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Title: Visual Inspection of Ultrasonic Calibration Blocks

1 Scope

Work Instruction for the visual inspection of ultrasonic calibration blocks.

2 Preparation

The visual inspection shall be carried out using the minimum of Category 'B' instruments.

Equipment required:

- 1000mm (or longer) straight edge
- Set of feeler gauges
- 10mm numeric stamps
- Brass wire brush

The 1000mm straight edge and feeler gauges shall have been checked against a Category 'A' reference straight edge. This shall have a current and valid checking record and be recorded as a Cat B item in the Calibration Database.

3 Method CB87

3.1 This check shall be performed by either a level 2 ultrasonic competent person or a technically competent person nominated by the Route Asset Manager Track.

3.2 Check that the identification number is clearly visible.

3.3 Check that the calibration label is in date

3.4 Check there is no surface corrosion. It is not expected to have highly polished surfaces, but the surface should be clean and free from contaminates and corrosion pitting. Where corrosion exists and it is not possible to remove with a **brass** wire brush, the block shall be quarantined and sent for refurbishment / calibration to a Network Rail approved calibration house. The calibration block shall be stored in a lightly oil impregnated rag to minimise surface corrosion.

3.5 Check for surface damage to the calibration blocks, paying particular attention to areas where "corner reflectors" are used to set sensitivity and where the transducer makes contact with the block. Where indentations/bruises greater than 2mm in diameter exist, the block shall be sent to a Network Rail calibration house for repair.

3.6 Results shall be recorded on the calibration form (see Appendix A) and retained for audit purposes

4 Method CB91

4.1 This check shall be performed by either a level 2 ultrasonic competent person or a technically competent person nominated by the Route Asset Manager Track.

4.2 Check that the identification number is clearly visible.

4.3 Check that the calibration label is in date.

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