

Liquid Penetrant Inspection Procedure

1. Perform JSEA with all personnel involved.
2. Perform visual inspection of asset to be inspected.
3. Locate all padeyes, lifting eyes, load bearing areas and other areas of inspection.
4. Clean areas to be inspected using appropriate methods according to CETCO Procedure PT-001. If areas to be inspected are painted, paint must be removed by blasting or any other means that will not mask relevant indications. If areas to be inspected are heavily soiled, oily, or greasy, use an appropriate degreasing agent. If degreasing agent is used, ensure that all areas to be inspected are clean and dry before proceeding.
5. A visual inspection shall be performed again after the item has been properly cleaned. If item is not cleaned to the inspectors satisfaction Step 4 shall be repeated.
6. Apply penetrant to areas of asset to be inspected.
7. Allow 10 minutes dwell time for penetrant.
8. Using a clean, white, lint free rag, remove as much penetrant from the surface of the part as possible.
9. Lightly apply cleaner to a new clean, white, lint free rag. Remove as much of the remaining penetrant from the surface of the part as possible using a new clean, white, lint free rag each time. DO NOT SOAK RAG WITH CLEANER. DO NOT SPRAY CLEANER DIRECTLY ONTO THE PART AS THIS WILL REMOVE PENETRANT FROM RELEVANT INDICATIONS.
10. Allow 5 minutes for part to dry before applying developer.
11. Apply a thin coat of developer to areas to be inspected.
12. Allow 10 minutes for developer to dry and indications to fully form.
13. Evaluate and classify any indications as either relevant or non-relevant. Acceptance criteria shall be in accordance with approved standards.
14. All relevant and non-relevant indications shall be recorded to the CETCO MT/PT Report.
15. Report all findings to QA/QC Department.

Liquid Penetrant Inspection Manual

Mark Steyvers

A red circular graphic with a gradient, appearing as a partial circle or a stylized 'C' shape, located to the right of the author's name.

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Table of Contents Liquid Penetrant Inspection Manual

1. Understanding the eBook Liquid Penetrant Inspection Manual
 - The Rise of Digital Reading Liquid Penetrant Inspection Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Liquid Penetrant Inspection Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Liquid Penetrant Inspection Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Liquid Penetrant Inspection Manual
 - Personalized Recommendations
 - Liquid Penetrant Inspection Manual User Reviews and Ratings
 - Liquid Penetrant Inspection Manual and Bestseller Lists
5. Accessing Liquid Penetrant Inspection Manual Free and Paid eBooks
 - Liquid Penetrant Inspection Manual Public Domain eBooks
 - Liquid Penetrant Inspection Manual eBook Subscription Services
 - Liquid Penetrant Inspection Manual Budget-Friendly Options

6. Navigating Liquid Penetrant Inspection Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Liquid Penetrant Inspection Manual Compatibility with Devices
 - Liquid Penetrant Inspection Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Liquid Penetrant Inspection Manual
 - Highlighting and Note-Taking Liquid Penetrant Inspection Manual
 - Interactive Elements Liquid Penetrant Inspection Manual
8. Staying Engaged with Liquid Penetrant Inspection Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Liquid Penetrant Inspection Manual
9. Balancing eBooks and Physical Books Liquid Penetrant Inspection Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Liquid Penetrant Inspection Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Liquid Penetrant Inspection Manual
 - Setting Reading Goals Liquid Penetrant Inspection Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Liquid Penetrant Inspection Manual
 - Fact-Checking eBook Content of Liquid Penetrant Inspection Manual
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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