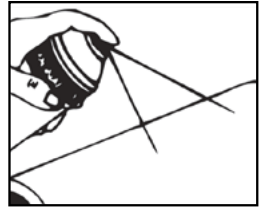


Magnetic Particle Inspection Instructions

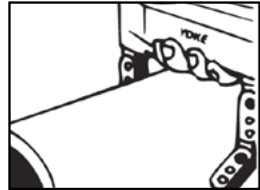
1. Cleaning

Pre-clean the part or area to be inspected by coating with cleaner, allowing it to stay on the part long enough to dissolve dirt or film. Then, wipe the part with a clean cloth and allow to dry completely before proceeding.



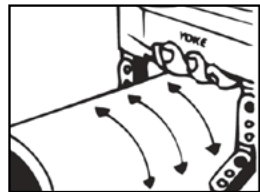
2. Position Magnetizing Device

Place the yoke or coil on the part being tested so that the device is located perpendicular to the direction of suspected defects.



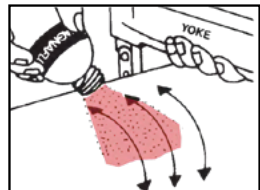
3. Energize Magnetizing Device

When the device is energized, a magnetic field is formed in the test part.



4. Apply Magnetic Particles

While the magnetic field is energized, apply the appropriate magnetic particles to the part being inspected. The particles can be in dry powder form or suspended in a liquid bath. Switch off the current.



5. Inspect for Defects

With non-fluorescent particles, indications will be visible in normal light, but remember you'll need to view the part under a UV black light to see fluorescent particle indications.



Visible Magnetic Particles



#1 Gray

White-Gray Fine, Dry Powder, Dry Method

Container Sizes:

10 lb pail PN 01-1716-69
45 lb pail PN 01-1716-87



#8A Red

Rust-Red Fine, Dry Powder, Dry Method

Container Sizes:

10 lb pail PN 01-1780-69
45 lb pail PN 01-1780-87



#2 Yellow

Pale Yellow Fine, Dry Powder, Dry Method

Container Sizes:

10 lb pail PN 01-1732-69
45 lb pail PN 01-1732-87



7HF

Oil-Based Visible Magnetic Particle Suspension, Wet Method

Container Size:

Aerosol Case (12) PN 01-1580-78



MV-740

Water-Based Visible Magnetic Particle Suspension

Container Size:

1 gal (case of 4) PN 01-9140-35

Fluorescent Magnetic Particles



14AM

Oil-Based Fluorescent Magnetic Particle Suspension

Container Sizes:

Aerosol Case (12) PN 01-0145-78
5 gal pail PN 01-0145-40

White Contrast Paint



WCP-2

Solvent-Based White Contrast Paint

Container Size:

Aerosol Case (12) PN 01-2250-78

Cleaner



SKC-S

Non-Halogenated Solvent Cleaner

Container Sizes:

Aerosol Case (12) PN 01-5750-78
1 gal Case (4) PN 01-5750-35
5 gal pail PN 01-5750-40
55 gal drum PN 01-5750-45