

A QUICK WAY TO SIZE

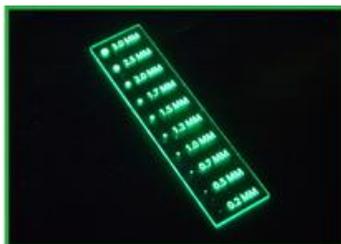
WHAT IS A FAULT?

A correct definition is: “an imperfection in a material or a piece which makes it unfit for the predicted use”. It is for this reason that all the specifications of penetrant testing and magnetic particle inspection include criteria quality acceptance which fix the acceptable limits concerning the dimension of indicators either individual or collective.

WHAT ROLE DO THE COMPARATORS PLAY?

The use of fluorescent transparent comparator supply by SREM provides assistance to the inspector to evaluate the importance of the indications, the discontinuity revealed by penetrant materials and fluorescent magnetic particle inspection. These comparators are transparent plastic strips, of dimensions (to 25 x 130 mm) with markings of known dimensions.

These markings are green in daylight and fluorescent under ultraviolet rays UV-A 365nm. The comparators are transparent, they can be used in the zones to be examined by putting them above the indications and by performing a direct verification “congruence” with the known dimension on the comparator. Furthermore, three of these comparators (Types 6, 7 and 8) are designed to help the inspector in the evaluation of the distance of the indications. (See diagram page 4)



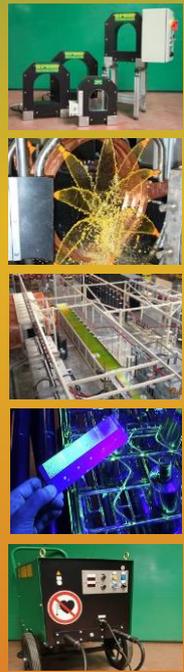
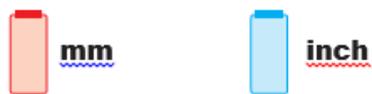
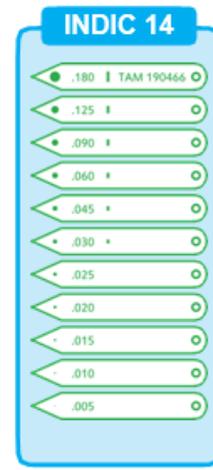
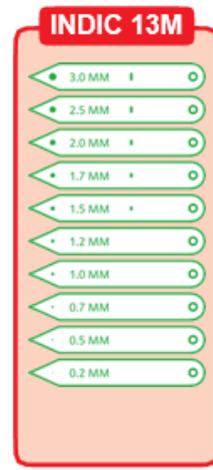
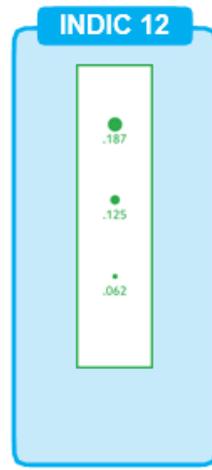
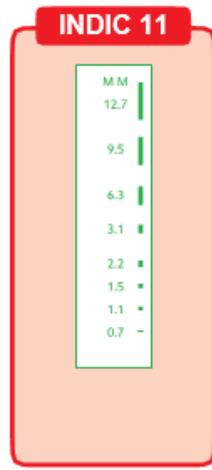
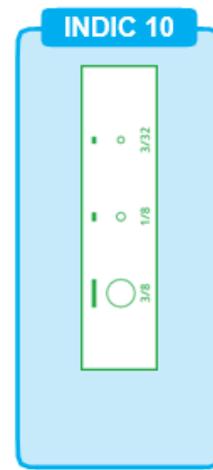
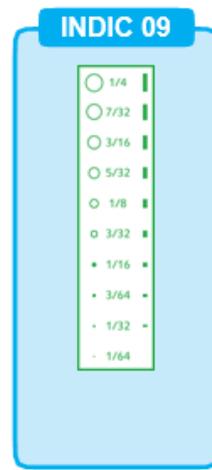
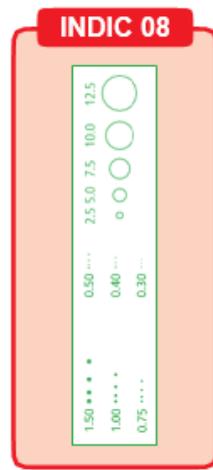
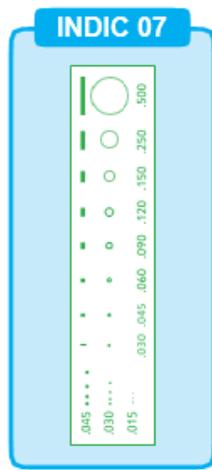
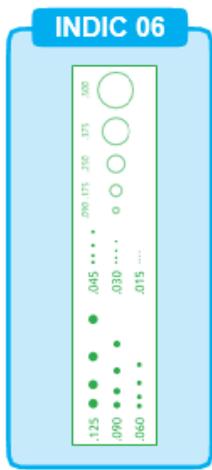
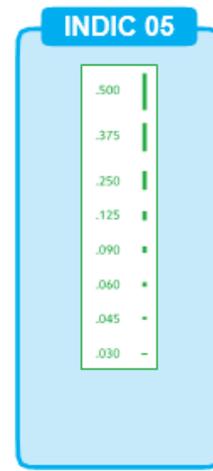
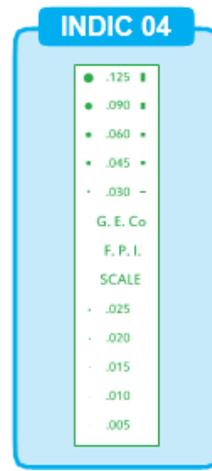
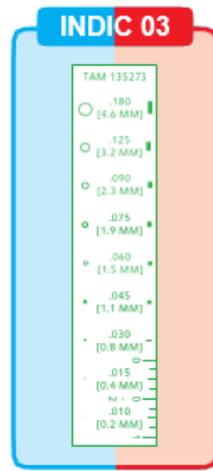
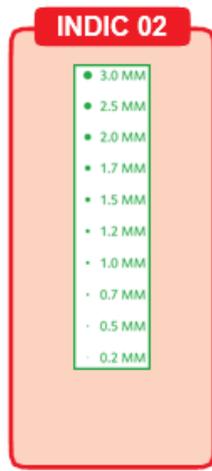
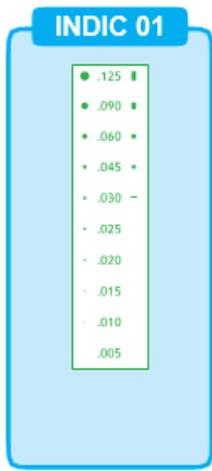
FLUOGRAPHE
CONTROMAG
SONDEX
FLUXO



SREM Technologies
ZI Ouest,

14 rue des Frères Chappe
72200 La Flèche
Tel: 02 43 48 15 10
Mail: info@srem.fr
Web: www.srem.fr

FLUORESCENT TRANSPARENT COMPARATOR



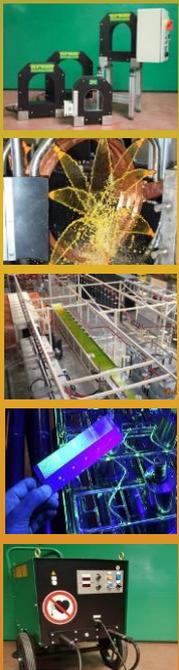
FLUOGAPHE
CONTROMAG
SONDEX
FLUXO



SREM Technologies
ZI Ouest,
14 rue des Frères Chappe
72200 La Flèche
Tel: 02 43 48 15 10
Mail: info@srem.fr
Web: www.srem.fr

DESCRIPTION OF FLUORESCENT TRANSPARENT COMPARATOR

- Type 1:** (Reference INDIC 01) in inch
- 10 indications in full circle from 0,005 to 0,125 inch.
- Type 2:** (Reference INDIC 02) in mm
- 10 indications in full circle from 0,2 to 3,00 mm.
- Type 3:** (Reference INDIC 03) also called « TAM 135273 » in inch and in mm
- 2 x 9 indications, circular et linear (line), from 0,01 to 0,18 inch \Leftrightarrow from 0,2 to 4,6 mm.
 - Conforms to Specification TAM 135273 from PRATT & WHITNEY AIRCRAFT.
- Type 4:** (Reference INDIC 04) in inch
- 10 indications in full circle from 0,005 to 0,125 inch.
 - For the 5 tallest sizes, from 0.030 to 0.125 inch, linear indications are also present.
 - Conforms to requirements from GENERAL ELECTRIC.
- Type 5:** (Reference INDIC 05) in inch
- 8 linear indications (line) from 0,03 to 0,500 inch.
 - Linear indications are specifically used in magnetic particle testing.
- Type 6:** (Reference INDIC 06) in inch
- 6 series of 4 identical full circles from 0.015 to 0.125 inch which allow both to size the fault and evaluate the inter-fault distance (see diagram page 4).
 - 1 series de 5 circles from 0.090 to 0.500 simply for sizing
- Type 7:** (Reference INDIC 07) in inch
- 3 series de 4 full circles from 0.015 to 0.045 inch which allow both to size the fault and evaluate the inter-fault distance (see diagram page 4).
 - 1 double series of circles and linear indications from 0.030 to 0.500 inch, simply for sizing.
 - Conforms to requirements from General Electric.
- Type 8:** (Reference INDIC 08) in mm
- 6 series de 4 full circles from 0.30 to 1.50 mm which allow both to size the fault and evaluate the inter-fault distance (See diagram page 4).
 - 1 Series de 5 circles from 2.5 to 12.5 mm simply for sizing
- Type 9 :** (Reference INDIC 09) in inch
- 2x 10 indications, circular and linear, from 1/64 to 1/4''
 - This comparator stand out for its fractional graduation.
- Type 10:** (Reference INDIC 10) in inch
- 2 x 3 indications circular and linear; 3/32, 1/8 and 3/8''
- Type 11:** (Reference INDIC 11) in mm
- 8 linear indications from 0,7 in 12,7 mm (values based on fractions of an inch).
- Type 12:** (Reference INDIC 12) in inch
- 3 indications of full circles from 0,062- 0,125 and 0,187''
- Type 13M:** (Reference INDIC 13M) in mm
- 10 flap mounted on pivot with indications in full circles from 0.2 to 3 mm. On the 5 tallest sizes (from 1.5 to 3 mm), the linear indication is also present.
- Type 13I:** (Reference INDIC 13I) in inch
- 10Flap mounted on pivot with indications in full circles from 0.005 to 0.125 inch. On the 5 tallest sizes (from 0.030 to 0.125 inch), the linear indication is also present.
- Type 14:** (Reference INDIC 14) also called « TAM 190466 » in inch
- 11 Flap mounted on pivot with indications in full circles from 0.005 to 0.180 inch. On the 5 tallest sizes (from 0.030 to 0.180 inch), the linear indications is also present
 - Conforms to requirements TAM 190466 from PRATT & WHITNEY AIRCRAFT.



**FLUOGRAPHE
CONTROMAG
SONDEX
FLUXO**



SREM Technologies
ZI Ouest,
14 rue des Frères Chappe
72200 La Flèche
Tel: 02 43 48 15 10
Mail: info@srem.fr
Web: www.srem.fr

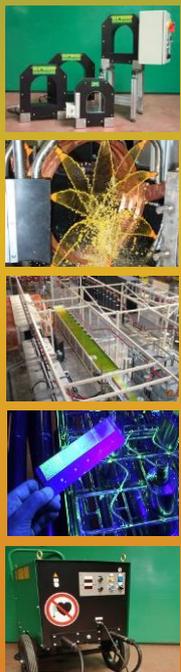
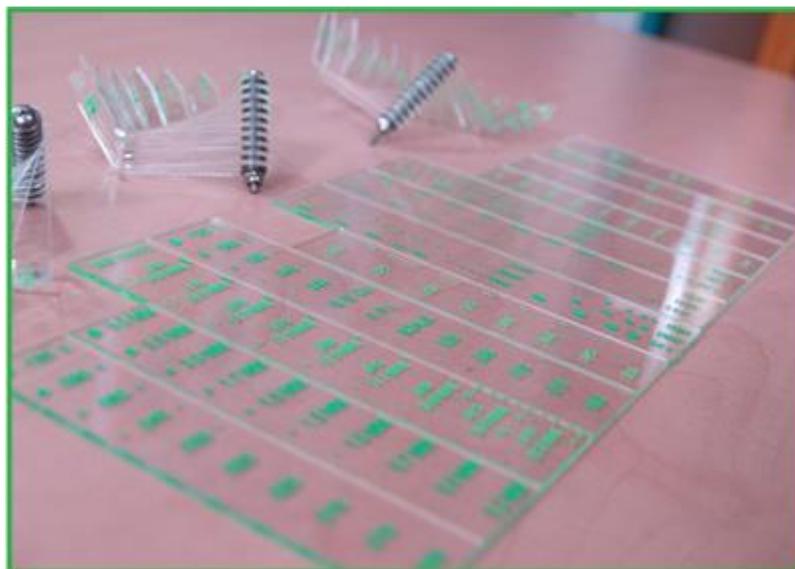
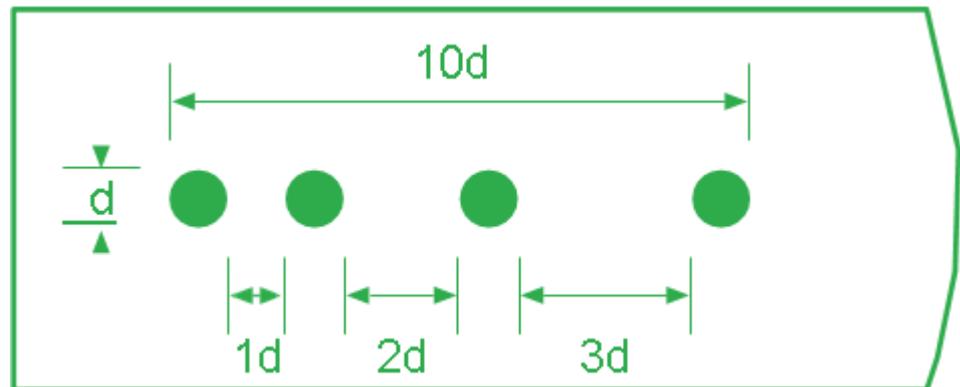
CONFORMITY :

Our fluorescent transparent comparators are adapt to the following dimensional tolerances:

Dimension of indicators in inch	Tolerances in inch	Dimension of indicators Conversion in mm	Tolerances Conversion in mm
from 0,060 to 0,500	$\pm 0,005$	from 1,524 to 12,7	$\pm 0,127$
0,045	$\pm 0,004$	1,147	$\pm 0,102$
0,030	$\pm 0,003$	0,762	$\pm 0,076$
from 0,010 to 0,025	$\pm 0,002$	from 0,254 to 0,635	$\pm 0,051$
0,005	de $\pm 0,002$ à 0,000	0,127	from $\pm 0,051$ to 0,000

DIAGRAM OF INDICATION DISTANCE COMPARATORS:

The spaces between the indications respecting the scale above for the comparators type 6, 7 and 8



FLUOGAPHE
CONTROMAG
SONDEX
FLUXO



SREM Technologies
ZI Ouest,
14 rue des Frères Chappe
72200 La Flèche
Tel: 02 43 48 15 10
Mail: info@srem.fr
Web: www.srem.fr