

PERFORMANCE INDICATORS pi SERIES
M(pi): Performance indicators for Magnetic Particle Inspection
Ketos Ring

Qualitech Ketos ring is manufactured as per ASTM-E 1444 from round annealed stock of 01 tool steel. It has through drilled holes on circumferential periphery at specified distances. It is supplied with copper conductor (optional) of 31.7 mm diameter which can pass through the centre of Ketos ring.

Test Procedure:

1. Place the conductor through the centre of the Ketos ring. Place the ring at the centre of the conductor along its length.
2. Magnetize the ring circularly by passing current through the conductor.
3. Apply magnetic particles (wet or dry) to the surface of the ring while the current is flowing.
4. Examine the ring within one minute under visible light having intensity of 1000 lx for non fluorescent particles and black light having intensity of 1000 $\mu\text{W}/\text{cm}^2$ for fluorescent particles.

Observations:

Particles should show the number of holes as specified below:



Type of suspension	Amperage FWDC or HWDC	Minimum number of holes to be indicated
Fluorescent powder (wet)	1400	3
	2500	5
	3400	6
Visible powder (wet)	1400	3
	2500	5
	3400	6
Dry powder	1400	4
	2500	6
	3400	7