

CERTIFICATE OF INSPECTION (ULTRASONIC)

CLIENT - NAME AND ADDRESS: REVISS Services (UK) Ltd 6 Chiltern Court Asheridge Road Chesham Buckinghamshire HP5 2PX	SHEET 1 OF 2 SHEET JOB No: 91018 (Aerospace) REPORT No: REV/011/0609 UT WORKS ORDER No: TBA PURCHASE ORDER No: RSL06814 DATE OF TEST: 23 Jun 09
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PLACE OF TEST: Colston, Brunel Park, Bumpers Farm, Chippenham, Wiltshire SN14 6NQ

DESCRIPTION OF ITEMS INSPECTED (INCLUDE DRAWING / PART No. WHEN POSSIBLE)	QUANTITY	MATERIAL	ITEM IDENT OR SERIAL No.	STAGE OF PRODUCTION OR HEAT TREATMENT
Isotope Transportation Flask	1 off	Stainless Steel (Grade unknown). H ₂ O	-	As manufactured

INSPECTION STANDARD: Nil Supplied	ACCEPTANCE STANDARD: To estimate average gap between Inner Surface of Steel Outer Casing and the Lead Shield Material
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INSPECTION TECHNIQUE: Nil Supplied

Surface: Plate	Access: Good	Weld Process: N/A	Joint Type: N/A					
Instrument Type: Krautkramer USN 58L	Serial No: 01D4YP	Couplant: Sonagel/H ₂ O	PCP Ults 13 Completed:					
Probe Type	Crystal Size	Frequency	Serial No.	Sensitivity	Timebase	Reject	Cal. Block	Ref. Block
0 Deg.	0.5" DIA	5MHz	01XRFD		See Below	0	Nil	See Below

INSPECTION DETAILS AND RESULTS:



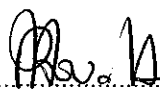

Ref Block: A flat topped lead block was submerged in a water bath.
 2 off 1.00mm Spacers were placed on top of the lead block.
 A 10mm Stainless Steel Plate was placed on top of the spacers.
 (Spacers of 0.50mm, 1.00mm, 1.50mm and 2.00mm were available for use).

Instrument Setup: The following parameters were set into the Instrument.

Range: 3.00mm
 Probe Delay: 3.4106µS
 Velocity: 1501 M/S
 Display Delay: Zero
 Frequency: 5 MHz
 Rectify: RF
 Gain: 66dB
 An acetate cover was placed on to the Instrument Display window

Method: Area of Interest is the gap between the backwall of the Stainless Steel Casing and the Lead Block.
 The probe was placed on the Steel surface and the first and second returns from the Steel/H₂O interface were marked on the acetate with chinagraph pencil. The return from the Lead Block was marked on the Acetate with a second colour chinagraph. The 1.00 mm spacers were replaced with 2.00mm spacers. The return from the Lead block was again marked on the acetate. This operation was repeated for 0.50 and 1.50mm spacers. Displays were rechecked for the different spacers.

REMARKS:

TESTED BY: P Davies S.N.T. EN4179 L2  SIGNED DATE: 23 Jun 09 	APPROVED BY:  SIGNED DATE: 23 Jun 09 
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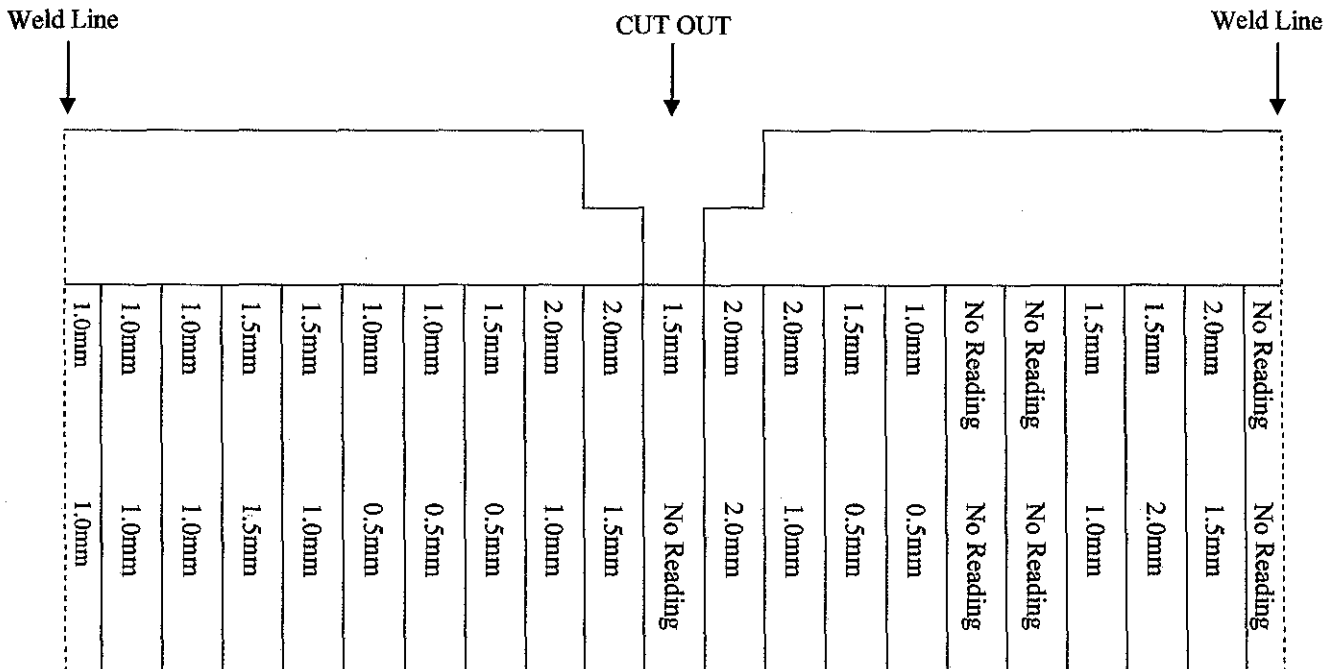
SERIAL No.: 91018 (Aerospace) REV/011/0609 UT

SHEET 2 OF 2 SHEETS

RESULTS


Ultrasonic readings were taken on the Steel Casing between the vanes around the flask. Vertically between the Intrnal Top and Centre Steel Bands and between the Centre and Lower Steel Bands. 42 off Readings.
Each Reading that had an ultrasonic return has been included on Fig. 1 below. Where no return was indicated, a value of 'No Reading' has been inserted.

ALL MEASUREMENTS ARE APPROXIMATE.

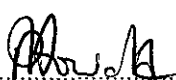


Kipper Diagram of Transportation Flask.

Fig. 1

TESTED BY: P Davies
S.N.T. EN4179 L2
SIGNED:  DATE... 23 Jun 09



APPROVED BY:
SIGNED:  DATE: 23.06.09
For and on behalf of Caparo Testing Technologies.

