



CGM CIGIEMME S.p.A.



Controlli Non Distruttivi - Non Destructive Testing

TAM 135273 CRACK COMPARATOR



DESCRIPTION

The TAM 135273 crack comparator is used to measure the actual size of indications identified during the liquid penetrant testing. It measures indications in increments ranging from 0.010' to 0.180' (0.2 mm to 4.6 mm)

In compliance with: PRATT & WHITNEY Requirements TAM 135273

USER INSTRUCTIONS

PRELIMINARY STAGE

1. **Surface preparation:** thoroughly clean the piece to be inspected.
2. **Penetrant application:** apply the penetrant liquid and wait.
3. **Removing penetrant excess:** remove the penetrant from the surface.
4. **Developer application:** apply the developer to extract the penetrant from the surface cracks.



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USE OF THE DEVICE

- 1. Work in a properly darkened area, as indicated in the procedure:** the comparator markings and crack indications will be fluorescent and will be most visible under UV light.
- 2. Positioning:** place the comparator directly next to or above the fluorescent marking to be measured. As it is transparent, the comparator allows the crack to be seen through it.
- 3. Comparison:** compare the reading with the various calibrated marks on the comparator. The TAM 135273 measures readings in increments from 0.010' to 0.180' (from 0.2 mm to 4.6 mm)..
- 4. Recognition:** identify the mark that most closely matches the dimensions of the fluorescent crack.
- 5. Measurement:** record the indication's width or length based on the corresponding marking. This data is used for quality control to ensure compliance with the standards required, for example, by Pratt & Whitney.
- 6. Final cleaning:** clean the comparator after use in order to ensure it remains intact for future inspections.

IMPORTANT INFORMATION

- **Handle with care:** handle the comparator with care to avoid scratches, as these could damage the markings and adversely affect measurements.
- **Maintenance:** use separate TAM 135273 for different penetrant systems in order to avoid cross-contamination and to ensure reliable results. Check the comparators periodically.

AVAILABLE MODELS

PART NUMBER	DESCRIPTION	REF.
04099809	TAM 135273 Cracks Comparator	98.5



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