

550 TRIP CASTING TESTING PROCEDURES

1. Using the slides on the test unit, move the Dial Indicators to a neutral position to ensure there is no restriction when installing the casting to be tested.
2. Clean Casting Bore.
 - a. Ensure the bore on the casting is clean.
 - b. Remove any dirt/dust particles with a low pressure air gun or a brush.
3. Installing casting on test unit.
 - a. Place the casting on the mat between the two holding blocks.
 - b. Clean the OD of the holding pin.
 - c. Insert the holding pin into the bored hole.

Note: The holding pins are tapered and act as a GO/NO GO Gauge. If the pins fully penetrate this deems the casting unusable.

- d. Repeat "c" for other side.

Note: When inserting pins use minimal pressure, excessive pressure will cause taper lock.

4. With a bristle brush sweep off any dust from the back side of the casting.
 - a. Make sure to sweep dirt towards bore of casting so that the dirt does not get in the dial slides.
5. Place the proper testing block on top of the casting.
 - a. There are blocks for the 350, 550 and 650 Trip Castings.
6. Use the provided vice grips to firmly clamp the test block.
 - a. Clamp the vice grip on the reference clamp point on the test block.
 - b. Failure to clamp on the reference point will give an inaccurate reading.
7. Set the Dial Indicators for calibration.
 - a. Set the Dial Indicators so they are exactly 90° to the test block surface. (Failure to do this will give inaccurate readings).
 - b. Set so dial may register positive and negative reading. (Middle of stroke).
 - c. Set dial face at zero - only to be done at end or edge.
 - d. Slide dial #1 from edge to edge - record variance.
 - e. Slide dial #2 from end to end - record variance.
8. The acceptable tolerances are listed on the engineered drawings posted on the walls of the test room.

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INSPECTORS RESPONSIBILITY

1. Dial Indicators, test blocks are not to be handled with dirty hands or gloves.
2. The door of the test room is to be closed at all times.
3. Practice good housekeeping at all times.
 - a. Inspection tools are to be cleaned before and after use.
 - b. Inspection tools are to be returned to their proper place when not used.
 - c. Inspection area and test unit are to be cleaned before and after use.