

Pipe End Testing (Function Option, only requires additional software)

At normal production testing speeds the untested end lengths that can be achieved are typically 150mm. These untested end lengths can be reduced to virtually zero by using a combination of the Unicorn Cluster Probe Block and controlling the speed of the production tubes at the nose and tail ends. As the tube enters the URP425/S the advance speed is reduced such that when the probe units are applied to the tube, the speed is about 5 metres/min; once the probes are applied and testing commences the tube is accelerated back to its normal testing speed as shown in Figure 8. Similarly at the end of the tube the advance speed is reduced such that when the probe units are lifted off the tube speed is about 5 metres/min. The attached schematic diagram (Figure 9) shows the probe application/test start and probe lift/test stop positions. It is anticipated that this method of testing would achieve untested end lengths of no more than 20mm(longitudinal) and the extra time required for testing would be about 10 seconds per tube.

管端探伤（功能选项，仅需增加 PLC 控制软件）

在正常生产检测速度下，典型的管端盲区长度为 150mm 。通过采用 Unicorn 探头组件的组合及控制管材两端的速度可使盲区长度减至零。当钢管进入 URP425/S 时，降低前进速度，当探头单元放到钢管表面时，速度大约为 5 米/分；一旦探头就位、探伤开始，钢管便加速至如图 8 所示的正常检测速度。同样地，在钢管尾端，降低前进速度，当探头单元被提升离开钢管时，管材速度大约为 5 米/分。附图 9 显示了探头放到钢管/开始检测和离开钢管/检测结束的位置。预计用此检测方法，盲区长度不超过 20mm(纵向)，所需增加的检测时间大约 10 秒/每根。

FIG. 9

Schematic of End Testing Method

Longitudinal + Transverse + Wall Thickness/Lamination Probe Block

