

Type 2, appendix B, EN ISO 9934-2



CONFORMANCE:

Reference test bloc C (Part Number SR33TEM-C0C) supplied by SREM TECHNOLOGIES is fully conform to the requirements of the appendix B, § B.2 of EN ISO 9934-2.

DESCRIPTION:

Reference test bloc C is made of two rectified low carbon steel fit together with an air gap (0.015 mm). On each side of these bars, there are two magnets which are assembled top to bottom so that each bar may have a North and a South poles to its ends.

The length of the indication spectrum, which can be read on the right side and the left side indicated the quality of the magnetic ink which is used.

FIELD OF USE:

Reference test block C is intended to be systematically used:

- To check the performance of crack detection of magnetic inks and powders as part of the Quality Control at the manufacturing stage (§7.1.1 of EN ISO 9934-2) and in use (§ 7.1.2 of EN ISO 9934-2)
- To Compare the efficiency of magnetic inks and powders against reference samples.
- To Compare the performance of magnetic powders and inks of various types of the same source or of different sources.

METHOD OF USE:

Reference test block C is processed according to the method described at Appendix A of EN ISO 9934-2.

Keep Reference test block C away from any magnetic field. Do not put it between the poles of any MT (Magnetic Testing) equipment in operation.

4-1-Preparation of the sample of the magnetic powder of ink:

Withdraw a sample of the new product. Refer to the relevant Technical Data Sheet.

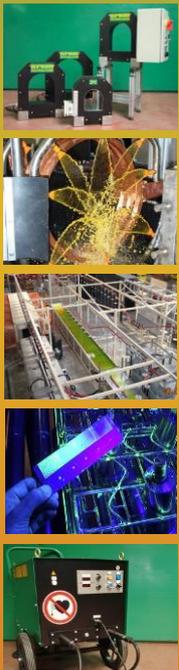
4.2- Cleaning of the Reference test block C:

It must be cleaned using an appropriate method in order to ensure that is free of any contamination such as: Fluorescent material, oxides, grease and any other pollution.

4.3- Application of the MT product:

The magnetic ink or powder is applied on the Reference test block C according the following parameters:

- Spraying time: From 3 to 5 seconds...
- Angle of inclination of the Reference test block C: $45^\circ + 10^\circ$ with horizontal.
- Spraying direction: $90^\circ + 10^\circ$ with the surface of the Reference test block C.



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

4.4- Viewing condition under ultraviolet (UV-A) light: according to EN ISO 3059.

- Ultraviolet (UV-A) illumination: $\geq 1\ 000\ \mu\text{W}/\text{cm}^2$ (and even: $\geq 1\ 500\ \mu\text{W}/\text{cm}^2$ according some specifications) at the level of the surface under inspection.
- White light illumination: ≤ 20 lux at the level of the surface under inspection.

4.5- Result:

The total length of the indications on the right and the left sides are to be recorded. The length of the two indications should be equal.

According to the materials which are used for the manufacture of the Reference test block C and the magnetic powder or ink which is under testing, the indications have not always the same length.

The indication is given from the external edges since this measurement is proportional to the quality of the product:

Short → Bad

Long → Good

Establish the minimum limit not to be reach (for instance by recording the indications given by a used product)

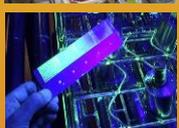
Stick on the Reference test block C a label on which the minimum value and the product name are written.

4.6 Final cleaning:

The Reference test block C must be cleaned according to an appropriate method to ensure that is free of magnetic ink or magnetic ink.

5- Checking report

SREM TECHNOLOGIES supplies the certificates of calibration or the checking reports with traceability to National Standards (COFRAC).



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