

TEAM COOPERHEAT-MQS, INC.

RADIOGRAPHIC TECHNIQUE SHEET

FORM 20.3-61 Rev. 4

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CUSTOMER RSS NO.: _____ SHEET: _____ REV: _____

MQS TECH. NO.: 12970

MQS RSS NO.: _____

CUSTOMER METALTEK INTERNATIONAL

DATE: 1-18-2005

PART NO. MCWF-C12103989

DESCRIPTION C2 COIL CASTING

MATERIAL CF8MNM

TOTAL NUMBER OF VIEWS 121 NUMBER X-RAY VIEWS 121 NUMBER GAMMA RAY VIEWS 0

MACH(s) MAKE(s) VARIAN MODEL(s) L2000 S/N(s) 20 MAX KV(s) 7500

SOURCE(s) N/A

PROCEDURE SPECIFICATION MSS-SP-54

ACCEPTANCE CRITERIA MSS-SP-54

MQS PROCEDURE NO. 20.H.010 REV. 0

PENETRATOR SPEC. ASTM E142-86

PROCESSING: AUTOMATIC ☒ PROCESSOR B2000 MANUAL ☐ TEMPERATURE 27.2°

TECHNICIAN J.P., S.S.

NDT LEVEL II

APPROVED BY Chris Rudolph NDT LEVEL III

VIEW IDENTIFICATION		*					
SOURCE/X-RAY MACH USED		VARIAN					
CURIES OR KV		7500					
MA OR PULSES		N/A					
SOURCE TO FILM DISTANCE		*					
EXPOSURE TIME OR RADS		*					
MATERIAL THICKNESS		I					
MATERIAL GROUP		I					
PENETRATOR SIZE/(AMT)	GP. <input type="checkbox"/>	*		SEE ATTACHED	INFORMATION		
SHIM BLOCK SIZE	GP. <input type="checkbox"/>	N/A					
FILM SIZE		*					
FILM TYPE/BRAND		*					
PB SCREEN, FRONT		.010					
PB SCREEN, BACK		.010					
SENSITIVITY		2-2T					
FILTER TYPE/LOCATION		N/A					
MASKING TYPE/LOCATION		N/A					
ANGLE		*					
NO. OF FILMS IN CASSETTE		*					
VIEWING: SING./DOUB./BOTH		S-B					
FOCAL SPOT SIZE		2 MM					
SKETCH AND/OR REMARKS		SEE ATTACHED					
GEOMETRIC UNSHARPNESS							

CUSTOMER Metaltek RSS # 12970 PART NO. MCWF-C2

VIEW	SFD	EXP. TIME	FILM TYPE	FILM SIZE	THK. RANGE	IQI
1-2	65"	25 KR	T	14 X 17	2-3/4"	50(2)
2-3	65"	25 KR	T	14 X 17	2-3/4"	50(2)
3-4	65"	25 KR	T	14 X 17	2-3/4"	50(2)
4-5	65"	25 KR	T	14 X 17	2-3/4"	50(2)
5-6	65"	25 KR	T	14 X 17	2-3/4"	50(2)
7-8	65"	25 KR	T	14 X 17	2-3/4"	50(2)
8-9	65"	25 KR	T	14 X 17	2-3/4"	50(2)
9-10	65"	25 KR	T	14 X 17	2-3/4"	50(2)
10-11	65"	25 KR	T	14 X 17	2-3/4"	50(2)
11-12	65"	25 KR	T	14 X 17	2-3/4"	50(2)
12-13	65"	25 KR	T	14 X 17	2-3/4"	50(2)
13-14	65"	25 KR	T	14 X 17	2-3/4"	50(2)
14-15	65"	25 KR	T	14 X 17	2-3/4"	50(2)
15-16	65"	25 KR	T	14 X 17	2-3/4"	50(2)
16-17	65"	25 KR	T	14 X 17	2-3/4"	50(2)
17-18	65"	25 KR	T	14 X 17	2-3/4"	50(2)
18-19	65"	25 KR	T	14 X 17	2-3/4"	50(2)
19-20	65"	25 KR	T	14 X 17	2-3/4"	50(2)
20-21	65"	25 KR	T	14 X 17	2-3/4"	50(2)
21-22	65"	25 KR	T	14 X 17	2-3/4"	50(2)
23-24	65"	25 KR	T	14 X 17	2-3/4"	50(2)
24-25	65"	25 KR	T	7 x 17	2-3/4"	50(2)
26-27	65"	25 KR	T	7 x 17	2-3/4"	50(2)
27-28	65"	25 KR	T	7 x 17	2-3/4"	50(2)
29-30	70"	25 KR	M125	14 x 17	1-1/2"	30(2)
30-31	70"	25 KR	M125	11 x 17	1-1/2"	30(2)
32-33	70"	25 KR	M125	14 x 17	1-1/2"	30(2)
33-34	70"	25 KR	M125	14 x 17	1-1/2"	30(2)
35-36	70"	25 KR	M125	11 x 14	1-1/2"	30(2)
36-37	70"	25 KR	M125	14 x 17	1-1/2"	30(2)
38-39	70"	25 KR	M125	14 x 17	1-1/2"	30(2)
39-40	70"	25 KR	M125	14 x 17	1-1/2"	30(2)
41-42	85"	35 KR	T/M125	14 X 17	1-1/2" - 2"	30, 40
42-43	85"	35 KR	T/M125	14 X 17	1-1/2" - 2"	30, 40
44-45	85"	35 KR	T/M125	14 X 17	1-1/2" - 2"	30, 40
45-46	85"	35 KR	T/M125	14 X 17	1-1/2" - 2"	30, 40
47-48	85"	35 KR	T/M125	14 X 17	1-1/2" - 2"	30, 40
48-49	85"	35 KR	T/M125	14 X 17	1-1/2" - 2"	30, 40
50-51	85"	35 KR	T/M125	14 X 17	1-1/2" - 2"	30, 40
52-53	90"	40 KR	D8/T/AA/Dumb	14 x 17	1-1/2" - 7"	30,40,100,140
53-54	90"	40 KR	D8/T/AA/Dumb	14 x 17	1-1/2" - 7"	30,40,100,140
54-55	90"	40 KR	D8/T/AA/Dumb	14 x 17	1-1/2" - 5"	30,40,100

CUSTOMER Metaltek RSS # _____ PART NO. MCWF-C 2

VIEW	SFD	EXP. TIME	FILM TYPE	FILM SIZE	THK. RANGE	IQI
55-56	90"	40 KR	D8/T/AA/Dumb	14 x 17	1-1/2" - 5"	30,40,100
56-57	90"	40 KR	D8/T/AA/Dumb	14 x 17	1-1/2" - 5"	30,40,100
57-58	93"	65 KR	D8/AA/T/D8	14 x 17	3" - 7"	60,140
58-59	90"	40 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
59-60	90"	40 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
60-61	90"	40 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
62-63	90"	40 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
63-64	90"	35 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
65-66	90"	150 KR	D8/AA/T/D8	14 x 17	1-1/2"	30(2)
67-68	90"	40 KR	T/M125	14 x 17	3" - 10"	60,140,180,200
68-69	90"	40 KR	T/M125	14 x 17	1-1/2" - 3"	30,40,60
69-70	90"	55 KR	D8/M125/AA	14 x 17	1-1/2" - 2"	30,40
V64	90"	40 KR	M125/M100	14 x 17	1-1/2" - 6"	30,40,100,120
71-72	80"	50 KR	AA/M125/T	11 X 14	1" - 1-1/2"	20,30
72-73	80"	90 KR	AA/M125/M100/T	14 x 17	1-1/2" - 5"	30,50,60,80,100
73-74	80"	35 KR	T/M125	14 x 17	1-1/2" - 5"	30,50,60,80,100
74-75	80"	35 KR	T/M125	14 x 17	1-1/2" - 4"	30,40,80
75-76	80"	35 KR	T/M125	14 x 17	1-1/2" - 4"	30,40,80
76-77	80"	30 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
78-79	80"	30 KR	T/M125	11 x 14	1-1/2" - 2"	30,40
79-80	80"	35 KR	T/M125	14 x 17	1-1/2" - 3"	30,40,60
80-81	80"	35 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
81-82	80"	30 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
83-84	80"	30 KR	T/M125	7 x 17	1-1/2" - 2"	30,40
85-86	80"	35 KR	T/M125	14 x 17	1-1/2" - 3"	30,40,60
86-87	80"	30 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
87-88	80"	60 KR	D8/M125/T	14 x 17	1-1/2" - 6"	30,40,120(2)
88-89	80"	30 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
89-90	80"	40 KR	AA/M125/T	14 x 17	1-1/2" - 3"	30,40,60
90-91	80"	30 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
92-93	80"	30 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
V94	72"	25 KR	T	14 x 17	2-3/4"	50
V95	72"	25 KR	T	8 x 10	2-3/4"	50
96-97	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
97-98	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
98-99	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
100-101	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
101-102	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
102-103	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
103-104	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
104-105	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
105-107	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)

CUSTOMER Metaltek RSS # 12970 PART NO. MCWF-C2

[illegible]

PART NO. MCWF-C2

Form 20.4 - 61 Attachment A