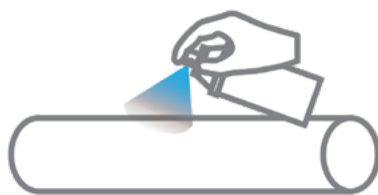
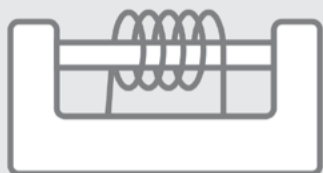


# MAGNAFLUX MAGNETIC PARTICLE INSPECTION PROCESS GUIDE



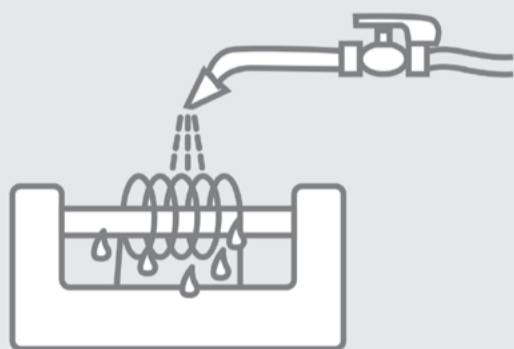
Preclean with Spotcheck SKC-S

## CURRENT/FIELD FLOW – FIXED BENCHES



D-2060  
Ferroflux  
MAG 40  
MAG 50  
Universal SW  
Universal WE

Mount the part to be tested and select current and/or field flow mode(s)



1. Start the flow of magnetic ink over the part
2. Switch on the current/field flow
3. Stop the flow of magnetic ink over the part
4. Switch off the current/field flow

## FIELD FLOW – PORTABLE YOKES AND COILS



Y1 Yoke  
Y6 Yoke  
Y7 Yoke  
Y8 Yoke



L10 Magnetising Coil  
Split Coils

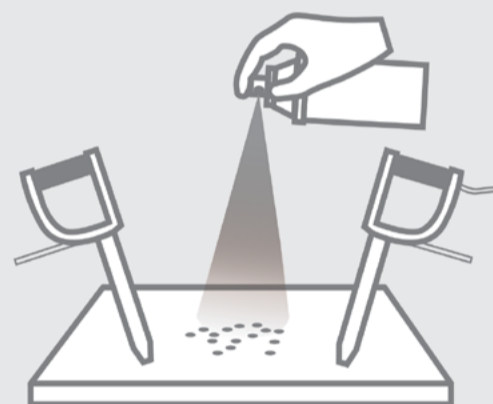


1. Switch on the magnetising field
2. Apply the magnetic powder/ink to the part
3. Switch off the magnetising field

## CURRENT FLOW – PORTABLE PRODS



Standard Prod Sets



1. Switch on the current
2. Apply the magnetic powder/ink to the part
3. Switch off the current

### FLUORESCENT MPI POWDERS/INKS

#### Powders

14A  
MG 410  
MG 601

#### Oil Vehicle

MG/MX Carrier II

#### Ready-to-Use Inks

14HF  
410HF

#### Water Bath Additives

WA-1  
WA-2

#### Concentrates

WB-12  
MF-655 WB

### VISIBLE MPI POWDERS/INKS

#### Dry Method MPI

1 Grey  
8A Red

#### Concentrate

WB-27

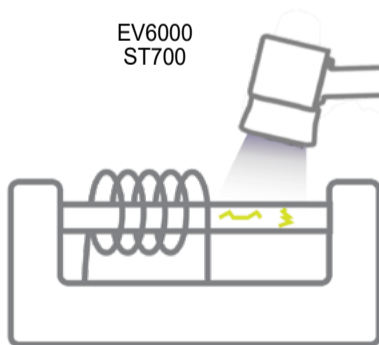
#### Ready-to-Use Ink

7HF

#### White Contrast Paint

WCP-2

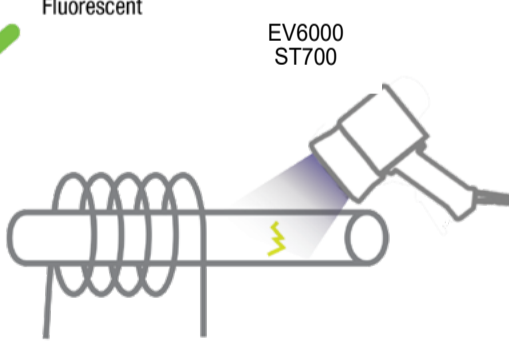
EV6000  
ST700



Fixed Benches

Inspect  
Fluorescent

EV6000  
ST700



Portable Coils



Inspect  
Visible



Portable Prods



Portable Yokes

### DEMAGNETISATION



1. Put part in coil
2. Turn on current
3. Draw part through demagnetising unit
4. Check for residual magnetism
5. Remove part from unit
6. Turn off current