



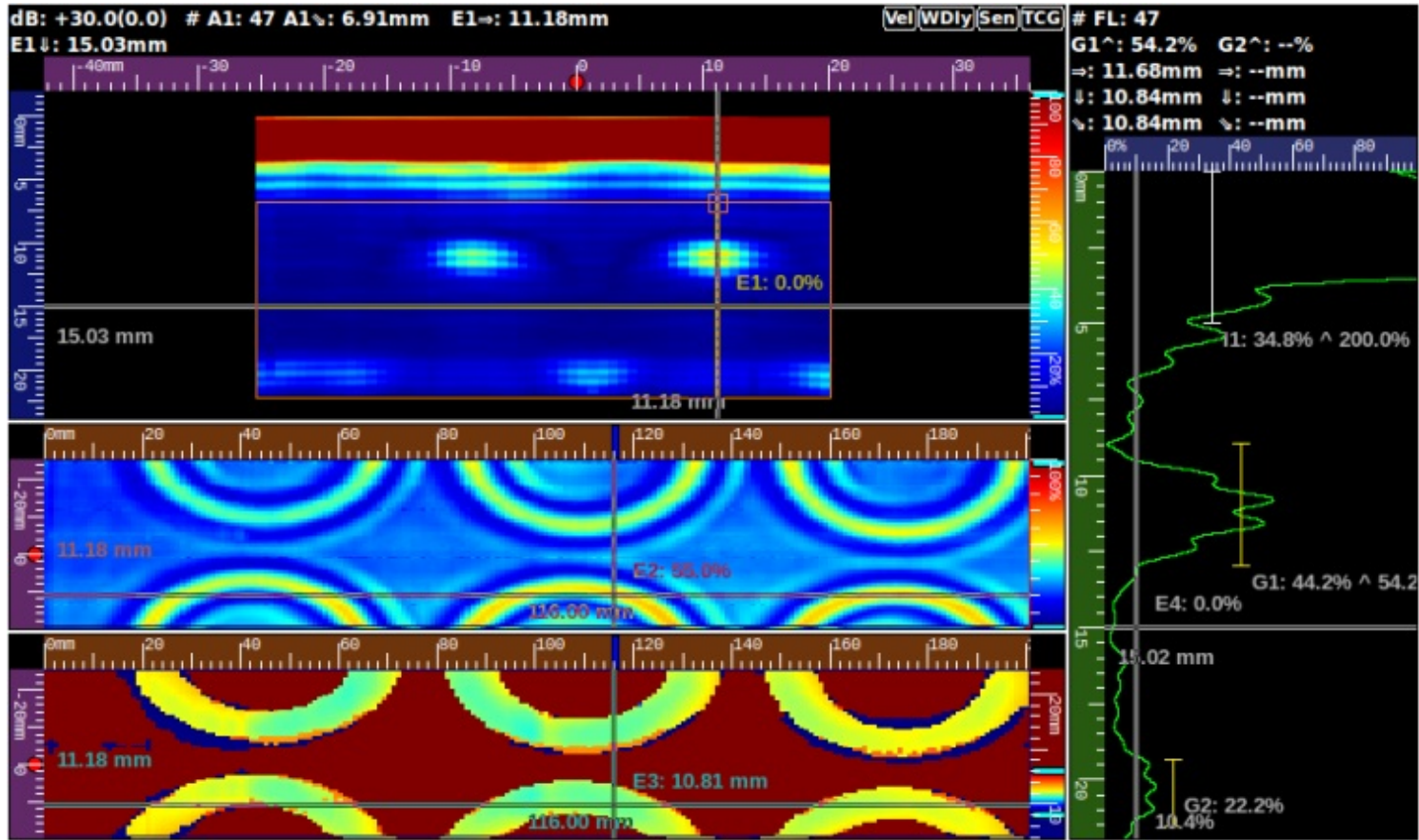
# Veo Inspection Report



Software : 3.1.31.dev5249

Component	Config File Name	File Vers.	Operator	Procedure Ref	Inspection Date
	Example_WheelProbe_2.25M64E0.8P_IFT_0005.utdata	1.1			2010-11-12 10:15:29

N/A	G1 ^ %FSH	G1 ^ ↓	G1 ↓ Start	G1 ↓ Stop	G2 ^ %FSH
	54.2%	10.84 mm	8.99 mm	13.01 mm	--



Legend :

L1	A	Abbrev.	Description
TOP1	1	BPL	Path Length
TOP1		D	Depth
		SD	Surface Dist.
		A	Amplitude

\*[Filter, Smoothing, Sub-Sampling]

Inspection	Info
Acq Freq / MaxRate	100 MHz, 20.0 Hz
Voltage Phased Ar.	100 V
Probe 1 [Freq, Model]	2.25 MHz, Sonatest-WheelProbe
Wedge 1 [Velo, Model]	1.500 mm/μs, WheelProbe

Encoder Info	
Encoding Setup	Scan Axis Only
Enc. Name	N/A
Scan Enc Resol.	14.350 ticks/mm
Part	Info
Material	Steel
Velocity [LW/SW]	6.320 mm/μs, 3.240 mm/μs
Thickness	16.00 mm
Weld	None

Scan / Cursor	Value1	Value2	Value3	Value4
S1 L-Scan/A1	BPL 6.91 mm	D 6.94 mm	SD 11.31 mm	0.00°
S1 L-Scan/E1	BPL 15.02 mm	D 15.03 mm	SD 11.18 mm	0.00°
S1 Top View/E2	---	---	SD 11.18 mm	S.Axis 116.00 mm
S1 Top View/E3	---	---	SD 11.18 mm	S.Axis 116.00 mm
S1 A-Scan/I1	BPL 0.00 mm	D 0.00 mm	0.00°	Level 34.8%
S1 A-Scan/G1	BPL 10.84 mm	D 10.84 mm	SD 11.68 mm	Peak 54.2%
S1 A-Scan/G2	N/A	N/A	N/A	N/A
S1 A-Scan/E4	BPL 15.02 mm	D 15.03 mm	0.00°	Level 10.4%

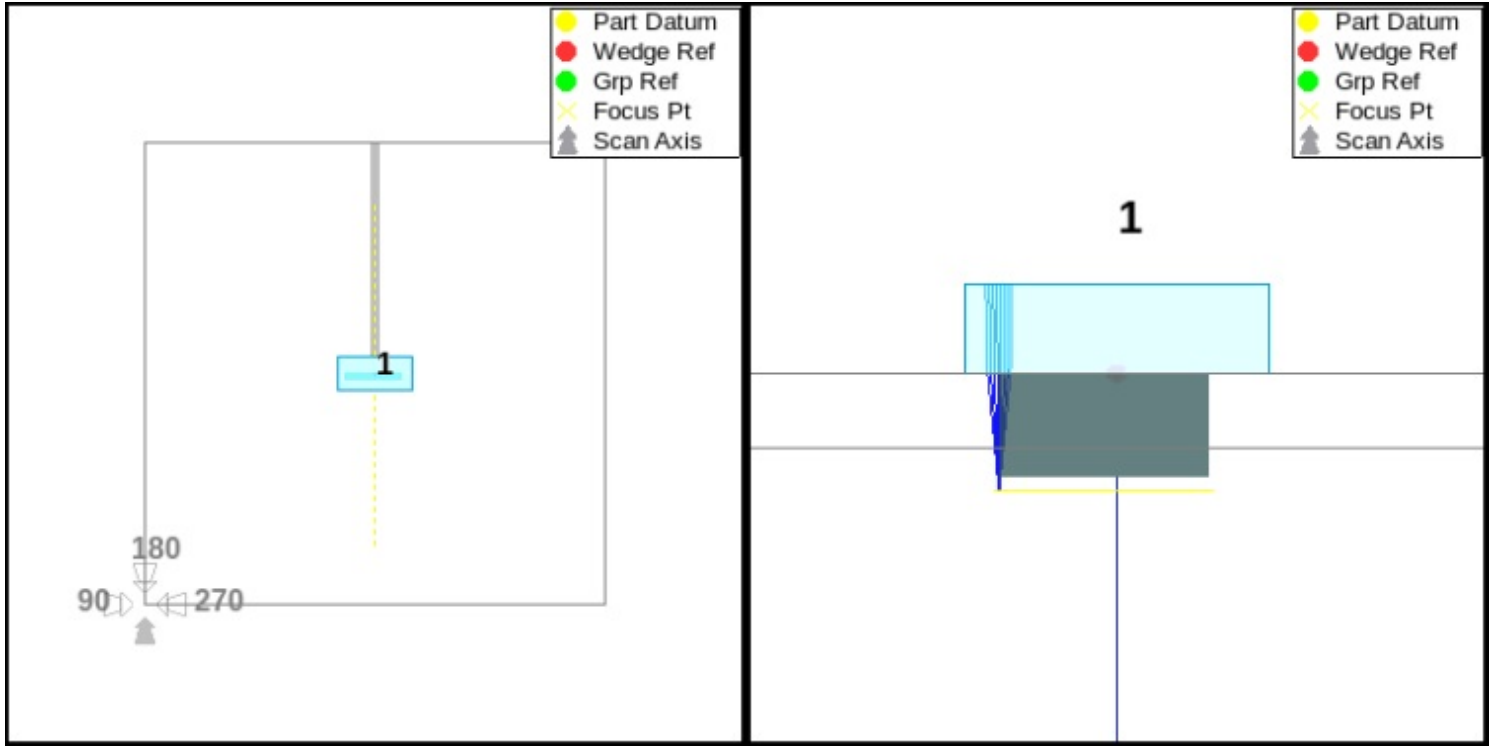
Scan S1 - Linear	Value
Signal Processing*	Yes
Velocity LW	6.320 mm/μs
Gain , Ref	30.0 dB, 0.0 dB
Focal Distance	25.00 mm, No
Start/Stop Path	22.00 mm
Angle / Element #	0.00°, 8
PRF	15000 Hz



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Inspection					
Probe Qty	1	Alarms	Off	Qualification	none
Scan Qty	1	Encoded Axis Ref.	Wedge Reference	Procedure Ref	N/A
Voltage Phased Ar.	100 V	Job/Customer	N/A	Couplant	N/A
Acq. Freq.	100 MHz	Site	N/A	Trigger	Encoder
Max Frame Rate	20.0 Hz	Operator	N/A		

Probe P1 - Phased-Array 1D					
Type	Phased-Array 1D	Pulse Width	222.22 ns	Elmt Size Dim 2	6.40 mm
Manufacturer	Sonatest	Nb Elmt Dim 1	64	Elmt Offset Dim 2	8.60 mm
Model #	Sonatest-WheelProbe	Elmt Pitch Dim 1	0.80 mm	Element Layout	Bottom Left Row
Serial #	N/A	Elmt Size Dim 1	0.76 mm		
Frequency	2.25 MHz	Elmt Offset Dim 1	3.20 mm		

Wedge P1 - Phased-Array 1D					
Type	Flat	Contact Surface	Planar	Probe Back Dist	1.00 mm
Manufacturer	Sonatest	Height	19.00 mm	Probe Side Dist	0.00 mm
Model #	WheelProbe	Width	29.20 mm	Probe Inset	0.00 mm
Serial #	N/A	Length	65.00 mm	Wedge Velocity LW	1.500 mm/μs

Part					
Material	Steel	Thickness	16.00 mm	Velocity SW	3.240 mm/μs
Component	N/A	Velocity LW	6.320 mm/μs	Weld	None
Serial #	N/A	Velocity SW	3.240 mm/μs		
Location Ref	N/A	Cal. Block Serial #	N/A		



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## Scan S1 - Linear

Type	Linear PE	PRF	15000 Hz	First Elmt TX	1
Gain , Ref	30.0 dB, 0.0 dB	Sub-Sampling	1:1	Last Elmt TX	64
Focal Dist	25.00 mm	Smoothing	Yes	First Elmt RX	1
Angle	0.00°	Filter	2.25 MHz	Last Elmt RX	64
Nb Active Elmt	8	Signal Rectification	Full	Beam Qty.	57
Range Path	22.00 mm	IFT Active	Yes	Sample Qty.	700
Stop Path	22.00 mm	IFT Start	0.00 µs	Path Res.	31.8 spl/mm
Double Res	No	IFT Range	1.58 µs	Wedge Delay Cal Status	None
Delay	0.00 µs	IFT Threshold	34.81%	Sensitivity Cal Status	None
Wave Mode	LW Velocity	Probe TX/RX	P1 - Phased-Array 1D	TCG Cal Status	None
Travel Mode	Half Path	Probe RX	P1 - Phased-Array 1D	Velocity Cal	None

## Geometry

W1 Index Off.	0.00 mm	W1 Rotation	90.0°	Encoder Area CL Offset	0.00 mm
W1 Scan Off.	0.00 mm	Encoder Area CL Pos	0.00 mm	Encoder Area Rotation	0.00°

## Encoder parameters

Encoding Setup	Scan Axis Only	Scan Enc Resol.	14.350 ticks/mm	Scan Step	1.00 mm
Enc. Name	N/A	Scan Start Pos	0.00 mm	Scan Invert Dir	Yes
Scan Axis Name	X	Scan Distance	200.00 mm	Data File Size	15.52 MB
Scan Enc Type	Quadrature	Scan Stop Pos	200.00 mm	Max Phys. Enc. Speed	263.2 mm/s

S1 L-Scan	BPL	Depth	SD	Angle	Beam	Peak
Angular 1 (A1)	6.91 mm	6.94 mm	11.31 mm	0.00°	47	8.1%
SQ1[Top, Left]	---	6.81 mm	-25.38 mm	---	---	---
SQ1[Bot, Right]	---	22.23 mm	20.17 mm	---	---	---
Cartesian Extractor 1 (E1)	15.02 mm	15.03 mm	11.18 mm	---	---	N/A

S1 Top View	SD	Scan Axis	Amplitude
Cartesian Extractor 2 (E2)	11.18 mm	116.00 mm	55.0%

S1 Top View	SD	Scan Axis	Amplitude
Cartesian Extractor 3 (E3)	11.18 mm	116.00 mm	55.0%

S1 A-Scan	BPL	Depth	SD	Amplitude
IFT Gate 1 (I1)	---	---	---	34.8%
IFT Gate 1 (Peak)	0.60 mm	0.60 mm	11.68 mm	200.0%
Gate 1 (G1)	---	---	---	44.2%
Gate 1 (Peak)	10.84 mm	10.84 mm	11.68 mm	54.2%
Gate 2 (G2)	---	---	---	22.2%
Gate 2 (Peak)	N/A	N/A	N/A	N/A
Cartesian Extractor 4 (E4)	15.02 mm	15.03 mm	11.68 mm	10.4%
Delta (I1-G1)	---	---	---	-9.4 %
Delta (I1^G1^)	-10.25 mm	-10.25 mm	0.00 mm	145.8 %
Delta (I1-G2)	---	---	---	12.6 %
Delta (I1^G2^)	N/A	N/A	N/A	N/A
Delta (G1-G2)	---	---	---	22.1 %
Delta (G1^G2^)	N/A	N/A	N/A	N/A