

INSPECTION STANDARD  
DIESEL COMPONENT WORKS, PATIALA

31PD5674

(A)

Number

31PD5674

MAGNETIC FLUORESCENT PARTICLE INSPECTION (WET)  
METHOD

Sheet

1 OF 1

Date

STANDARD - GROUP TYPE C

DESCRIPTION:

This specification covers inspection requirements, using the Magnetic Fluorescent Particle Inspection (Wet) Method, to the standard as shown below. This standard is identified as GROUP TYPE C.

PROCEDURE & RECOMMENDED CURRENTS:

For general instructions covering the Magnetic Fluorescent Particle Inspection (Wet) Method, see DLW Specification 31PD5671.

INSPECTION STANDARD (ACCEPTANCE LIMITS):

1. Quench cracks not permitted.
2. Grinding cracks not permitted.
3. Open indications not permitted.
4. Not-open indications less than one inch individually or 2 inches collectively permitted.
5. Threaded areas with not-open indications less than 1/2 inch individually or 1 1/2 inches collectively permitted.
6. Forging laps, pipe, laminations, shrinks, etc., not permitted.

REMARKS:

1. Any indications in excess of the above standard may be removed by grinding or buffing, within limits of serviceability, and reinspected for possible salvage.
2. Open indications (seams) are defined as any indication which is visible in white light after the magnetic powder has been removed.
3. Not-open indications (non-metallic inclusions) are defined as any indication which is not visible in white light after the magnetic powder has been removed.

Retyped on 10.2.83

SUPER VALIDATED CHD BY SDO 15/01/83 15/01/83	15/01/83 15/01/83	15/01/83 15/01/83	15/01/83 15/01/83	15/01/83 15/01/83
ALTERATIONS HR 21/81	COMPONENT WAS LOCOMOTIVE & PATIALA WAS VARANASI			
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