water. Recommended dilution is 80 mL of 14A Redi-Bath per 1 gal of water. Refer to graduation marks on side to measure out 14A Redi-Bath. Mix for 15 minutes or until the particles are completely dispersed. Check particle concentration before use. Do not mix 14A Redi-Bath with oil.

<b>Water</b>	<b>14A Redi-Bath</b>
1 gallon	80 mL
1 liter	21 mL

## REMOVAL

All components, parts, or inspection areas must be properly demagnetized before cleaning to ensure easy particle removal. Cleaned parts may be treated with a temporary film protective coating if longer corrosion protection is required.

## STORAGE

Store in a well-ventilated area away from magnetizing equipment and heat sources. Protect from sunlight. Product age, exposure to elevated temperatures, and/or exposure to a strong magnetic field may adversely affect particle redistribution. Refer to Safety Data Sheet for additional storage instructions.

## PACKAGING

27 fl oz / 798 mL bottle (case of 6) 01-9130-41  
1 gal / 3.78 L jug (case of 4) 01-9130-35

## HEALTH AND SAFETY

Review all relevant health and safety information before using this product. For complete health and safety information, refer to the product Safety Data Sheet, which is available at [www.magnaflux.com](http://www.magnaflux.com).

## INSTRUCTIONS FOR USE

Use 14A Redi-Bath with appropriate magnetization procedure and equipment. For best results, all components, parts, or areas to be tested should be clean and dry prior to testing to provide an optimal test surface and reduce particle suspension contamination. Particle suspension must be properly mixed and continuously agitated when in use to ensure uniformity and concentration.

The suspension can be applied by gently spraying or flooding the area to be tested using the continuous or residual application method. Inspect under ultra-violet black light. Check particle concentration before use.

## Maintenance Recommendations

Magnetic particle suspensions need to be properly maintained to provide consistent results. Suspension concentration and contamination should be monitored at least once a day, or according to applicable specifications. Contaminated suspensions, or those in use for an extended length of time, should be replaced. Properly cleaning all components, parts, or inspection areas before testing helps to significantly reduce particle suspension contamination.

Particle concentration should be determined after initial bath preparation and at least once a day, or according to applicable specifications, to maintain the proper level of particles in the suspension. The most widely used method of control is by settling volume measurement in a graduated ASTM pear-shaped centrifuge tube. For testing 14A Redi-Bath, Magnaflux centrifuge tube 8493 is recommended: 100 ml capacity, stem graduated from 0 to 1 mL in 0.05 mL increments.