



AEROSPACE MATERIAL SPECIFICATION	AMS3046	REV. F
	Issued 1974-03 Revised 2009-04 Reaffirmed 2014-12 Superseding AMS3046E	
Magnetic Particles, Fluorescent Wet Method, Oil Vehicle, Aerosol Packaged		

RATIONALE

AMS3046F has been reaffirmed to comply with the SAE five-year review policy.

1. SCOPE

1.1 Form

This specification covers one type of fluorescent magnetic particles in the form of a mixed, ready-to-use suspension in an odorless, inspection oil vehicle and packaged in aerosol cans.

1.2 Application

This product has been used typically as the inspection medium in a wet, fluorescent magnetic particle inspection system as defined in AMS2640 or ASTM E 1444, but usage is not limited to such applications.

1.3 Safety - Hazardous Materials

While the materials, methods, applications, and processes described or referenced in this specification may involve the use of hazardous materials, this specification does not address the hazards which may be involved in such use. It is the sole responsibility of the user to ensure familiarity with the safe and proper use of any hazardous materials and to take necessary precautionary measures to ensure the health and safety of all personnel involved.

2. APPLICABLE DOCUMENTS

The issue of the following documents in effect on the date of the purchase order forms a part of this specification to the extent specified herein. The supplier may work to a subsequent revision of a document unless a specific document issue is specified. When the referenced document has been cancelled and no superseding document has been specified, the last published issue of that document shall apply.

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2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or 724-776-4970 (outside USA), www.sae.org.

AMS2640	Magnetic Particle Inspection
AMS2641	Vehicle, Magnetic Particle Inspection, Petroleum Base
AMS2820	Packaging, Aerosol
AMS3044	Magnetic Particles, Fluorescent, Wet Method, Dry Powder

AS5282	Tool Steel Ring for Magnetic Particle Inspection
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2.2 ASTM Publications

Available from ASTM International, 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959, Tel: 610-832-9585, www.astm.org.

ASTM D 1966	Test Method for Foots in Raw Linseed Oil (Gravimetric Method)
ASTM E 1444	Magnetic Particle Testing

3. TECHNICAL REQUIREMENTS

3.1 Material

The product shall be composed of durable fluorescent magnetic particles, which have been dyed or otherwise treated to attain the color specified. The particles shall be supplied mixed in the proper proportion with an inspection vehicle and packaged in aerosol cans.

3.1.1 Fluorescent magnetic particles shall conform to AMS3044.

3.1.2 Magnetic particle inspection vehicle shall conform to AMS2641.

3.2 Storage Life

The product shall meet the requirements of 3.3 when tested at any time up to 12 months from date of manufacture.

3.3 Properties

The product shall conform to the following requirements; tests shall be performed on the product supplied in accordance with specified test methods, using a test suspension prepared by spraying the complete contents of several aerosol cans into a clean container to produce at least 1 quart (1 L) of suspension, agitating the aerosol cans frequently to exhaust all particulate material:

3.3.1 Contamination

The product shall show no evidence of foreign material, agglomeration, or scum, determined by visual examination of the test suspension at the following times:

3.3.1.1 During preparation of the test suspension as in 3.3.

3.3.1.2 After mixing the test suspension, allowing it to stand for not less than 30 minutes, and agitating it slightly.

3.3.1.3 During tests to determine other characteristics of the product.

3.3.2 Concentration

The concentration of fluorescent magnetic particles in the freshly-sprayed suspension shall be 0.15 to 0.30 mL of fluorescent magnetic particles in 100 mL of suspension, determined by mixing the test suspension thoroughly, filling a 100 mL calibrated centrifuge tube as specified in ASTM D 1966, allowing it to stand undisturbed for at least 30 minutes, and reading, on the calibrated tube, the volume of the particles settled from the suspension.

3.3.3 Sensitivity

3.3.3.1 Ring Test

The product shall provide a seven-hole indication on the ring test specimen defined in AS5282, determined by placing the ring on a 1-inch (25-mm) diameter copper bar and circularly magnetizing the ring in a standard magnetic particle inspection unit by passing 2500 amperes of direct current through the bar immediately before flushing the ring with the agitated test suspension that has passed the contamination (3.3.1) and concentration (3.3.2) tests. Examine the ring in a darkened area under UV-A illumination of at least 1000 $\mu\text{W}/\text{cm}^2$ at the inspection surface. Visible light shall not exceed 2 foot-candles (20 lux) at the inspection surface.

3.3.3.2 Flaw-to-Background Test

Obtain a test part, or prepare a test specimen, containing flaws of the size expected to be found in routine inspection. The surface finish of the test specimen shall be representative of production parts. Magnetize and flush the specimen as specified in 3.3.3.1, using a sample of agitated test suspension that has passed the contamination (3.3.1) and concentration (3.3.2) tests. View the flaw indications in a darkened area under ultraviolet light as defined in 3.3.3.1. Indications shall be sharp and distinct. Background fluorescence around the flaws shall be of a level which will neither obscure the flaw indications nor cause difficulty in flaw detection.

3.4 Aerosol Spray Cans

The aerosol cans selected for test shall be maintained at room temperature for not less than 12 hours prior to testing. During testing, the aerosol can may be immersed in water at $77\text{ }^\circ\text{F} \pm 2$ ($25\text{ }^\circ\text{C} \pm 1$) periodically to maintain the container and its contents at room temperature.

3.4.1 Sprayability and Leakage

3.4.1.1 All aerosol pressure cans shall be equipped with a spray nozzle. The nozzle shall provide a fine, steady spray and shall deposit the product evenly on a flat or vertical surface. No chunks of solids shall be expelled and no clogging of the nozzle shall occur.

3.4.1.2 The characteristics of the spray pattern and the performance of the spray nozzle shall be evaluated by vigorously shaking the can for not less than 30 seconds with the contained pellet sounding on each shake and spraying a pattern on large sheets of newspaper or a similar surface to determine the coverage and evenness of the spray. After spraying several patterns, the nozzle shall be examined for evidence of chunks or solids and clogging. The can shall then be immersed for not less than 15 minutes in water at 126 to 129 $^\circ\text{F}$ (52 to 54 $^\circ\text{C}$); there shall be no visible evidence of leakage from, or distortion of, the pressurized container. The pressurized can shall then be immersed in water at $77\text{ }^\circ\text{F} \pm 2$ ($25\text{ }^\circ\text{C} \pm 1$) until the temperature has stabilized and, after vigorous shaking, two more patterns shall be sprayed. The spray characteristics shall have not changed and there shall be no chunking of particles or clogging of the nozzle.

3.4.1.2.1 CAUTION: DO NOT HEAT THE PRESSURIZED CAN OVER 129 $^\circ\text{F}$ (54 $^\circ\text{C}$).

3.4.2 Complete Expulsion

The complete usable portion of the contents shall have been expelled before the propellant is expended. The expelled contents shall be not less than 5 fluid ounces (50 mL) and the particle content shall conform to the aerosol spray requirements. Vigorously shake for not less than 30 seconds each unused can to be tested, with the contained pellet sounding on each shake, and expel the contents in a series of short blasts into a clean glass container graduated in ounces (mL) in such a manner that the entire contents of the can will be retained in the glass container. The aerosol can may be immersed periodically in water at $77^{\circ}\text{F} \pm 2$ ($25^{\circ}\text{C} \pm 1$) to maintain the can and its contents at room temperature. Repeat the vigorous shaking and short blasts until there is no further escape of gas.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for Inspection

The vendor of the product shall supply all samples for vendor's tests and shall be responsible for the performance of all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the product conforms to the specified requirements.

4.2 Classification of Tests

4.2.1 Acceptance Tests

All technical requirements of this specification, except storage life (3.2), are acceptance tests and shall be performed on each lot.

4.2.2 Preproduction Tests

All technical requirements of this specification are preproduction tests and shall be performed prior to or on the initial shipment of product to a purchaser, when a change in material and/or processing requires reapproval as in 4.4.2, and when purchaser deems confirmatory testing to be required.

4.3 Sampling and Testing

Shall be as follows:

4.3.1 For Acceptance Tests

Sufficient product shall be taken at random from each lot to perform all required test. The number of determinations for each requirement shall be as specified in the applicable test procedure or, if not specified therein, not less than three.

4.3.1.1 A lot shall be all product produced in a single production run from the same batches of raw materials under the same fixed conditions and presented for vendor's inspection at one time. A lot may be packaged in smaller quantities and delivered under the basic lot approval provided lot identification is maintained.

4.3.2 For Preproduction Tests

As agreed upon by purchaser and vendor.

4.4 Approval

4.4.1 Sample product shall be approved by purchaser before product for production use is supplied, unless such approval be waived by purchaser. Results of tests on production product shall be essentially equivalent to those on the approved sample.