

ISO 24647:2023-02 (E)

Non-destructive testing - Robotic ultrasonic test systems - General requirements

Contents		Page
Foreword		v
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	Requirements for test personnel	2
5	Test system	2
5.1	General	2
5.2	Design principles	3
5.3	Test equipment	3
5.3.1	Instrument	3
5.3.2	Probes	3
5.3.3	Robots	3
5.3.4	Couplant	4
5.4	Typical test systems	4
5.4.1	Single-robot test system	4
5.4.2	Twin-robot test system	6
6	Characteristics and requirements for robotic ultrasonic test systems	9
6.1	General	9
6.2	Test technique	9
6.2.1	General	9
6.2.2	Pulse-echo technique	9
6.2.3	Trough-transmission technique	9
6.3	Planning of scan pattern and programming of robot motion control	9
6.3.1	General	9
6.3.2	Path planning method	9
6.3.3	Restrictions	12
6.4	Synchronisation of the acquisition of ultrasonic and position data	12
6.4.1	Synchronisation of ultrasonic signal and robot position	12
6.4.2	Synchronisation -- Minimum requirements	12
6.4.3	Synchronisation -- Optional requirements	13
6.5	Conditions for the application	13
7	Verification of the test system	13
7.1	General	13
7.2	Ultrasonic instrument and probes	14
7.2.1	General	14
7.2.2	Single-probe systems	14
7.2.3	Multi-probe systems	14
7.2.4	Normalization of pulse-echo systems	14
7.2.5	Normalization of through-transmission systems	14
7.3	Robots	14
7.4	Synchronization	15
7.5	Complete system -- Robots, instrument and probes combined	15
7.5.1	General	15
7.5.2	Signal-to-noise ratio	15
7.5.3	Image distortion coefficient	16

7.5.4	Detection sensitivity	16
8	Typical process of an automated test for a robotic ultrasonic test system	17
8.1	Preparation	17
8.2	Probes	17
8.3	Trajectory planning	17
8.4	Setup of the scanning reference coordinate system	17
8.5	Test procedure	17
9	Documentationoftheverificationresults	18
Annex A (informative)	Trajectory planning	19
Annex B (informative)	Exampleofaverificationreport	30
Bibliography	34