



Technical Bulletin 184
Mi-Glow® 134 magpac™

Mi-Glow® 106 black particles premixed with powdered Wetting Agent 34 for use in water media, packaged in 110 gram dissolvable PVA bags. Higher particle concentration provides heavier indication buildup for easy detection. It is designed to be used with visible light for finding discontinuities in finished products.

Properties

Particle Color: Black

Specific Gravity (powder): 0.8 @20C

Particle Size: Not less than 98% passage through US Standard No. 325 (45 µm) sieve as defined in AMS 3042. The typical range of particle sizes is from 0.5 to 4.0 µm, with an average particle size of 1.5 µm.

Sensitivity: Mi-Glow® 134 magpac™ shows a minimum of 6 lines on a tool steel ring (as defined in SAE AS5282), set on a 1-inch diameter copper bar, magnetized with 2500 A of direct current.

Particle Certification: Particles meet or exceed all relevant industry specifications, including but not limited to ASTM E 1444, AMS 3042, MIL-STD-271, NAVSEA 250-1500-1, NTR-1E. Certification is included with each shipment.

Temperature Limits: 32-120°F (0-49°C)

Shelf Life: Four (4) years, when closed containers are stored in a clean, dry environment away from excessive heat and cold. A Certificate of Shelf Life is available upon request.

Directions for Use

Preparation: The change-over from a solvent system to a Mi-Glow® 134 magpac™ system requires a thorough cleaning of the tank and piping. This can be accomplished in most cases by flushing the system twice, using about 1/2 gallon of Cleaner 500 and 10-15 gallons of water. Flushing should be followed by a water rinse.

Mi-Glow® 134 magpac™ should be used at a concentration of one pac per 5 liters (1.32 gallons) of water. For best results, add a bag to a circulating bath and allow it to dissolve. If more than one bag is needed, add one bag at a time to the circulating bath.

Lighting: A minimum of 100 foot candles (1000 lux) of visible light at the part surface per ASTM E 709 and ASTM E 1444 is recommended.

Settling Test: The settling test, to check particle concentration and contamination, shall be performed upon startup, at each shift thereafter and whenever the bath is changed or adjusted.

Checking Bath Concentration - The settling test is essential to check the bath concentration and is accomplished by gravity settling in a graduated pear-shaped centrifuge tube as specified in Guide E709.

1. Run the pump for 30-60 minutes, to agitate the suspension thoroughly and to assure particle distribution.
2. Fill 100 ml sample from the delivery hose into the centrifuge tube.
3. Demagnetize the sample and stand, together.
4. Allow particles to settle for a minimum of 30 minutes or until completely settled.
5. The recommended volume is between 1.2 and 2.4 ml.
6. Adjust bath, either by adding particles or vehicle, if necessary.

Checking Bath Contamination - To determine bath contamination, use the same sample that was used for the concentration settling test, and examine the liquid above the settled particles. The liquid should be clear. If the liquid is noticeably grey or black, the bath must be changed. Next, examine the graduated portion of the tube where the particles have settled, with a visible light for striations or bands of contamination that will be different in color and appearance than the settled particles. These striations or bands represent solid contamination, and if they exceed 30% of the settled particles, the bath should be changed.

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