Tool Steel / Ketos Test Ring

The Test Ring is intended to be a total system check for your DC output equipment. This test gauge with subsurface discontinuities is an excellent tool that provides a quick way to confirm overall performance of your DC output machine.

The Test Ring is meant to be a quick overall system performance indicator. This ring is to be processed by the continuous method using a 1-inch diameter central conductor. When properly processed, indications of artificial subsurface discontinuities will be produced on the circumferential surface of the ring. The number of indications produced is the function of magnetizing current amperage and the characteristics of the indicating medium. The results should conform to the minimum standards in the chart on page 2.

Instruction:

Place the ring on a non-ferromagnetic central conductor (1"-1 1/4" / 2.54cm - 3.175cm). Clamp the central conductor between the head and tailstocks. With the amperage set to predetermined levels used for every test, magnetize the ring circularly with a contact shot using the continuous method of particle application. A consistent number of indications per level reveals the system has good dept of penetration and also system is working properly. Refer to tables for number of indications to be visible. It is recommended to benchmark the performance of each specific combination of ring and magnetizing equipment used in order to detect any decrease in performance.

Specifications Compliance:

- ASTM E709
- ASTM E1444
- MIL STD 1949A
- ASME BPVC SECTION V

Tool Steel Test Ring:

PARTICLES USED	AMPERAGE FWDC or HWDC	MINIMUM REQUIRED NO. OF HOLES INDICATED
Fluorescent Oxide (wet)	500	3
	1000	5
	1500	6
	2500	7
	3500	9
Visible Oxide (wet)	500	3
	1000	4
	1500	5
	2500	6
	3500	8
Dry Powder	500	4
	1000	6
	1500	7
	2500	8
	3500	9

Ketos Test Ring:

PARTICLES USED	AMPERAGE FWDC or HWDC	MINIMUM REQUIRED NO. OF HOLES INDICATED
Fluorescent Oxide (wet)	1400	3
	2500	5
	3400	6
Visible Oxide (wet)	1400	3
	2500	5
	3400	6
Dry Powder	1400	4
	2500	6
	3400	7

Note:

Do not use with AC magnetic field.

The Test Ring is an individual field leakage plot similar to the one shown below. The ring has been serialized to give you traceability in order to meet compliance standards.

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