

MAGNETIC PARTICLE TESTING ACCESSORIES



MPI Accessories

"MAGNAFLUX® Magnetic Particle Testing Accessories have allowed us to streamline and simplify our NDT process, while simultaneously boosting inspection speed and reducing cost."

simplify



Magnaflux® Magnetic Particle Testing Accessories are designed to help improve the speed, detection capabilities, and cost effectiveness of your MPI system.

Simplifying Inspection

CABLES, CONNECTORS & REMOTE DEVICES

Cables

Rubber covered flexible cables are available in standard lengths of 15' (4.57m) and 20' (6.09m) with a choice of either end or lug connectors. Custom cables and replacement connectors are also available.

Part Number:

- 11306 15' (4.57m) lugs at both ends
- 11307 15' (4.57m) lug and either end
- 11308 15' (4.57m) either ends at both ends
- 11312 20' (6.09m) lugs at both ends
- 11313 20' (6.09m) lug and either ends
- 11312 20' (6.09m) either ends at both ends



Connectors

Connectors for attaching 4/0 cables to Magnaflux® magnetizing equipment, including wet benches, powerpacks and mobile units.

Part Number:

- 1238 Either end connector (allows quick cable disconnect for maximum flexibility)
- 1238A Connector boot only
- 1574 Either end lug adapter (changes lug terminal to either end terminal)
- 1576 90° either end lug adapter (same as lug adapter 1574 but 90°)
- 2590 4/0 lug for permanent attachment to magnetizing equipment



Remote Control Cable

15' (4.57m) cable allows for remote energizing of portable power packs. Comes standard with 3 PTL plug.

Part Number:

- 157657 Remote Control Cable



Remote Palm Button

Remote palm button that mounts on side of Mag Kit for energizing current from power pack. Comes standard with 3 PTL plug.

Part Number:

- 169621 Mag Kit Remote Palm Button



MAGNETIC PARTICLE TESTING ACCESSORIES

Quality experts the world over count on Magnaflux® Magnetic Particle Testing Accessories to maintain their manufacturing standards and to help simplify, expand and improve their magnetic particle inspection processes. If you are looking to add to, or replace outdated MPI test components, you will find that Magnaflux offers an impressive line-up of accessories designed to meet your exact needs. From coils and prod sets, to field indicators, monitoring devices and spray applicators, Magnaflux® brand MPI accessories will help keep your process control operations performing at peak productivity and quality levels.

CENTRIFUGE TUBES & STANDS

Magnaflux® centrifuge tubes are individually calibrated to monitor the precise concentrations of Magnaglo® and Magnavis® particles in baths, as well as the contamination levels of their solutions.

Part Number: 8493 - Centrifuge Tube for Magnaglo® 14A, 14AM and 20B Fluorescent Particles. Measures in increments between 0 and 1.0 ml in 0.05 increments.

Part Number: 2461 - Centrifuge Tube for Magnaglo® MG-410 Fluorescent Particles. Measures in increments between 0 and 0.2 ml in 0.01 increments.

Part Number: 507923 - Centrifuge Tube for Magnavis® 7C and 9C Visible Particles. Measures in increments between 0 and 1.5 ml in 0.10 increments.

Part Number: 1837A - Aluminum Centrifuge Stand. Safely holds centrifuge tubes when mixing bath concentrations.



COILS

Coils for Bench Units

Five-turn coils in sizes from 12" to 25" that conform to most parts and produce optimal magnetic field applications.

Part Number:

- 28501 12" (30 cm) Coil
- 28511 16" (41 cm) Coil
- 28531 20" (51 cm) Coil
- 28541 25" (64 cm) Coil



Flat Magnetic Coil

For non-contact magnetic particle inspection of small parts such as fasteners and ring-like parts. Can be used with any magnetic particle unit or power pack to allow for the quick, easy processing of multiple parts at one time.

Part Number:

- 611700 Flat Magnetic Coil



L-10 Coil

Portable AC coil for use in the detection of surface cracks.

Part Number:

- 50651 Coil size 10" (25 cm) I.D. / 15" (38 cm) O.D. Comes with durable carrying case, flexible 10' (3 m) power cord. 115v, 60hz, 1-phase power source required to operate. 2,800 amp. turns.
- 620983 Coil size 10" (25 cm) I.D. / 15" (38 cm) O.D. Comes with durable carrying case, flexible 10' (3 m) power cord. 230V, 50/60hz, 1-phase power source required to operate. 2,800 amp. turns.



Clam Shell Coil Assembly

Part Number:

- 623031 19.7" (50 cm) Clam Shell Coil Assembly





CONDUCTORS & ADAPTERS

Central Conductors

Solid copper rods in diameters of .50" to 1.00" that provide circular magnetization of hollow parts.

Part Number:

622632 .50" Diameter x 15.875" Length

622633 .75" Diameter x 15.875" Length

622634 1.00" Diameter x 15.875" Length



622639

Small Parts Adapters

Magnaflux® small part adapters allow standard wet horizontal MPI test units to be used for inspecting small parts such as bolts, screws and pins. *Not for use with 12 x 12 contacts.*

Part Number: 28470 - Headstock Adapter. Made of solid copper and mounts directly to headstock.

Part Number: 28471 - Tailstock Adapter. Made of solid copper and mounts directly to tailstock.



28470

28471

CONTACT CLAMPS

Magnaflux® spring loaded and heavy-duty contact clamps facilitate the easier, more accurate inspection of tubing, bars, and tubular assemblies such as aircraft engine mounts, fuselage sections and large welded structures.

Part Number: 1865A - Spring Loaded Contact Clamp. For 1.25" to 2.50" diameter parts. Replacement copper braid (Part Number: 14710) also available.

Part Number: 169802 - Heavy-Duty Contact Clamp. For parts up to 7.00" diameter.

Part Number: 54975 - Magnetic Leach. Permanent magnet with 4/0 either end connector for attaching to parts.



1865A

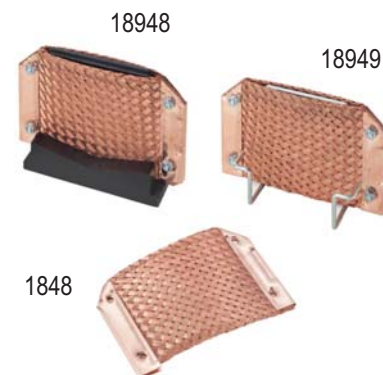
CONTACT PADS & PLATES

Magnaflux® long lasting copper braided contact pads and lead contact plates prevent arc burn by helping to maintain proper electrical contact between test parts and contact heads. Available in a variety of sizes to fit most MPI units.

Part Number: 1848 - Replacement Copper pad for 18948 and 18949. 4.75" (120.65mm) x 7.5" (190.5mm).

Part Number: 18948 - Double-Braided Pad with V-Block. Heavy copper braid provides contact over a larger surface area. Built with neoprene, the V-Block base centers and supports test parts. Can be reversed to provide two wear faces. Fits all units except A-915 and smaller Mag Series units.

Part Number: 18949 - Double-Braided Pad with Clip. Offers the same performance features as the 18948 but clips over the headstocks of A-915 and smaller Mag Series units.



18948

18949

1848

Contact Pads & Plates Continued -

Part Number: 605647 - Lead Contact Plate. Soft lead plate provides excellent contact with test parts and duplicates original headstock/tailstock contact plates. Fits all units except the A-915 and smaller Mag Series units. Size: 6.75" (171.45mm) x 6.635" (168.275mm) x .25" (6.35mm) thick.

Part Number: 605657 - Heavy Duty Lead Contact Plate. Copper impregnated lead contact plate that lasts 10 times longer than standard lead contact plates. Fits all units except A-915 and smaller Mag Series units.



FIELD INDICATORS

Field Indicators

Magnaflux® rugged, pocket-size 10 and 20 gauss field indicators are used to measure residual magnetism remaining in parts after magnetization.

Part Number: 2480 - Field Indicator. Inexpensive and disposable non certified 10 gauss field indicator.

Part Number: 505056 - 10 Gauss Calibrated Field Indicator. 10 gauss certified field indicator accurate to +0.5 gauss with a scale range of 10-0-10. Certification is provided with meter.

Part Number: 105645 - 20 Gauss Calibrated Field Indicator. 20 gauss certified field indicator accurate to +0.5 gauss with a scale range of 20-0-20. Certification is provided with meter.



Digital Hall Effect Meter Probe Gaussmeter

Magnaflux® digital hall effect meter measures AC and DC field strength. Includes meter, traverse probe, zero gauss chamber, batteries, manual, and case.

Part Number:

- 622604 Hall Effect Meter
- 622606 Axial Probe for Digital Hall Effect

622604



Pie Field Indicator

The Magnaflux® magnetic particle pie gauge is used as an aid in determining the direction of magnetic fields used in the detection of discontinuities in ferrous metal parts.

Part Number:

- 169799 Pie Field Indicator

169799



PORTABLE HAND SPRAYERS

Magnetic Particle Spray System

30 Gallon portable MPI spray system with 15 ft. recirculation hose and fan-pattern spray gun for inspection of large parts. May be used with water or oil based solutions. Continuous agitation for even particle suspension and fully portable with casters for easy mobility.

Part Number:

- 621778 Magnetic Particle Spray System

621778





Portable Pressure Sprayer

Easy to use, heavy-duty pressure sprayer for spot application of magnetic particle bath.

- Chrome-plated solid brass construction
- 1 quart capacity
- 200 psi maximum pressure

Part Number:

195260 Portable Pressure Sprayer

195260



Powder Spray Bulb

Lightweight, easy to use spray bulb for applying Magnavis® dry powders. Cap removes for easy refilling.

Part Number:

501232 Powder Spray Bulb

501232



MONITORING DEVICES

Quick Break Tester + Shot Timer

The Magnaflux® Quick Break Tester and Shot Timer displays peak quick break voltage in a quantitative way to facilitate detection of possible degradation of quick break.

Part Number:

622646 Quick Break Tester + Shot Timer

622646

Shot Timer

The Magnaflux® Shot Timer provides universal shot time detection for all MPI equipment.

- Reads shot time with 10ms resolution on digital display
- Microprocessor controlled for accurate signal capture and peak detection
- Low battery detection

Part Number:

622901 Shot Timer

622901



Digital Amperage Meter Kit

The Magnaflux® Digital Amperage Meter Kit is specifically designed for NDT applications and will certify the amperage on all MPI equipment manufactured by Magnaflux® up to 10,000 amps. Checks AC, HWDC, 1 Phase FWDC, and 3 Phase FWDC.

Part Number:

622350 Digital Amperage Meter Kit



622350

PROD SETS

Magnaflux® prod sets are convenient handheld electrodes used for conducting sectional inspections of welds, casting, forgings and other large and complex part shapes. Comfortable, pistol style grips and out-of-the-way cable hookups make it easy for testing parts that are not wet bench friendly.

Standard Prod Sets

Part Number: 622088 - For use with M-2000 Series units

Part Number: 157662 - For use with P-70 and P-1500 units



Dual Horizontal Prod Assemblies

Part Number: 622499 - For use with M-2000 Series units

Part Number: 157781 - For use with P-70 and P-1500 units



STEADYRESTS & CONTACT BLOCKS

Steadyrests

Used to support and stabilize long or heavy parts during the inspection process.

Part Number: 1857 - Rail Mounted Roller Type Steadyrest. Mounts and moves on rails with adjustable height to accommodate various part lengths. Fits all units except A-915 and small Mag Series units. Weight capacity up to 1,500 lbs.

Part Number: 605750 - Headstock Mounted Roller Type Steadyrest. Mounts on headstock to support one end of part (use rail-mounted Part Number 1857 to support other end). Speeds up part loading as coil may be retracted past the headstock. Fits all units except A-915 and small Mag Series units.

Part Number: 621658 - Tailstock Steadyrest. Designed for mounting on the tailstock and will work with either headstock or tailstock steadyrests.



Contact Block

Permits remote testing of parts that are too heavy for processing on a unit. When clamped between head and tailstock, the block supplies magnetizing current to remote prods or clamps through flexible cables (cables not included, see cables & connectors).

Part Number:

1830 Contact Block



1830

TEST BLOCKS

Continuous Method Test Block

The Magnaflux® Continuous Method Test Block is used to check for proper magnetizing techniques on wet horizontal MPI units. Crack indications form on the test block when current flow and bath concentrations are at proper levels.

Part Number:

75130 Continuous Method Test Block



75130



TEST PIECES

Magnetic Particle Test Bar

The Magnaflux® Magnetic Particle Test Bar contains coarse and fine surface and subsurface defects in both directions. It meets or exceeds most industry and military standards for artificial test specimens.

Part Number:

189838 Magnetic Particle Test Bar



189838

Quantitative Quality Indicator Test Pieces

Quantitative Quality Indicators (QQI) are magnetic particle test pieces with artificial defects that are used to verify field direction and relative strength. They are also used to balance multi-directional fields and to increase productivity by minimizing magnetizing shots.

Part Number: 519630 - Standard QQI Model #KSC-230. Basic circular and cross bar flaw configuration suitable for longitudinal and circular fields. Flaw depth of 30% of shim thickness, .002" thick.

Part Number: 521048 - Standard QQI Model #KSC-430. Basic circular and cross bar flaw configuration suitable for longitudinal and circular fields. Flaw depth of 30% of shim thickness, .004" thick.

Part Number: 519631 - Miniature QQI Model #KSC-4-230. Similar to KSC-230 except miniature design for small areas on test part. The 4 circles may be cut apart for individual use. Flaw depth of 30% of shim thickness, .002" thick.

Part Number: 519632 - Variable Depth QQI Model #KSCT-234. Used for more quantitative work, the KSCT-234 contains 3 concentric circular flaws of varying depths. Flaw depths of 20%, 30% and 40% of shim thickness, .002" thick.

Part Number: 521049 - Variable Depth QQI Model #KSC4-234. Used for more quantitative work, the KSC4-234 contains 3 concentric circular flaws of differing depth. Flaw depths of 20%, 30% and 40% of shim thickness, .004" thick.



519630

519631

519632

521048

521049

Tool Steel Test Ring

The Magnaflux® Tool Steel Test Ring is a magnetic particle test piece with pre-drilled holes to simulate subsurface discontinuities. It provides a reliable method of verifying magnetic particle system performance when actual test parts with discontinuities are not available.

Part Number:

159999 Tool Steel Test Ring



159999

Magnetic Flux Indicators

Magnaflux® Type G (General use) magnetic flux indicators come in a packet of 5 and are used to detect appropriate levels of magnetic field strength. These flexible indicators also assist in determining directional orientation of the magnetic field.

Part Number:

008M004 Magnetic Flux Indicators (set of 5)



008M004