



PSM-5

Variables in Process as used in panel evaluation

1. Operator Performance (Skill)
2. Preparation of Panel
3. Temperature in Work Area
4. Temperature of test panel
5. Temperature of Penetrant
6. Penetrant Manufacturer & Composition
7. Viscosity of Penetrant
8. Method of Application
9. Quality of In-Use Penetrant
10. Dwell Time in Penetrant (Min-Max)
11. Pre-wash
12. Water Quality
13. Temperature of wash water
14. Pressure of wash water
15. Angle of deflection
16. Distance from target
17. Wash Gun Nozzle (Size of water droplet)
18. Length of wash time
19. Emulsifier Temperature
20. Time of emulsification
21. Emulsification Concentration
22. Quality of In-Use Emulsifier
23. Agitation of emulsifier
24. Time from emulsifier Bath to Rinse
25. Water Wash Temperature
26. Water Wash Pressure
27. Angle of deflection
28. Distance from target
29. Wash Gun Nozzle
30. Length of wash time
31. Drying Method
32. Dry Temperature
33. Dry Time
34. Length of Rest Time before Developer
35. Developer Manufacturer
36. Developer Method
37. Application of Developer
38. Temperature of Panel at application
39. Length of Developer dwell
40. Inspection booth lighting (White Light)
41. Inspection booth lighting (Black Light)
42. Length of time for inspectors eyes to acclimate
43. Eyesight of inspector
44. Proper reference of comparison
45. Angle of Panel to Blacklight
46. Distance of Panel to Blacklight
47. Process performed on Line or in Lab

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