

-G

☐ CUSTOMER ISSUED
☐ GOVERNMENT SOURCE
☐ PLANT SAFETY PART
☐ CRITICAL PART

WD Detection Services, Inc.
 2001 Commerce Blvd.
 New York, NY 10014
 Tel: (212) 312-1111
 Fax: (212) 312-1112
 Email: info@wd-ds.com

MAGNETIC PARTICLE INSPECTION PAGE 1

NUMBER	W0071	REVISION	
NAME	WHEEL 15.5"X18"		
MATERIAL	STEEL	HEAT TREAT	
PROGRAM	NDE GIVEN		
CUSTOMER	ANDREWS INVENTOR CONTROLS INC.		
CONFIGURATION FORM OR SHAPE	CASTING		
METHOD OF MARKING	Tag		
IN PROCESS OR FINAL	Final		
PROCEDURE SPECIFICATION	ASTM E1444/ASTM 1444M-11	CLASS	
	PSD		
ACCEPTANCE CRITERIA	NO RELEVANT INDICATIONS	GRADE	CLASS
	PSD		
NOTE: UNLESS OTHERWISE SPECIFIED, USE THE EQUIPMENT, MATERIALS, AND PROCESSING PARAMETERS SPECIFIED IN ISO-9000 WHEN INSPECTING HARDWARE TO THE TECHNICAL SHEET			
SURFACE FINISH	Free To Paint		
PREPWORK (NSP, CLEANING)	Solvent Clean	Rust Prevention Oil	
	CRDC	Wet Continuous	

DEMAGNETIZATION: use A.C. coil, move parts slowly back a position one (1) foot in front of the coil, steadily, through to a point three (3) feet behind the coil, rotate parts of complex geometry. Repeat this procedure as necessary to remove residual magnetism. Maximum residual field shall not exceed 62 Gauss when measured with a calibrated field indicator.

SPECIAL INSTRUCTION

- 1) SHOT #1 CENTRALLY LOCATED CONDUCTOR, TURN, ROTATE 180 DEGREES THEN SHOOT AGAIN TO EFFECTIVELY COVER THE ENTIRE CIRCUMFERENCE. REPEAT THESE STEPS ON NINE ADDITIONAL HOLES.
- 2) SHOT #2 CENTRALLY LOCATED CONDUCTOR, ROTATE 180 DEGREES THEN SHOOT AGAIN TO EFFECTIVELY COVER THE ENTIRE CIRCUMFERENCE. REPEAT THESE STEPS ON NINE ADDITIONAL HOLES.
- 3) SHOT #3 CENTRALLY LOCATED CONDUCTOR, ROTATE 180 DEGREES THEN SHOOT AGAIN TO EFFECTIVELY COVER THE ENTIRE CIRCUMFERENCE.
- 4) SHOT #7 DEMAG.

WORK ORDER - TRAVELER #

John W. Miller

MAGNETIC FIELDS

PROPERTY TAXES (County, City, and School District)				PROPERTY TAXES	
COUNTY OF ALBERTA, CITY OF CALGARY, SCHOOL DISTRICT NO. 1				PROPERTY TAXES	
DATE: 11/11/2011 11:11 AM				ADDRESS:	
PROPERTY IDENTIFICATION		PROPERTY VALUE		PROPERTY TAXES	
1		100.0%	100.0%	100.0%	100.0%
2		1.000%	1.000%	1.000%	1.000%
3		1.000%	1.000%	1.000%	1.000%
4	114.5441				
5	1.000%				
6	1.000%				

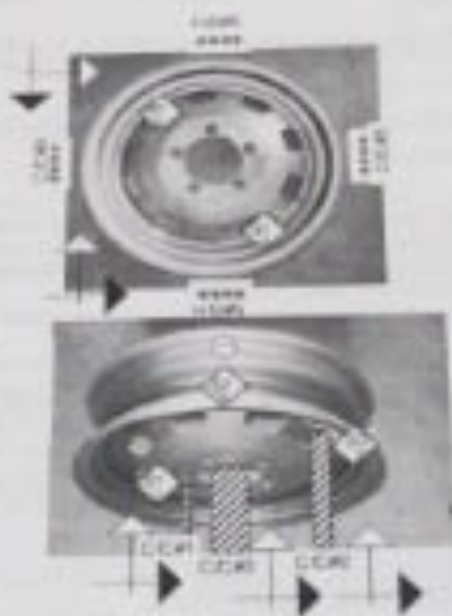
SYMBOLS:

— ☐ MISSING DATA (blank) ☐ CHERRY COMPLETION ☐ $\frac{1}{2}$ CHERRY COMPLETION

— ☐ MISSING DATA (filled) ☐ CHERRY TABLE REJECTION ☐ $\frac{1}{2}$ CHERRY TABLE REJECTION

— ☐ MISSING DATA (blank) ☐ CHERRY COMPLETION ☐ $\frac{1}{2}$ CHERRY COMPLETION

— ☐ MISSING DATA (filled) ☐ CHERRY TABLE REJECTION ☐ $\frac{1}{2}$ CHERRY TABLE REJECTION



Prepared By	Marvin Fuentes
Approved By	Marvin Fuentes

Acronyctodes

LEVEL 3	DATE 06/21/2012
LEVEL 3	DATE 06/21/2012

2025年1月1日















