

## APE SERVICE BULLETIN

## DEEP FOUNDATION SOLUTIONS

VIBRATORY HAMMER • POWER UNIT • AUGER SYSTEMS • DIESEL & HYDRAULIC HAMMERS
• DRILL RIGS • HYDRAULIC PILING RIGS • WICK DRAIN INSTALLERS • LEAD SYSTEMS



## **#61 Cracked Clamp Inspection**

How to: Color Penetration Test.

- 1. Inspect to identify any hairline cracks. (see image 1.)
- 2. Remove all paint and foreign material. (see image 2.)
- 3. Clean clamp with Cleaner/Remover. (see image 2.)
- 4. Apply Penetrant. (see image 3.)
  - a. Allow 1 to 30 minutes before removing surface penetrant, depending on suspected crack.
- 5. Using a rag, spray the rag with cleaner/remover to remove excess surface penetrant.
- 6. Apply Developer. (see image 4.)
  - a. Allow 5 to 15 minutes, then inspect for red lines on surface for any cracks while red dots will mark pores.
- 7. If cracks are found, remove the attachment from service and contact your local APE representative.





Image 2.



Image 3.



Image 4.

