



Sonotron NDT

4, Pekeris str., Rabin Science Park, Rehovot, 76702, Israel
Phone:++972-(0)8-9311000 Fax:++972-(0)8-9477712

Simple TOFD / PA Scanner

SSBC 288690

SSBC 288690 FR



Brief User Manual





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Tools Required:



**Philips
Screwdriver**

**3 mm hex ball
Screwdriver**





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TOFD Probes

Planar Welds

1. Install probes [1] into the Probe-Holders [2] as it is shown on the Fig.1
2. Fit Probe-Holders into the scanner frame with use of long screws [3] on the rail, and fix with nuts [5]

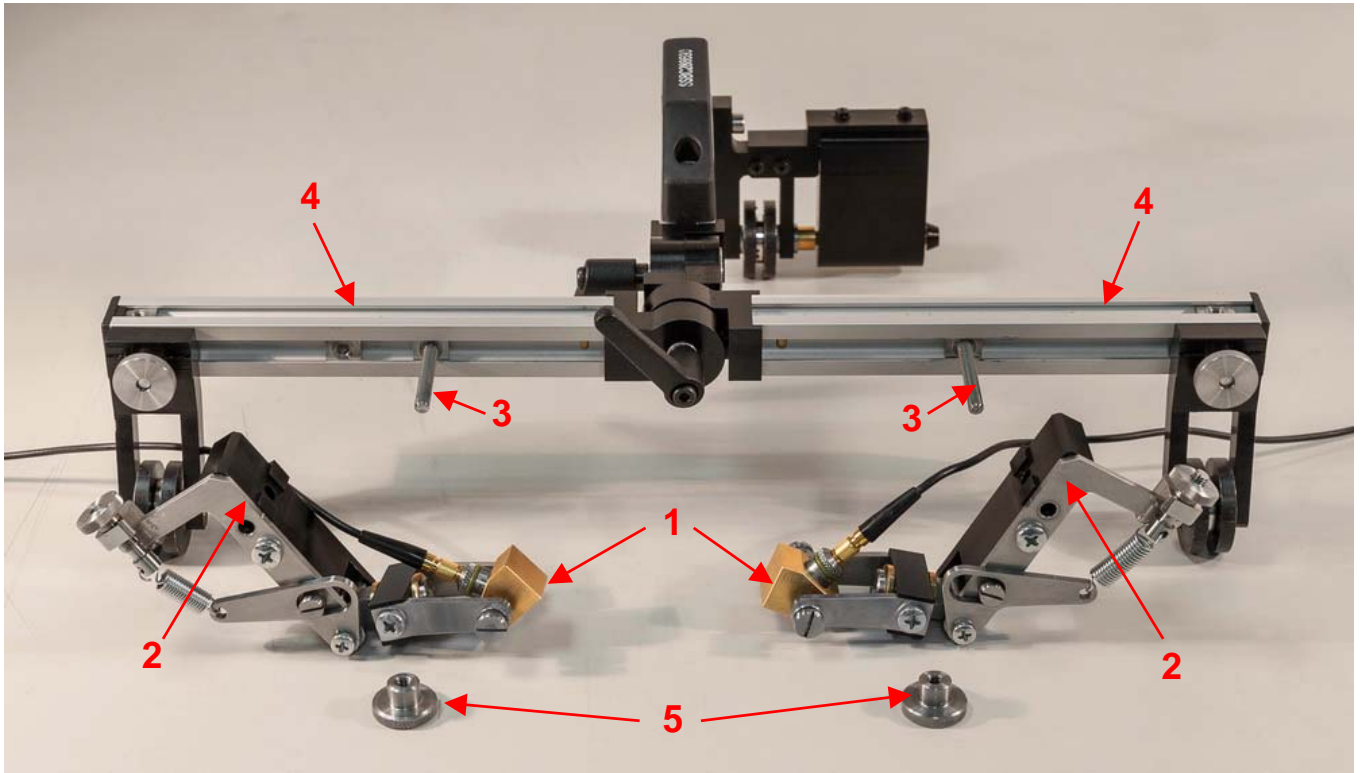


Fig. 1





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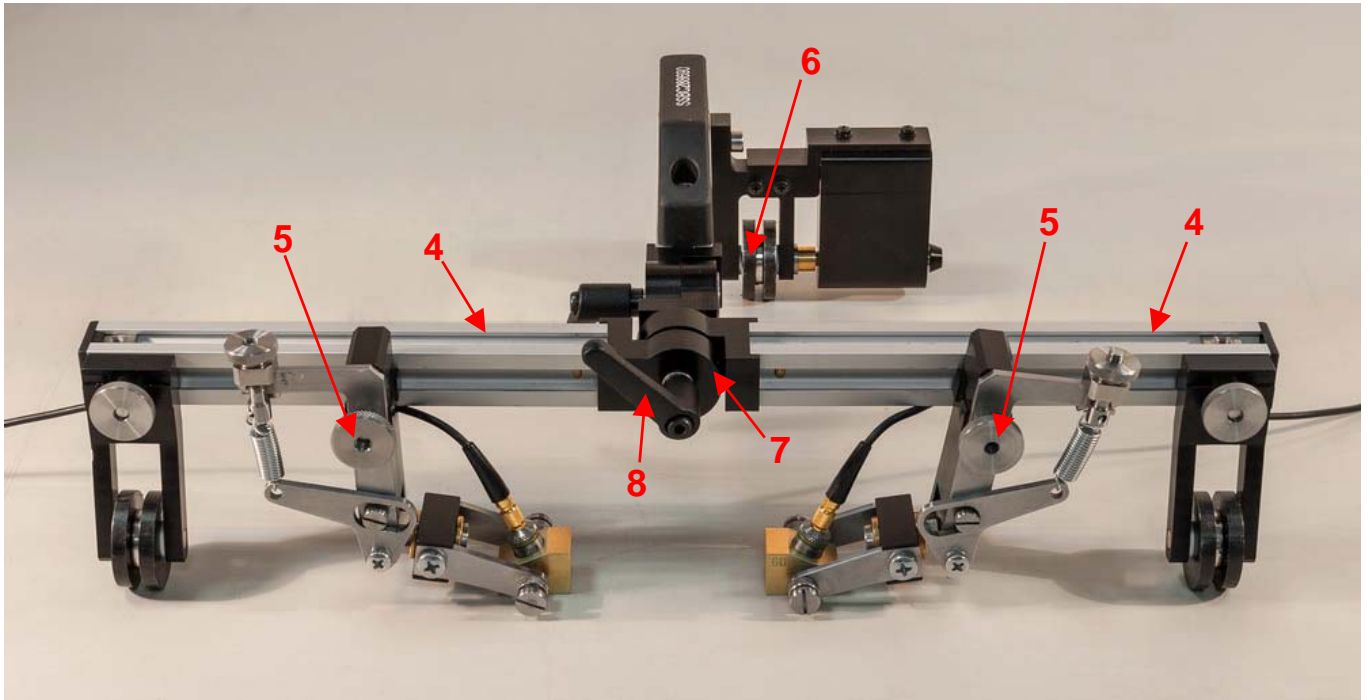


Fig.2





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3. Rails [4] and axis of wheel [6] should be adjusted to stay at the scanning surface.
 Use Joint [7] to adjust the rails and fix them with screw-handle [8] as it is shown on the Fig.2

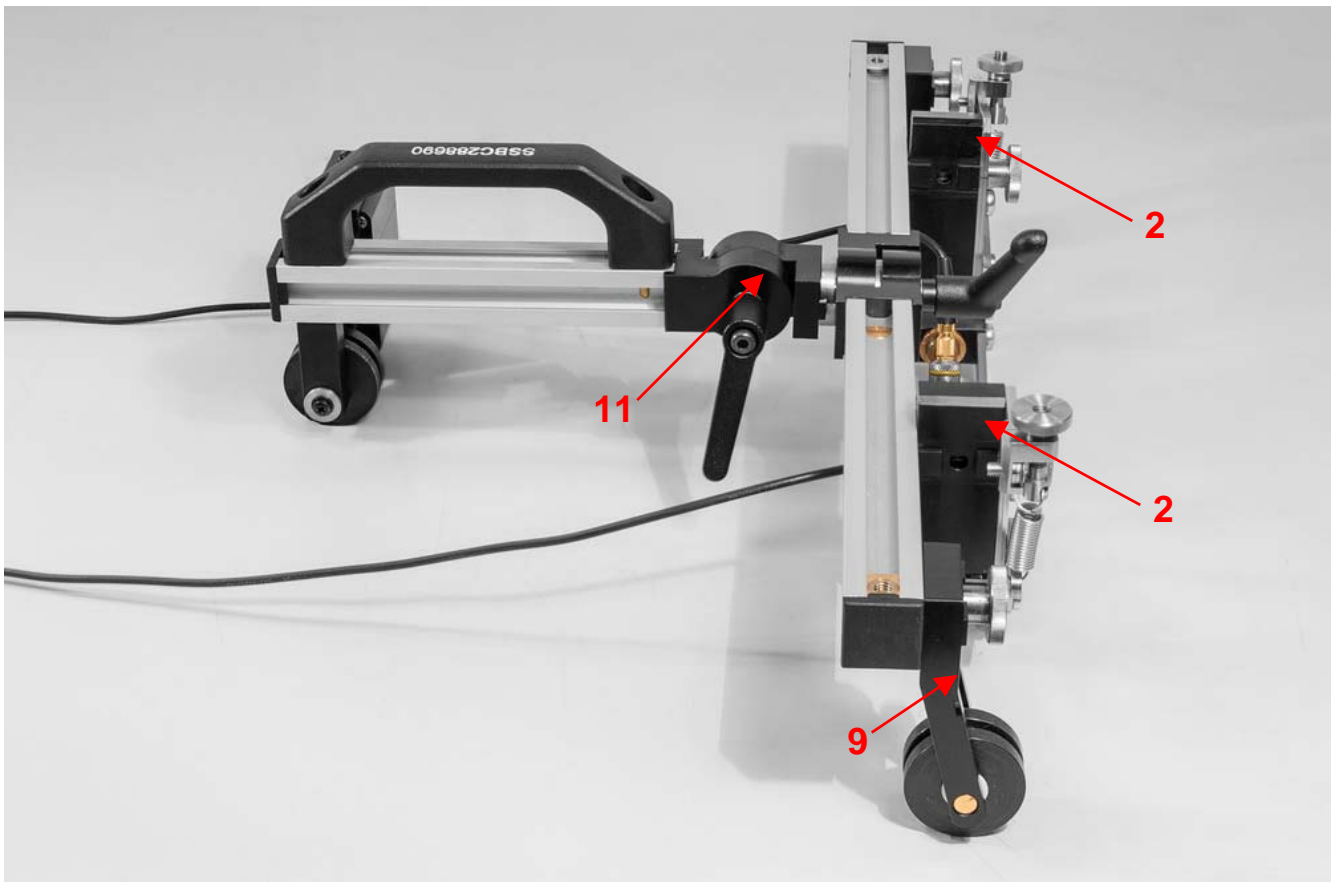


Fig. 3

4. Ensure that both left & right wheels [9] are installed on the same side of the rail as the Probe-holders as it is shown on the Fig.3
5. Adjust Joint [11] to set Probe-holders at rectangle to the scanning surface as it is shown on the Fig.3





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Circumferential welds

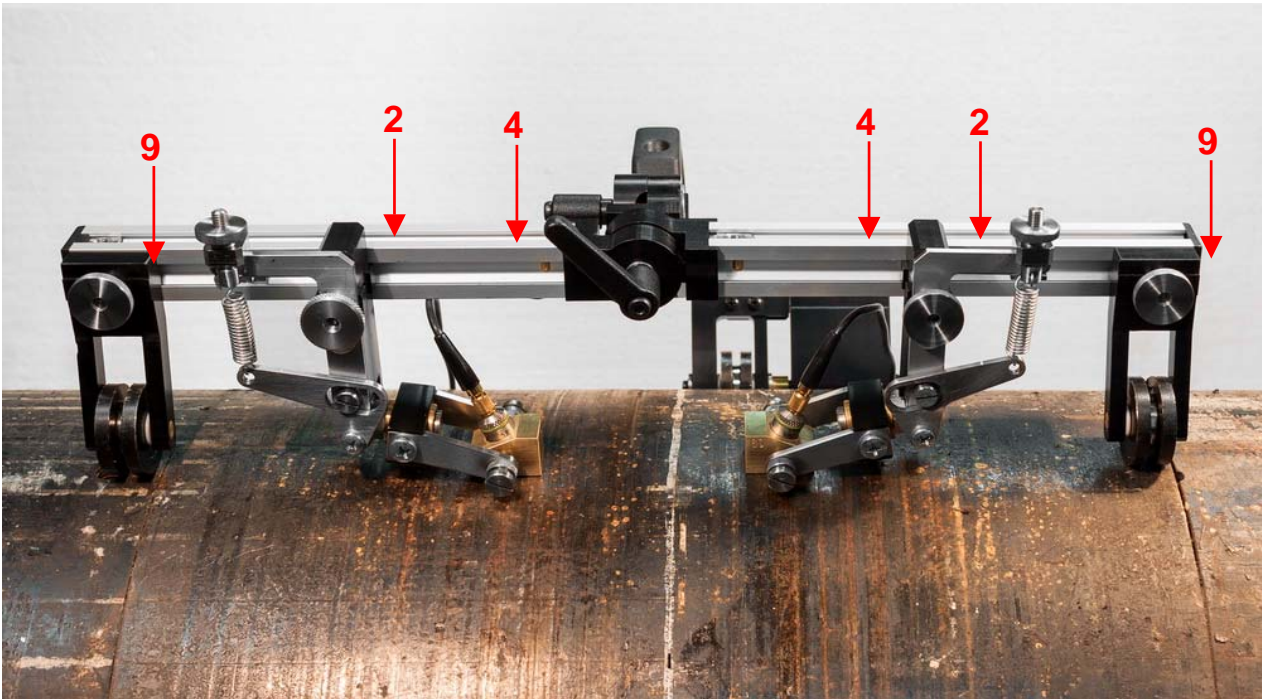
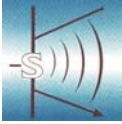


Fig. 4

1. For setting Probe Holders, wheels and rails proceed in the same manner as for flat surface same as for a flat surface – Fig.4





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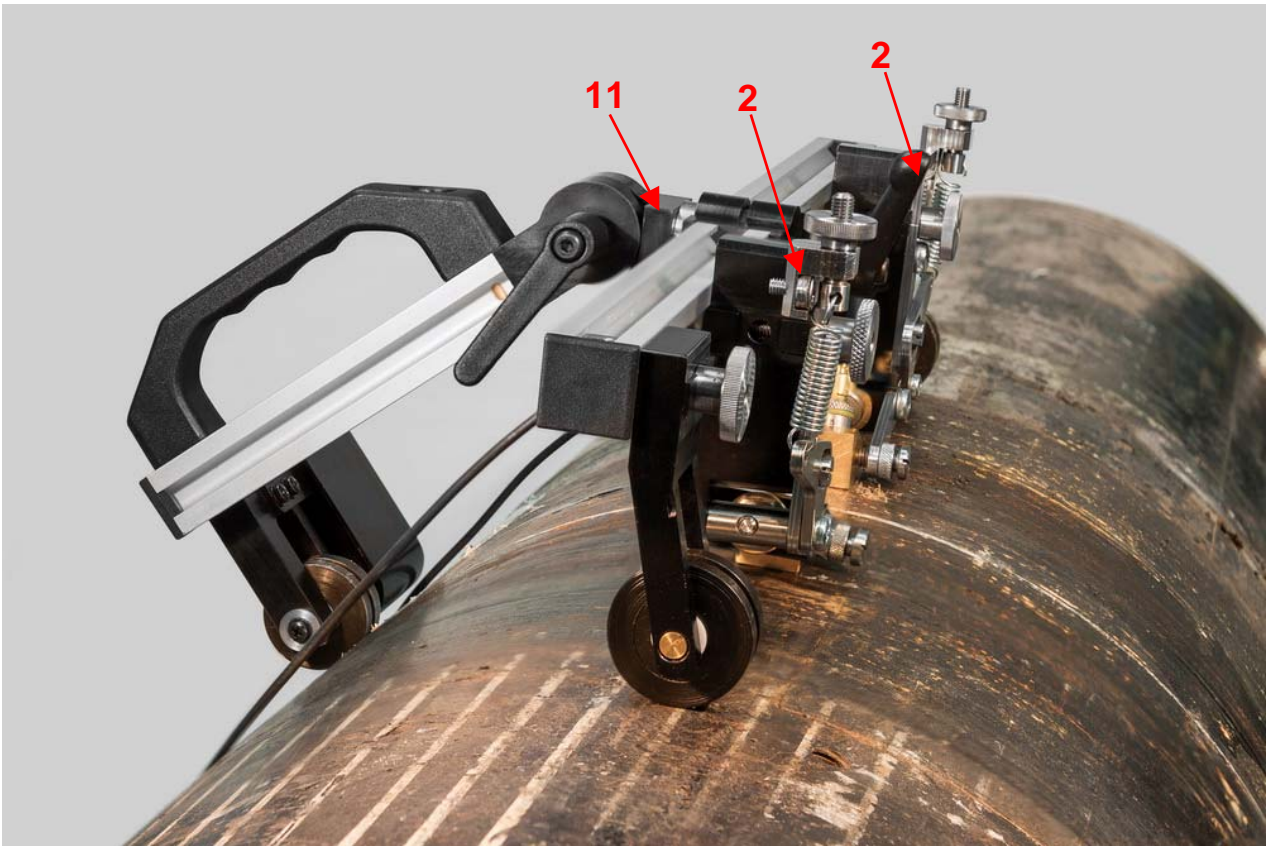
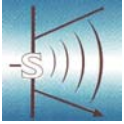


Fig.5

2. Adjust Joint [11] to set Probe-holders at rectangle to the scanning surface as it is shown on the Fig.5





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Longitudinal welds

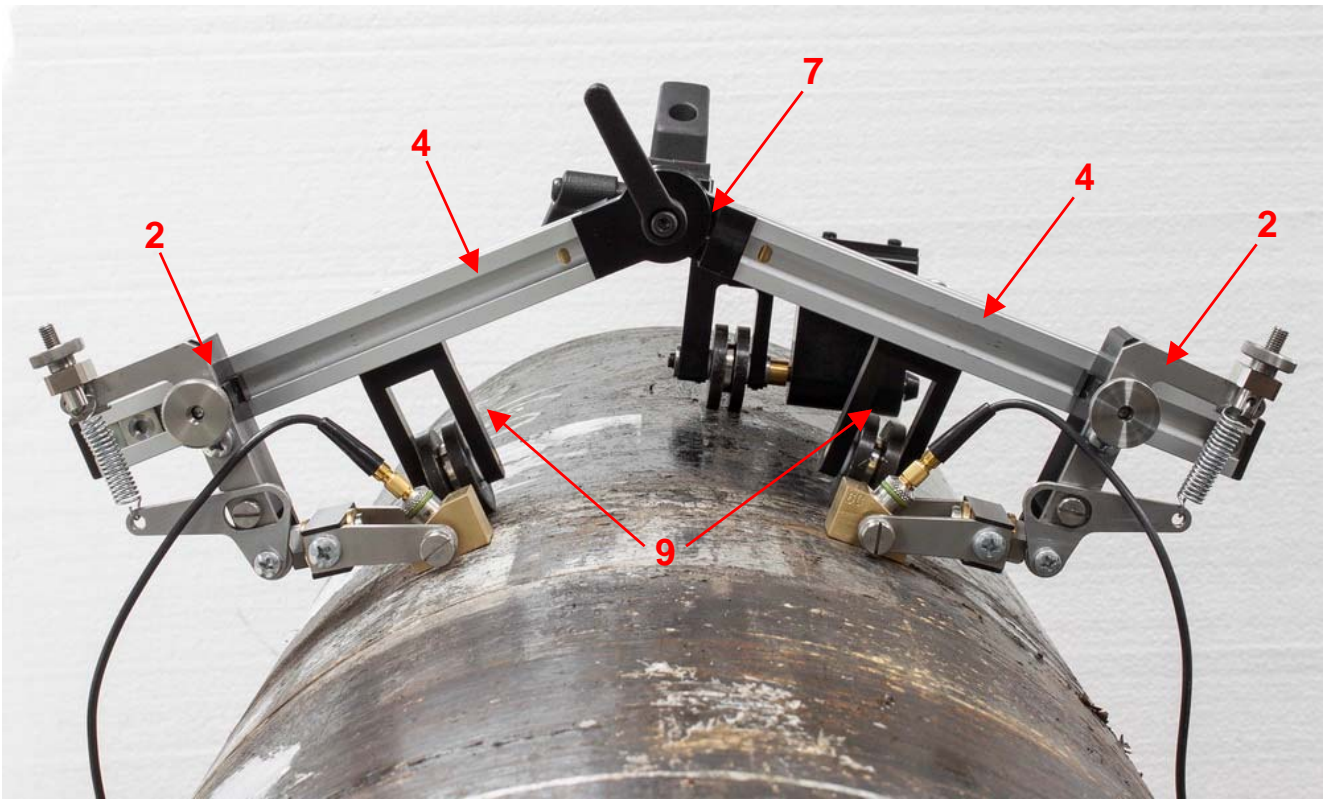


Fig. 6





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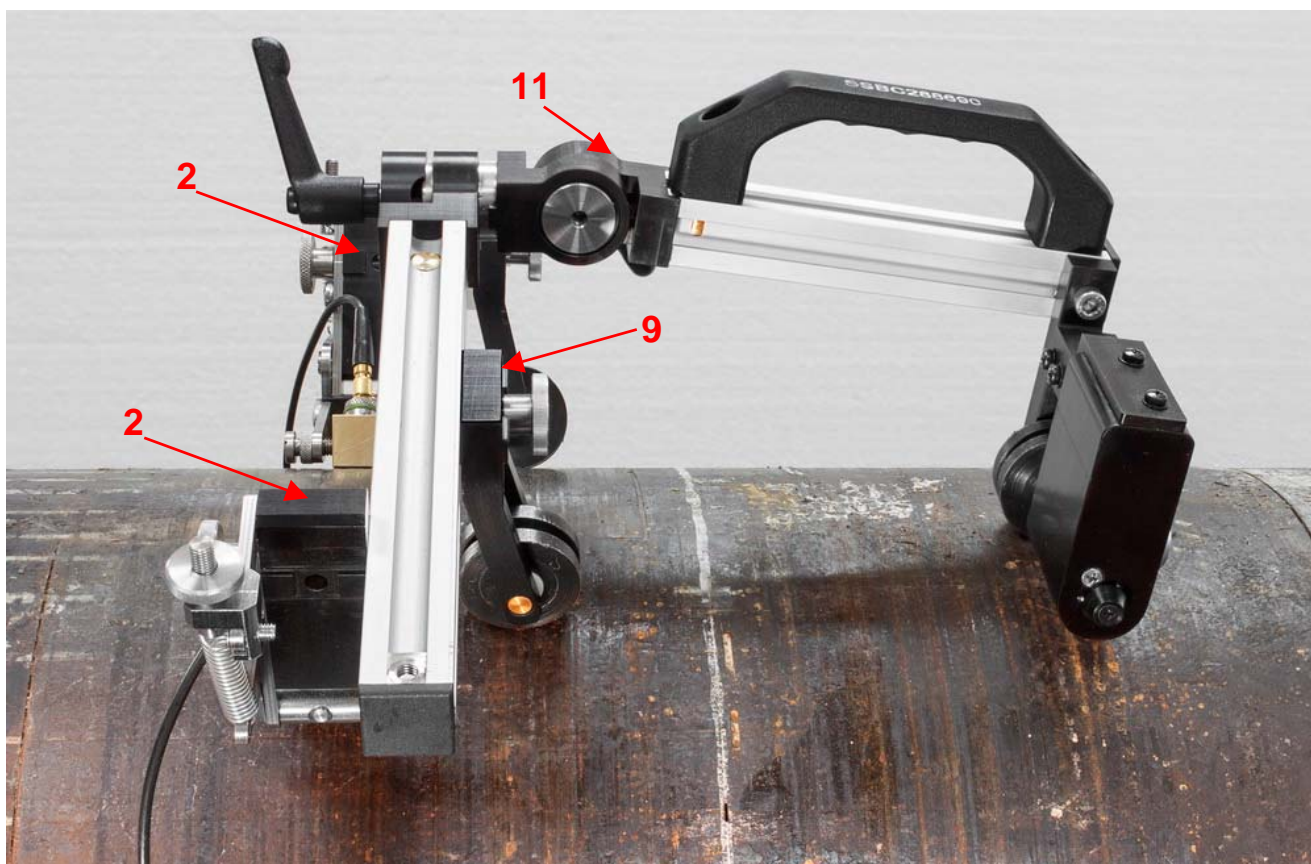


Fig. 7

1. Install the wheels [9] to stay on the rail at the opposite side rail from the Probe Holders [2], as it is shown on the Fig.6 and 7
2. Provide probe separation for the TOFD probes according to the inspection procedure and fix probe holders on the rails accordingly
3. Slide wheels at the opposite side of each rail and fix them I oppositely to the corresponding probe
4. Use Joints [7] [11] and to set probes at wheels at rectangle to the scanning surface





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PA Probes

Planar and circumferential welds

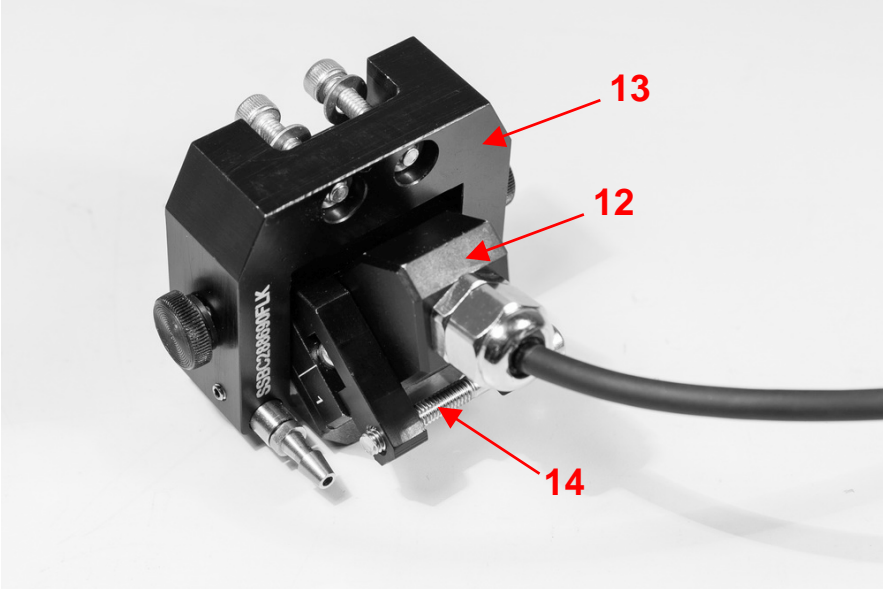


Fig. 8

- 1. Fit PA Probe 12 into Probe Holder 13 and secure it with screw 14 as it is shown on the Fig.8

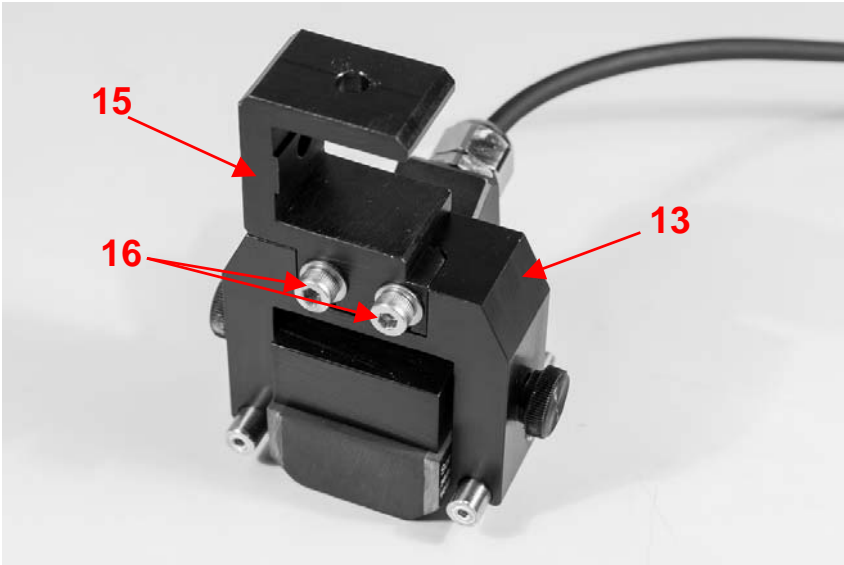


Fig.9

- 2. Attach fixture [15] to Probe Holder [13], and secure with screws [16] it is shown on the Fig.9





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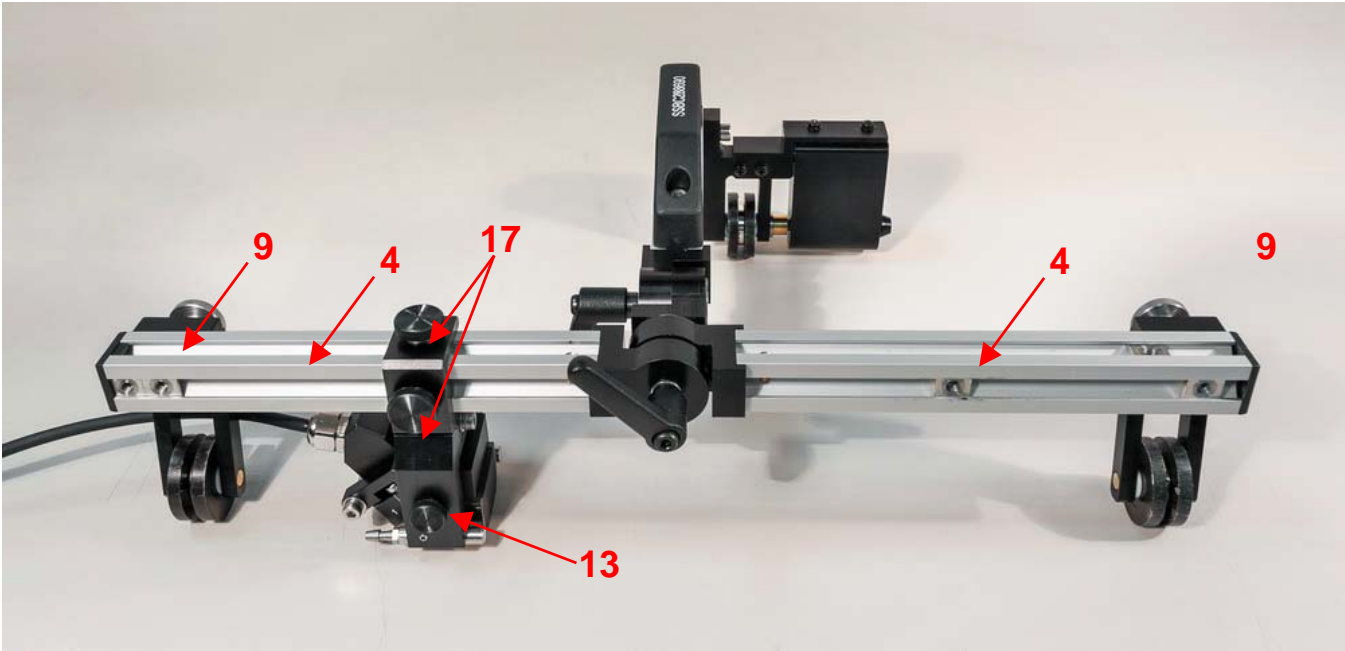


Fig.10





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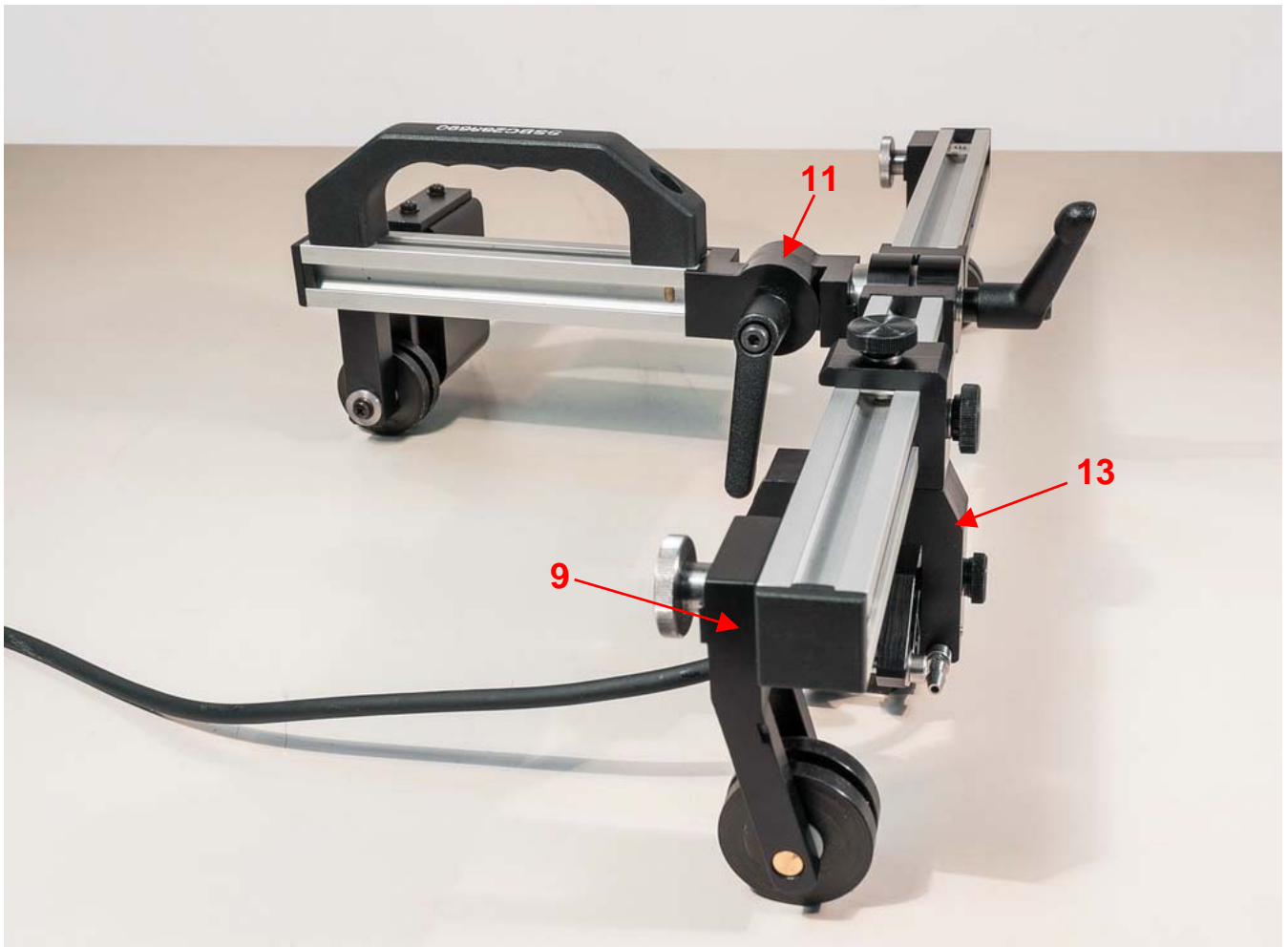


Fig. 11

3. Attach Probe-Holder(s) [13] and wheels [9] to the scanner at the opposite sides of the rails, as it on the Fig. 10
4. Secure Probe-holder(s) [13] position with two thumb-screws [17]
5. The PA Probe(s) and wheels should be settled at rectangle to the scanning surface





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Fig. 12





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Fig.13

6. Set scanner onto material for the inspection of circumferential welds as it is shown on the Fig.12 and 13. Distance(s) between PA Probe(s) and weld should be adjusted according to the inspection procedure





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Longitudinal welds

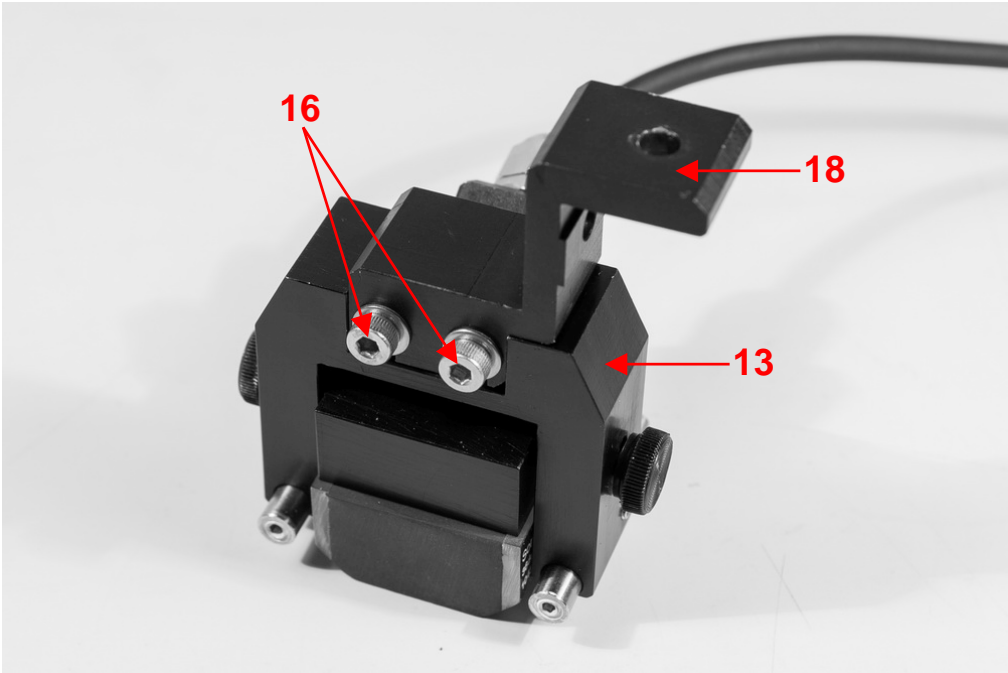


Fig.14

1. Attach fixture [18] to Probe Holder [13], and secure with screws [16] as it is shown on the Fig.14

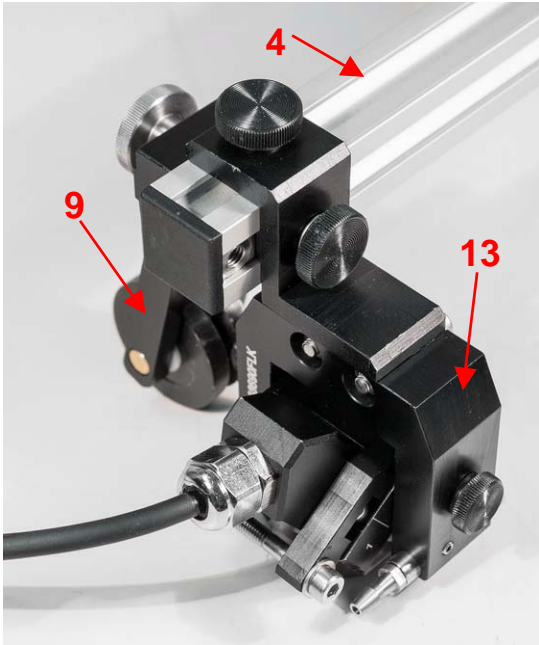


Fig. 15

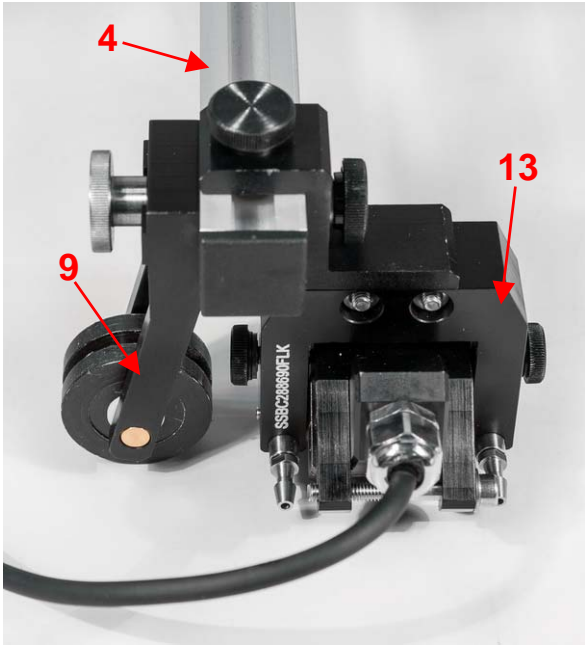


Fig. 16

2. Attach Probe-Holder(s) [13] and wheels [9] to the rail at opposite sides as it is shown on the Fig.15 and 16





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Fig.17

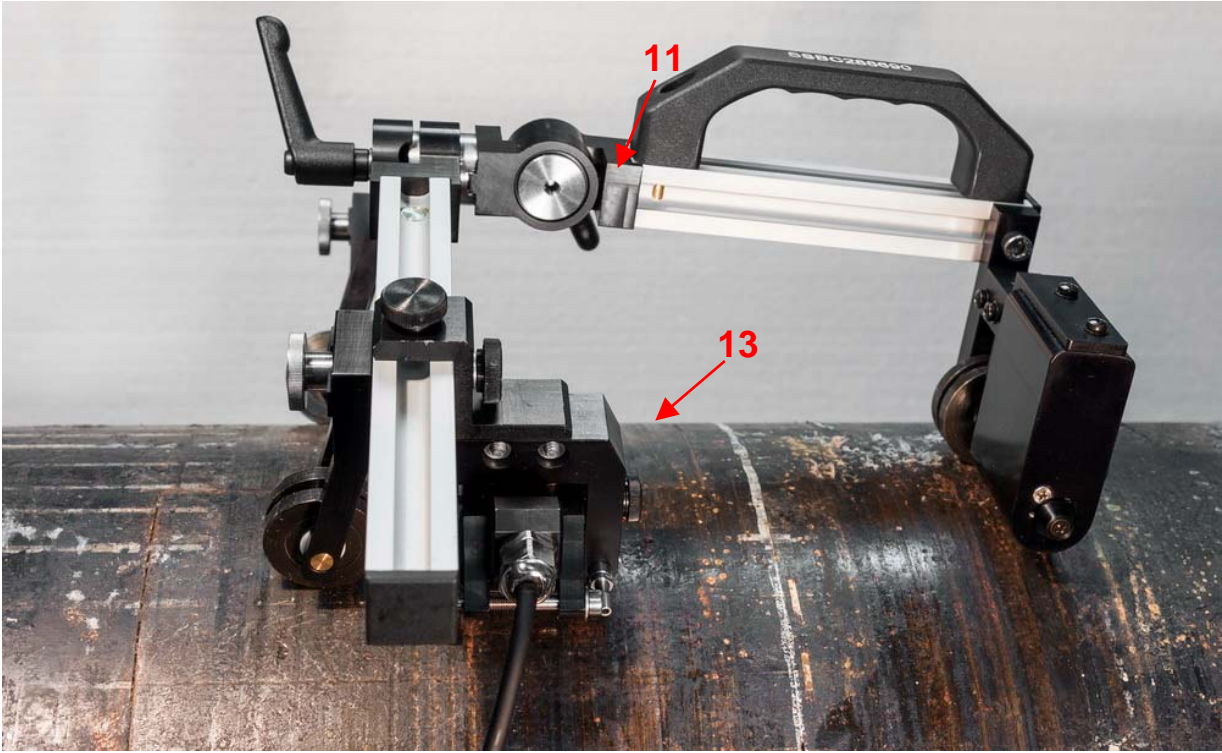


Fig. 18





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3. Place the scanner onto the scanning surface as it is shown on the Fig.17 and 18
4. Distance(s) between PA Probe(s) and weld should be adjusted according to the inspection procedure, wheels should be settled at the opposite side of the rail accordingly

