



## KO-19 Hi-Temp Remover

### Technical Data Sheet

Description: **KO-19** hi-temp remover used to remove excess penetrant from the surface of a part at elevated temperatures; up to 350°F (176.7°C). **KO-19** is the remover step of a three part system used to remove excess penetrant from part surfaces (**KO-17** hi-temp penetrant and **D-350** hi-temp developer) are the other materials of the hi-temp system. **KO-19** complies with low sulfur and low halogen requirements.

#### Chemical Properties

Color:	White Form as spray	Viscosity:	31.4 cSt @ 100°F
Flash Point:	Clear Liquid as bulk	Specific Gravity:	0.98
(100°C)	None	Boiling Point:	212°F

#### Companion Products

KO-17 Hi-Temp Penetrant

D-350 Hi-Temp Developer

#### Packaging

One Gallon Cans                      Five Gallon Cans  
16oz. Aerosol Cans (9 cans per case)

#### 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 – 36 months / Aerosol Can – 24 months

#### Specifications

SAE AMS 2644 & QPL

MIL-I-25135 Revisions E    ASME Code NDT, Sec V

#### Special Features

1. **KO-19** can be used to remove excess surface penetrant at elevated temperatures.
2. **KO-19** meets the ASME code qualification procedure compliance.
3. **KO-19** meets the requirements for low sulfur and halogen.
4. **KO-19** is a non-flammable remover.



## 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 hi-temp **KO-19** penetrant by spray or brush to a limited area. The area to which the penetrant is to be applied should not be too large, so processing can be completed within penetrant and developer dwell time restraints. The size of the area will vary with inspection temperatures, part geometry, and operator experience.

2. **Dwell:** The penetrant must be allowed to dwell on the part surface to promote the penetrant time to enter any surface flaws. At higher temperatures, penetration occurs more quickly.

225° – 350° F (107.2°C – 176.7°C)	30 seconds
175° – 225° F (79.4°C – 107.2°C)	1-2 minutes
125° – 175° F (51.7°C – 79.4°C)	2-3 minutes
75° – 125° F (23.9°C – 51.7°C)	3-10 minutes
50° – 75° F (10°C – 23.9°C)	10-30 minutes

Allowances must be made for contamination levels and flaw sizes.

3. **Removal:** Wipe the surface with paper or soft clean cloth towels to remove as much **KO-19** as possible from the surface part. Spray **KO-19** remover directly onto the surface of the part in a thin coat and immediately wipe from the part surface. The part is then wiped with a water saturated towel or cloth to remove the last traces of penetrant. Finally a dry wipe is used to remove any water from the part.

4. **Drying:** Use paper or cloth toweling to dry the part's surface thoroughly. Special drying time before applying developer to heated parts should not be required.

5. **Developing:** **D-350** developer should be sprayed on the part surface from a distance of 6-8 inches immediately after the excess penetrant has been removed and the part has dried. Apply a thin even coat, two or three thin coats are preferred to a single, heavy coat.

6. **Inspection:** Observe the surface for defect indication formation while the developer is applied. Final surface examination should begin within a minute or two after developer application. Surface examination should be completed as quickly as practical, and within ten or fifteen minutes.

## Health & Safety

**KO-19** hi-temp penetrant should be used with adequate ventilation and away from sparks, flame, since it is applied to heated surfaces. Wear protective clothing and equipment. Avoid prolonged or repeated contact with skin. Do not take internally. Consult the MSDS for more safety and health information.