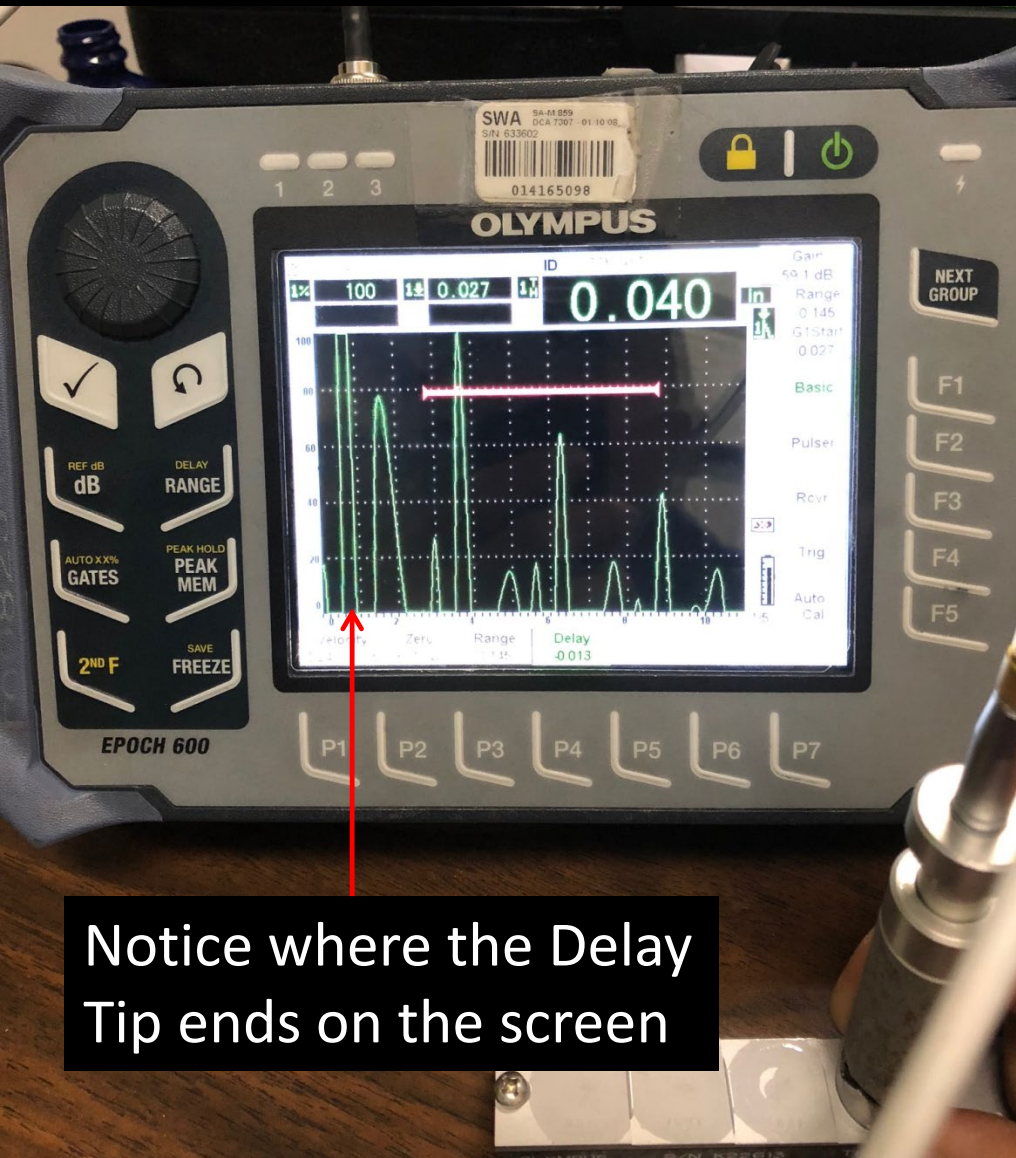


13 15  
 14 14  
 65 61  
 58 56  
 16 53  
 55 52  
 55 50  
 55 52  
 12 13 13  
 16 15 14  
 16 14

.078	.075	.074	.067	.063	.053	.054	.056	.066	.073	.074	.077			
.079	.075	.074	.067	.056					.073	.075	.076	.079	.079	
.077	.073	.074	.065	.058	.046	.045	.050	.066	.073	.076	.076			



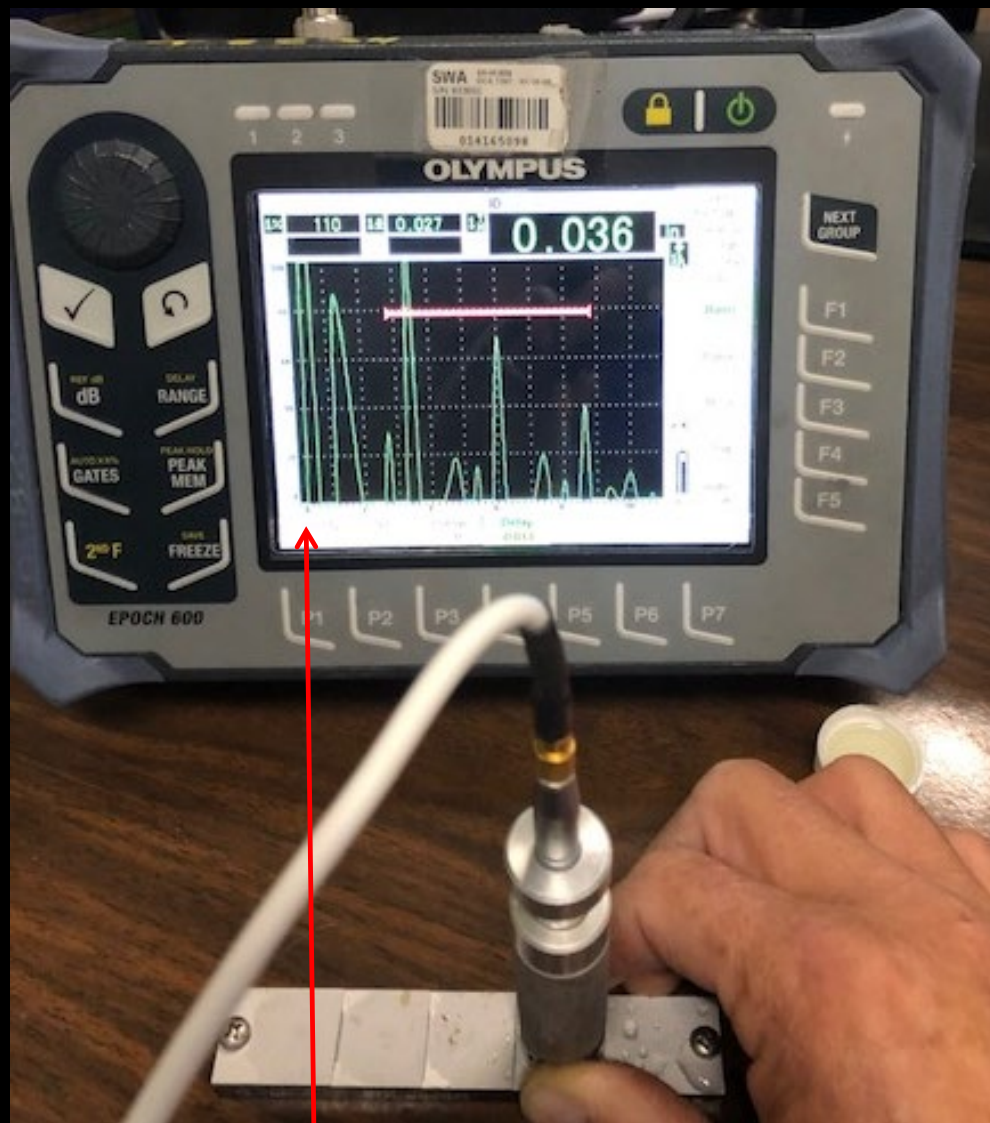


Notice where the Delay  
Tip ends on the screen

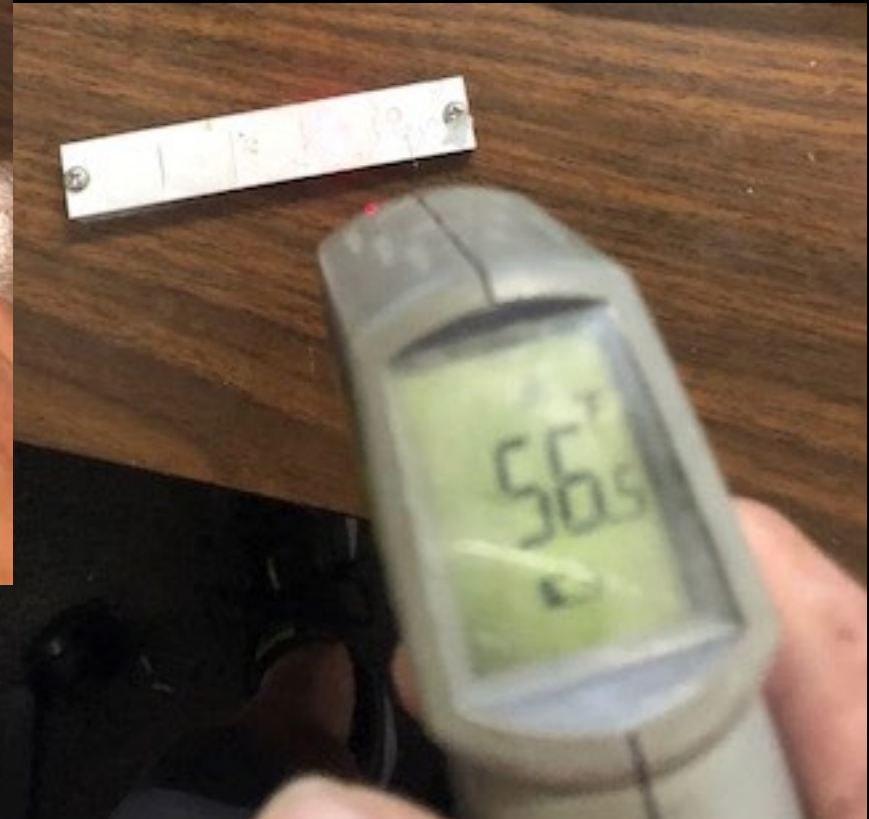
Room Temperature Calibration



# Calibration Block Cool

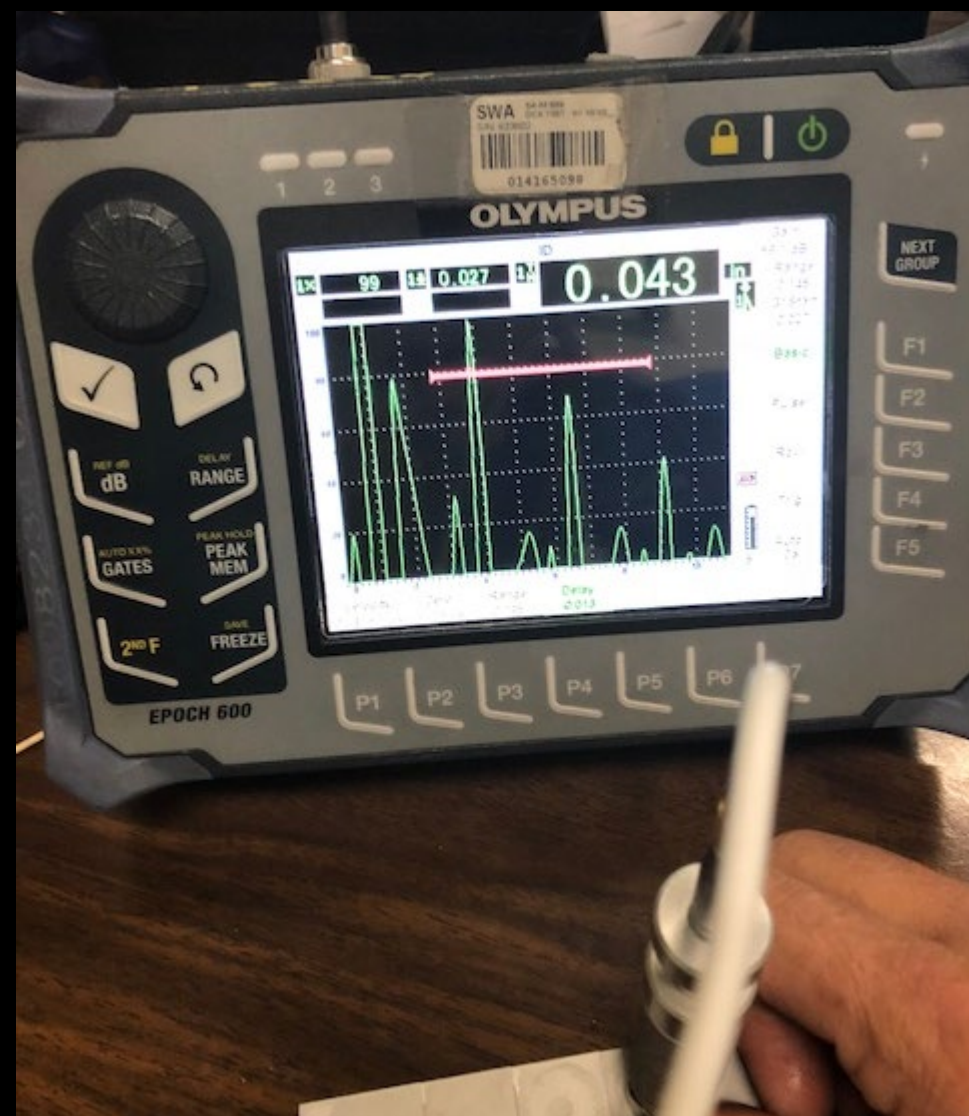


Notice where the Delay Tip ends on the screen when COOL. It has moved slightly left of calibrated.

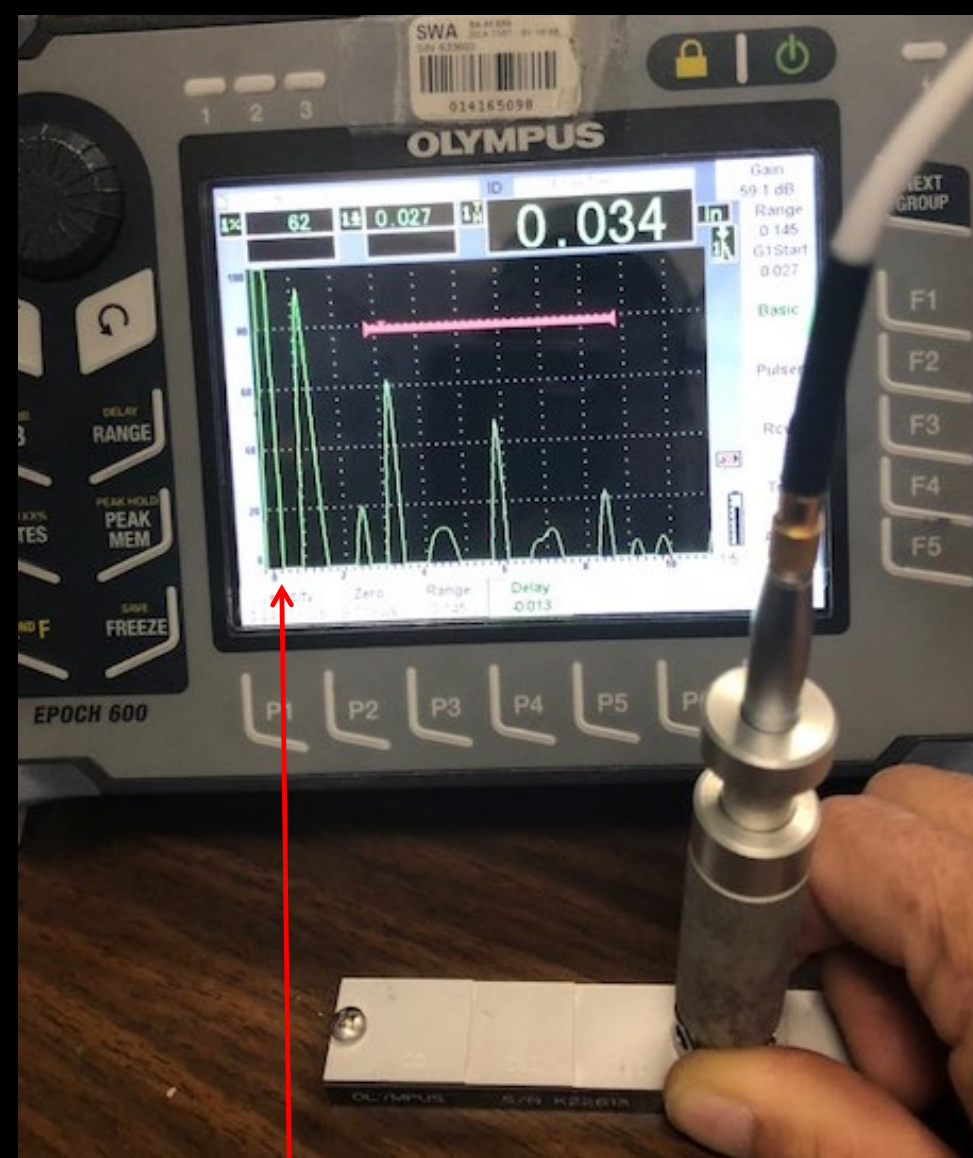




# Calibration Block Warm



Notice where the Delay Tip ends on the screen when WARM. It has moved slightly right of calibrated.

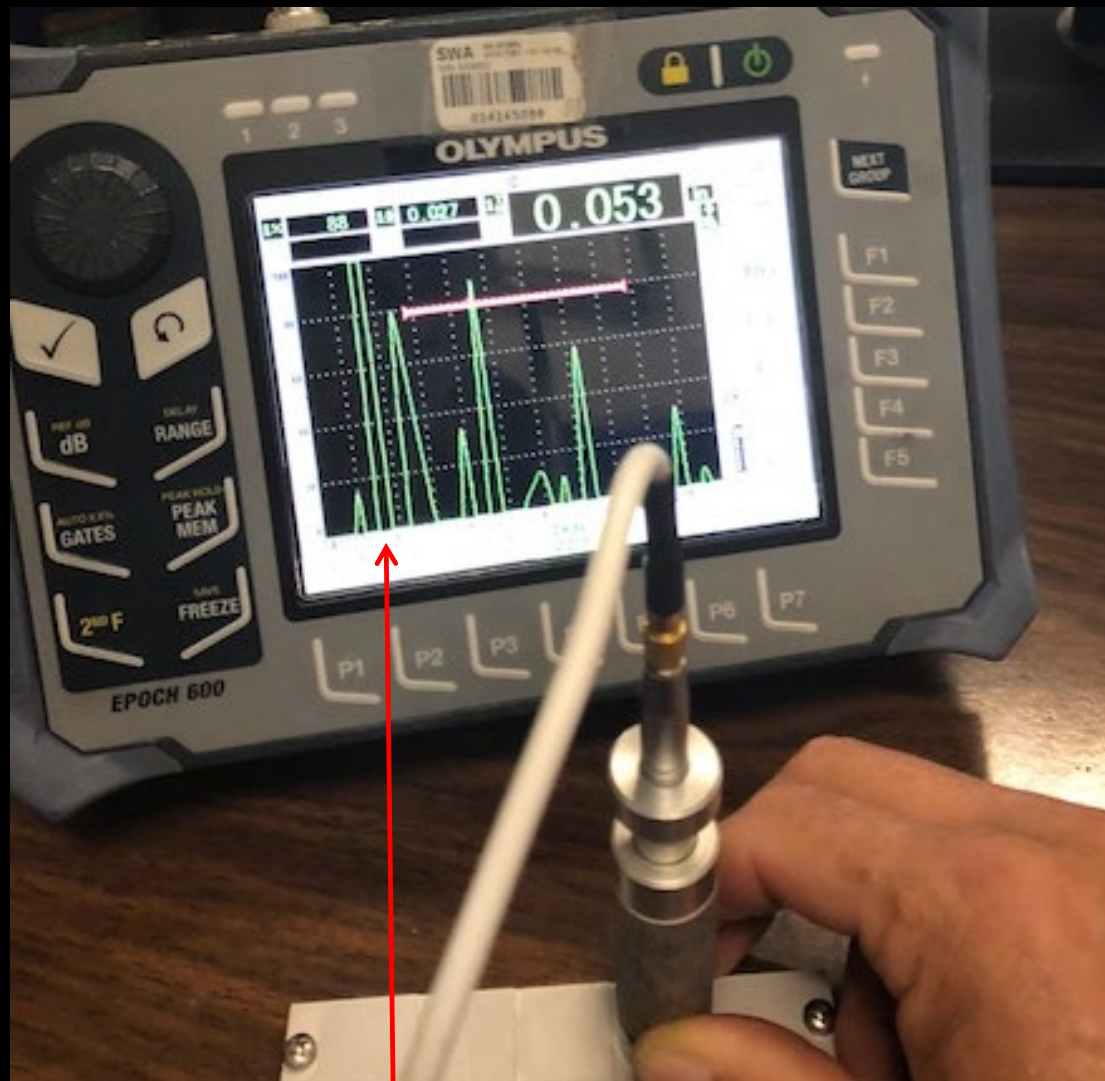


Tip Cold



Notice where the Delay Tip ends on the screen when COLD. It has moved a lot to the left of calibrated.

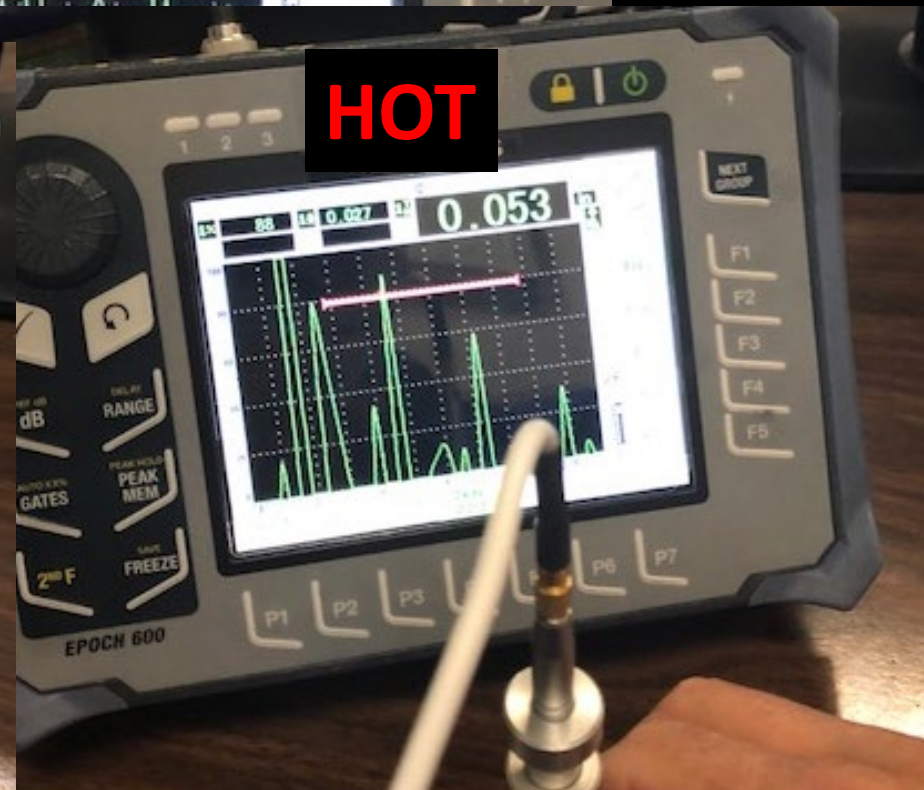
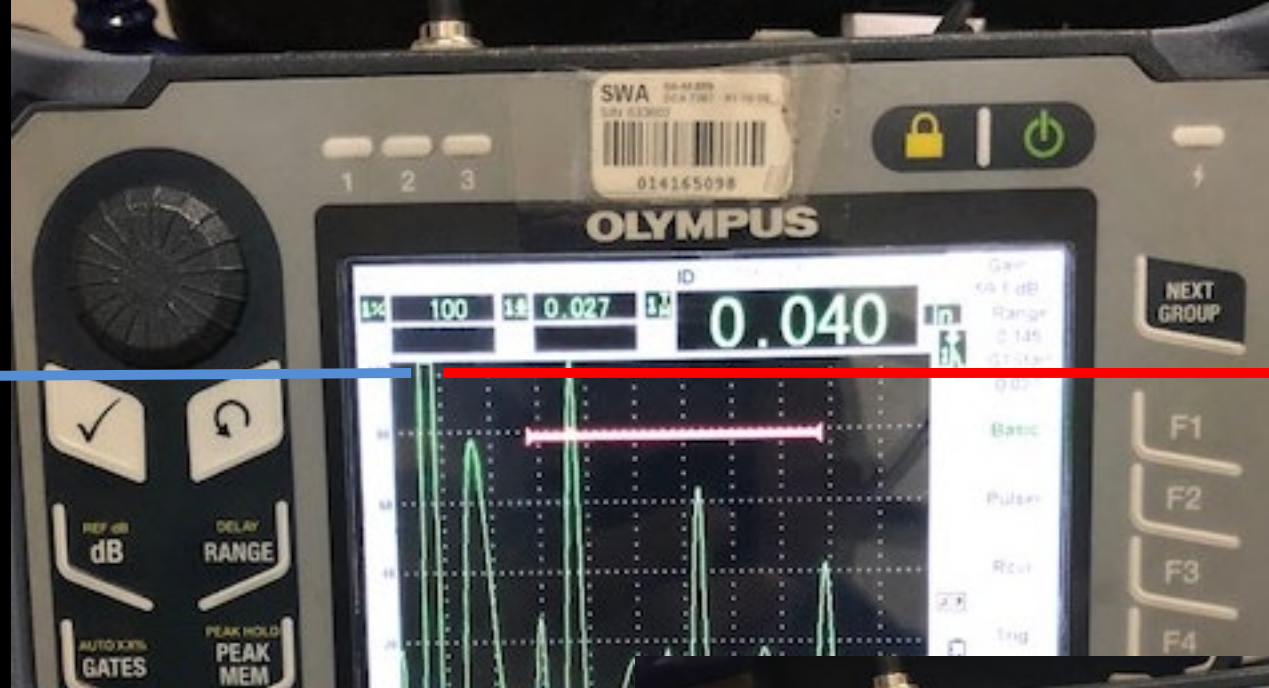




Tip Hotter



Notice where the Delay Tip ends on the screen when COLD. It has moved a lot to the right of calibrated.







OLYMPUS

SIN 633602  
014165098

1 2 3



EPOCH 600

P1 P2 P3 P4 P5 P6 P7

NEXT GROUP

F1  
F2  
F3  
F4  
F5

✓ ↺  
REF dB  
dB  
AUTO XX%  
GATES  
2ND F  
DELAY RANGE  
PEAK HOLD  
PEAK MEM  
SAVE  
FREEZE





# Key Takeaways

- **As the delay tip gets hotter or colder from the temperature during calibration the sound velocity within the tip changes.**
- **To prevent this issue causing measurement inaccuracy, allow the tip time to match the temperature of the part you plan to inspect before you calibrate.**
- **Another option is to use “Echo to Echo” measurements. This eliminates the tip in the distance equation.**

**Question or additional input:**