

# Liquid Penetrant Inspection Procedure

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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

**Roger Brown**



## **Liquid Penetrant Inspection Manual:**

*Manual on Liquid Penetrant Inspection* Canadian Government Specifications Board, 1977      *Manual on Liquid Penetrant Inspection* ,      *Manuals Combined: Nondestructive Testing (NDT) And Inspection (NDI)* , Over 8 300 pages Just a SAMPLE of the CONTENTS NONDESTRUCTIVE INSPECTION METHODS Published by the Departments of the Army Navy and Air Force on 1 March 2000 771 pages and June 2005 762 pages Metallic Materials and Elements for Aerospace Vehicle Structures 1 733 pages Designing and Developing Maintainable Products and Systems Revision A 719 pages Sampling Procedures and Tables for Inspection by Attributes 75 pages Nondestructive Testing Acceptance Criteria 88 pages Environmental Stress Screening Process for Electronic Equipment 49 pages Handbook for Reliability Test Methods Plans and Environments for Engineering Development Qualification and Production Revision A 411 pages Human Engineering Revision F 219 pages Sampling Procedures and Tables for Life and Reliability Testing Based on Exponential Distribution 77 pages Test Method Standard Electronic and Electrical Component Parts 191 pages Reliability Testing for Engineering Development Qualification and Production Revision D 47 pages Electroexplosive Subsystem Safety Requirements and Test Methods for Space Systems 150 pages 8 64 MB Reliability Prediction of Electronic Equipment Notice F 205 pages Reliability Program for Systems and Equipment Development and Production Revision B 88 pages Electronic Discharge Control Handbook for Protection of Electrical and Electronic Parts Assemblies and Equipment Excluding Electrically Initiated Explosive Devices Revision B 171 pages Electrical Grounding for Aircraft Safety 290 pages Fuze and Fuze Components Environmental and Performance Tests for Revision C 295 pages Requirements for the Control of Electromagnetic Interference Characteristics of Subsystems and Equipment Revision E 253 pages Maintainability Verification Demonstration Evaluation Revision A 64 pages Failure Rate Sampling Plans and Procedures Revision C 41 pages Maintainability Prediction 176 pages Definition of Terms for Reliability and Maintainability Revision C 18 pages Semiconductor Devices 730 pages Reliability Modeling and Prediction Revision B 85 pages Established Reliability and High Reliability Qualified Products List QPL Systems For Electrical Electronic and Fiber Optic Parts Specifications Revision F 17 pages Environmental Test Methods and Engineering Guidelines 416 pages Test Methods for Electrical Connectors Revision A 129 pages Environmental Engineering Considerations and Laboratory Tests Revision F 539 pages System Safety Program Requirements 117 pages Test Method Standard Microcircuits Revision E 705 pages Test Method Standard Microcircuits Revision F 708 pages Procedures for Performing a Failure Mode Effects and Criticality Analysis Revision A 54 pages      Introduction to Nondestructive Testing Paul E. Mix, 2005-06-10 This updated Second Edition covers current state of the art technology and instrumentation The Second Edition of this well respected publication provides updated coverage of basic nondestructive testing NDT principles for currently recognized NDT methods The book provides information to help students and NDT personnel qualify for Levels I II and III certification in the NDT methods of their choice It is organized in accordance with the American Society for Nondestructive Testing ASNT

Recommended Practice No SNT TC 1A 2001 Edition Following the author's logical organization and clear presentation readers learn both the basic principles and applications for the latest techniques as they apply to a wide range of disciplines that employ NDT including space shuttle engineering digital technology and process control systems All chapters have been updated and expanded to reflect the development of more advanced NDT instruments and systems with improved monitors sensors and software analysis for instant viewing and real time imaging Keeping pace with the latest developments and innovations in the field five new chapters have been added Vibration Analysis Laser Testing Methods Thermal Infrared Testing Holography and Shearography Overview of Recommended Practice No SNT TC 1A 2001 Each chapter covers recommended practice topics such as basic principles or theory of operation method advantages and disadvantages instrument description and use brief operating and calibrating procedures and typical examples of flaw detection and interpretation where applicable

**OSHA Technical Manual** United States. Occupational Safety and Health Administration. Office of Science and Technology Assessment, 1995 *Handbook of Polymer Testing* Roger Brown, 1999-01-21 The Handbook of Polymer Testing Physical Methods provides virtually currently used techniques for measuring and testing the physical properties of polymers A concise but detailed technical guide to the physical testing methods of synthetic polymers in plastics rubbers cellular materials textiles coated fabrics and composites the book analyzes

*Penetrant Testing: Principles, Techniques, and Applications - Interview Q&A with Experts* Chetan Singh, Penetrant Testing Principles Techniques and Applications Interview Q A with Experts is a comprehensive guide that provides a detailed overview of the principles techniques and applications of liquid penetrant inspection LPI or dye penetrant testing DPT for detecting surface breaking defects in materials In addition to covering the fundamental concepts of penetrant testing this book also features a series of exclusive interview Q A sessions with leading experts in the field The experts share their insights and experiences on a wide range of topics related to penetrant testing such as best practices emerging technologies and industry applications The NDT book is divided into several chapters that cover different aspects of penetrant testing including the penetrant testing process penetrant testing materials surface preparation and test conditions evaluation of indications applications of penetrant testing quality assurance and training and future developments and emerging technologies With its practical insights and detailed information NDT Penetrant Testing Principles Techniques and Applications Interview Q A with Experts is an indispensable resource for engineers technicians inspectors and anyone who is involved in non destructive testing NDT and quality control

*Heat Exchanger Design Handbook* Kuppan Thulukkanam, 2000-02-23 This comprehensive reference covers all the important aspects of heat exchangers HEs their design and modes of operation and practical large scale applications in process power petroleum transport air conditioning refrigeration cryogenics heat recovery energy and other industries Reflecting the author's extensive practical experience

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positioned to inspire NDE professionals to think broadly in terms of their role as continuous value add rather than discrete decision support This second edition contains many new chapters and half of all chapters were revised from the 1st edition based on the engagement of authors through global platforms such as the ICDNT Specialist International Group on NDE 4 0 and the International conference series on NDE 4 0      **Nondestructive Testing Standards a Review** Harold Berger,1977  
    Hearings United States. Congress. Senate. Committee on Aeronautical and Space Sciences,1970      **Hearings, Reports and Prints of the Senate Committee on Aeronautical and Space Sciences** United States. Congress. Senate. Committee on Aeronautical and Space Sciences,1970      **NASA EP.** United States. National Aeronautics and Space Administration,1970  
    *Space Program Benefits* United States. Congress. Senate. Aeronautical and Space Sciences,1970      *Space Program Benefits* United States. Congress. Senate. Committee on Aeronautical and Space Sciences,1970      **Index of Specifications and Standards** ,2005      Nuclear Science Abstracts ,1974      **Air Force Manual** United States. Department of the Air Force,1977

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