

## PRODS AND CLAMPS



Part Number: 157662



Part Number: 169802



Part Number: 54975



Part Number: 622499



Part Number: 1865A

### PROD SETS

Magnaflux® Prod Sets provide the flexibility to inspect large and complex shaped parts. These handheld electrode sets are convenient for conducting sectional inspections of welds, castings, forgings and large fabrications. Comfortable, pistol style grips and out-of-the-way cable hookups make it easy to test large and oddly shaped parts that are not wet bench friendly.

#### Standard Prod Set Part Numbers

622088: For use with M-2000 series units

157662: For use with P-Units

#### Dual Prod Assembly Part Numbers

622499: Dual Horizontal Prod Assembly for use with M-Series

157781: Dual Horizontal Prod Set Assembly for use with P-Series

622085: Dual Vertical Prod Set for use with M-Series

622334: Solid Copper Replacement Tips



## INSTRUCTIONS

1. Connect prod set to the power pack using 4/0 cables with lug connectors. Connect the control plug from prod set to power pack to enable remote trigger button on the prods.
2. Rotate the prods at a 90° angle from their original position. This ensures that all discontinuities are visible.
3. If necessary, overlap placement of the prods to ensure sufficient surface coverage.

## SPECIFICATIONS COMPLIANCE

ASTM E709-08 (Section 6.4, 12.3.2)  
ASTM E1444/E1444M-12 (Section 6.2.7)  
BPVC (Section V, Article 7: T-752)

## CONTACT CLAMPS

Magnaflux® contact clamp accessories allow testing of parts that could not be placed in wet bench MPI units. Magnaflux spring loaded and heavy-duty contact clamps allow for the easier and more accurate inspection of tubing, bars and tubular assemblies such as aircraft engine mounts, fuselage sections and large welded structures. Connected to terminals by lugs and flexible cables, contact clamps can be used with parts up to 7" in diameter.

### Contact Clamps Part Numbers

1865A: Spring Loaded Contact Clamp for 1¼" - 2½" diameter parts. Replacement copper braid (p/n 14710)  
169802: Heavy-Duty Contact Clamp is used for parts up to 7" diameter.  
54975: Magnetic Leech - Permanent magnet with 4/0 eitherend connector attaches to part.  
1830: Contact Block, lug connections, used to connect cables to horizontal bench units

## INSTRUCTIONS

1. Use 4/0 cables to connect contact clamps or magnetic leech to power pack using lug connections.
2. If necessary, overlap placement of the clamp/magnetic leech to ensure sufficient surface coverage.

## SPECIFICATIONS COMPLIANCE

ASTM E709-08 (Section 12.3.2)  
ASTM E1444/E1444M-12 (Section 6.2.7)  
BPVC (Section V, Article 7: T-754.1)