



Technical Data Sheet
PN: AZ-18031-211000 Rev. D

Scan Plan N°: UT-S-211-160
Revision A
Revision Date June 28, 2023

Page 1 of 9

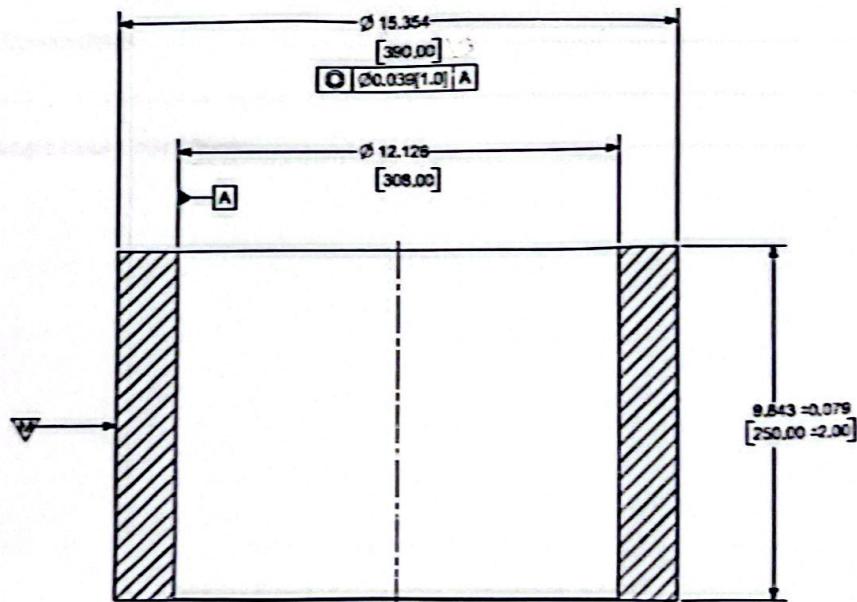
Customer: <i>Cliente:</i>	Israel Aerospace Industries (IAI)	Address: <i>Dirección:</i>	BEN GURION INT'L AIRPORT 70100
Testing Laboratory: <i>Laboratorio de prueba:</i>	FRISA Forjados	Address: <i>Dirección:</i>	Valentin G Rivero 127 Santa Catarina, NL, MX, 66150
Part Number: <i>Número de parte:</i>	AZ-18031-211000 Rev. D	Denomination: <i>Denominación:</i>	FORGING-5
Material: <i>Material:</i>	Ti 6-4	Criticality Class: <i>Clase crítica:</i>	Class A
Process Specification: <i>Especificación de proceso:</i>	AMS-STD-2154 Rev. E	Inspection extension: <i>Extensión de inspección:</i>	100%
Type Inspection: <i>Tipo de Inspección:</i>	Type 2 (Contact)	Inspection Technique: <i>Técnica de inspección:</i>	UT-S-211-160
Class: <i>Clase:</i>	A	Reference Procedure: <i>Procedimiento de referencia:</i>	NDT-I-025 Rev. 10

12. Surface Finish

13. Geometric Dimensioning

14. Cleaning

15. Surface finish after cleaning



A	Date	Scan Plan for raw material	Jorge Lara	Roni Levi	Signature	Date
Rev	Date	Description	Checked by	Approved by		
A	June 28, 2023			Roni Levi ASNT/NAS 410 LEVEL III		2/7/23

FRISA

 FRISA	Technical Data Sheet PN: AZ-18031-211000 Rev. D	Scan Plan N°:	UT-S-211-160
		Revision	A
		Revision Date	June 28, 2023
		Page 2 of 9	

Index

1. Scope:	3
2. Surface condition:	3
3. Identification:	3
4. Equipment:	3
5. Calibration:	3
6. Scanning Index:	3
7. Transfer check:	4
8. Calibration Verification:	4
9. Acceptance Criteria:	4
10. Reference Standard:	5
11. Scan Plan:	7
12. Part Number Dimensions:	8
13. Cleaning:	8
14. Step by step angle beam inspection:	8



Scan Plan N°:	UT-S-211-160
Revision	A
Revision Date	June 28, 2023
Page 7 of 9	

11. Scan Plan:

L-Wave _____

S-Wave

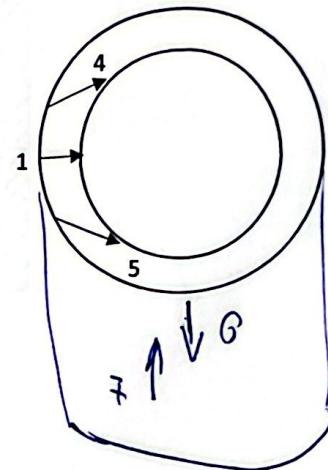
Face A



OD



Face B



Seq.	Surface	Beam Wave	Beam Direction	Sensitivity	Angle	Probe
1	Face A	Longitudinal	Axial	3/64" FBH DAC	0°	MSEB2
2	Face B	Longitudinal	Axial	3/64" FBH DAC	0°	MSEB2
3	OD	Longitudinal	Axial	3/64" FBH DAC	0°	MSEB2
4 & 5	OD	Shear	CW & CCW	3/64" FBH DAC	45°	MWB45-2
6 & 7	OD	Shear	CCW	3/64" FBH DAC	45°	MWB45-2