

**ORION**

THE ORIENTAL CHEMICAL WORKS PVT LTD

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AN ISO 9001:2015 COMPANY

TECHNICAL INFORMATION

ORION – 60BA

(BLACK MAGNETIC PARTICLE IN AEROSOL CAN)

ORION – 60BA is a prepared combination of visible black magnetic particle and a specially formulated odorless carrier solvent, packed in an aerosol dispenser. ORION – 60BA is designed to be used in white light inspection for revealing defects on ferromagnetic components.

PROPERTIES:

Particle color	:	Black under visible/white light at 100 fc (1000 Lux)
Particle size	:	Average particle size is less than 20 micron.
Sensitivity	:	ORION-60BA shows a minimum of 5 lines on an AISI - 01 Ketos Tool Steel Ring as defined in MIL-STD-1949.
Concentration	:	9.5 gm of black magnetic particle per liter of fluid.
Specification	:	Particles and mixture conforms to MIL-STD-1949, M&C/NDT/8/91, IS-6410, BS-4069 & AMS 3041.
Characteristics	:	Oil based, low odor, sulphur and chlorine free. CFC free Propellant

DIRECTION OF USE:

1. Prior to application, clean the surface to be examined thoroughly with a suitable cleaner, such as ORION 115 PR.
2. For best results use when the can is at ambient temperature.
3. Apply a thin uniform coating of ORION WCP-61 (white contrast paint) on the job surface from a distance of approximately 8 to 10 inches and allow it to dry up for two to five minutes.
4. Magnetize the job either by Electro-Magnetic Contour Probe (OCW/CP-300) or through Prod Type Magnetic Crack Detector (OCW/EMCD-1000)
5. Shake ORION 60 BA vigorously for twenty seconds and occasionally during use.
6. Point spray button towards inspection surface holding the can 8 to 10 inches from surface.
7. Spray solution on the magnetized surface until the surface is thoroughly covered with the solution. For re-confirmation of test, repeat steps mentioned under SI No. 4. & 5 above.
8. Examine the surface under visible / white light, not less than 100 fc for indications formed around the leakage fields.
9. If clogging of the valve occurs, remove and clean spray button with ORION 115 PR. Gently replace spray button with a twisting motion, holding top of the can and spray button opening pointed away from you.
10. Discard empty aerosol cans in trash bin. Do not puncture pressurized or empty aerosol cans.

APPLICATIONS:

Suitable for quick convenient inspection of Pipe Lines, Fabricated Structures, Heavy Duty Plated Fabrication, Structural Columns and In-situ Automobile and Locomotive parts.

PACKING:

ORION – 60BA is available in 400 ml aerosol containers with CFC free propellant.

SHELF LIFE:

24 months in sealed containers subject to STORING IN COOL & DRY PLACE.

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