1. **Pre-Cleaning**

   - Red/White with daylight
   - Fluorescent with UV light

2. **Penetrant**

   - **MR® 67 PS, 68 NF, 68 C, 311-R**
     - Water washable and/or solvent removable penetrant
     - Penetration time between 5 and 60 minutes
     - Application: spraying, brushing, flooding, dipping.

   - **MR® 67 F, 671 F, 672 F**
     - Water washable penetrant
     - Penetration time between 5 and 60 minutes
     - Application: spraying, brushing, flooding, dipping.

3. **Excess penetrant removal**

   - **using MR® 67 PS:**
     - Remove with water
     - Water pressure ≤ 2 bar,
     - Temperature ≤ 50 °C

   - **using MR® 68 NF, 68 C, 311-R:**
     - Remove with water and/or solvents
     - (e.g. MR® 79, 85, 88)
     - Water pressure ≤ 2 bar,
     - Temperature ≤ 50 °C

   - **using MR® 67 F, 671 F, 672 F:**
     - Remove with water
     - Water pressure ≤ 2 bar,
     - Temperature ≤ 50 °C

4. **Developing**

   - **MR® 70, 703 W**
     - Wet developer solvent based (MR® 70)
     - or wet developer water based (MR® 703 W)

   - **MR® 70, 81 T, 703 W**
     - Dry developer powder (MR® 81 T)
     - or wet developer solvent based (MR® 70)
     - or wet developer water based (MR® 703 W)

5. **Inspection**

   - **Daylight**
     - Illumination on surface
     - Min. 500 lux

   - **UV light**
     - Illumination on surface
     - Min. 1.000 μW/cm²
     - Darkened room with max. 20 lux

**Recording, if necessary:** postcleaning and protection

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