

MANUAL EDDY CURRENT

1. Introduction

Manual eddy current inspection can be applied to all areas listed, including the flange to tyre seat area when semi-automated eddy current techniques are not available, providing the hubs are fully disassembled apart from removing the bearing outer races. A wide range of test sets are available falling into two main categories; high frequency sets operating with a signal frequency above 1 MHz, low frequency sets operating below 1 MHz. In addition to the following procedures reference should also be made to test set manufacturers instructions when inspecting wheel hubs.

2. Inspection Probes

A. Various inspection probes are utilised during manual eddy current inspection, the most common types are:

- (1) Non ferrous point probes, used in conjunction with fixed high frequency test sets. The standard forms of the probe are:
  - (a) 'P' type (pencil) - probe tip in line with probe axis.
  - (b) 'K' type (knife) - probe tip at 90° to probe axis.
- (2) Differential probes used in conjunction with low frequency test sets operating at approximately 30 KHz. These probes may take the following forms:
  - (a) 10 mm (0.39 in.) long with a 2 mm (0.08 in.) radiused tip, used to inspect tyre seat radii.
  - (b) 10 mm (0.39 in.) diameter flat probe, used to inspect tyre seat area.
  - (c) Probes moulded to the form of the flange rim to tyre seat area. These probes will contain separately wound cores which give an extended area of coverage.
- (3) Non ferrous point probes used with variable frequency test sets at around 200 KHz. These probes are held in probe guides contoured to fit into the scan area.

3. Calibration Samples

A. To allow setting up of a test set a calibration sample is required. This may be one of the following types.

- (1) Standard non ferrous test block containing a slot 0,5 mm (0.02 in.) deep 0,1 mm (0.004 in.) wide.

# Ndt Manual Boeing

**Jianjun Gao**



**Ndt Manual Boeing:**

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