57640 North Eleventh Street
Calumet, MI 49913
Ph. (906) 337-3018
Fax (906) 337-2930
rel@relinc.com
www.relinc.com

REL TAM Panel - Twin
(Part Number: 250-00103)

Certification

REL certifies that REL TAM Panels are Hexavalent Chromium free.

Compliances met by REL TAM Panel plating: RoHS, REACH, WEEE, ELV, and Proposition 65.

Pratt & Whitney Approved TAM 146040-1 (Mirror/Polished Finish).

REL, Inc. is an officially approved P&W Source Manufacturer. REL, Inc. certifies that the Fluorescent Penetrant Inspection REL TAM Panel meets the requirements as stated in **TAM 146040-1, ASTM E1417, MIL-STD-6866, TO 33B-1-1, NAVAIR 01-1A-16-1, TM 1-1500-335-23, Rolls-Royce, and GE Aviation Process Specification P3TF47**. The REL TAM Panel has been manufactured and tested in accordance with the REL, Inc. procedure RWI-1105.

REL TAM Panel and Documentation includes:

1. REL Tam Panel in Tool Control System
2. Panel Certificate of Conformance (Sealed) **this document*
3. Penetrant System Monitoring Panel Documentation
    a. Serialized crack size certification document, including
    b. 1:1 Picture

REL TAM Panel Cleaning Procedure:

1. **Ultrasonically** clean in 98% methanol for 15 minutes,
    a. Alternate Cleaning Methods:
        i. Ultrasonically clean in Acetone
        ii. Ultrasonically clean in Isopropyl Alcohol
        NOTE: Do NOT use Oxidizing Chemicals to Clean panel
2. 15 minutes air dry,
3. Verify cleanliness:
    a. Use a LED UV-A lamp Certified to ASTM E3022. (See illustrations on 'ASTM E3022 Certified Inspection Lamps'. REL, Inc. document included for lamps approved for this purpose.)
    b. Inspect REL TAM Panel (5 places) at the intensity level of 3000 microwatts per centimeter squared to verify no residual fluorescent penetrant exists on the surface.

REL TAM Panel storage:

1. Store in dry packaging, or
2. Store in Acetone

REL TAM Panel Serial Numbers: 290714-176_A & 290714-176_B

Date of Certification: September 14, 2026

Certified by: RWB
Inspector

REL TAM Panel Processing Procedure:

Type 1 (Fluorescent Dye), Method D (Post-Emulsifiable, Hydrophilic), Form a (Dry Powder), Level 4 (Ultra-high sensitivity)

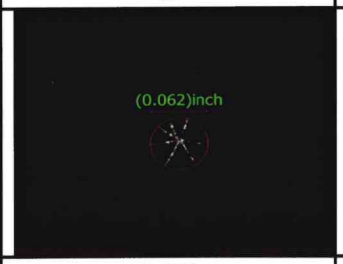
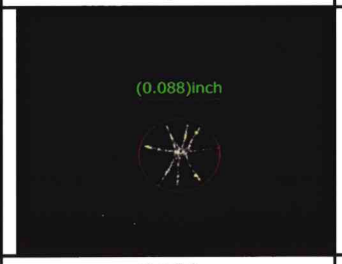
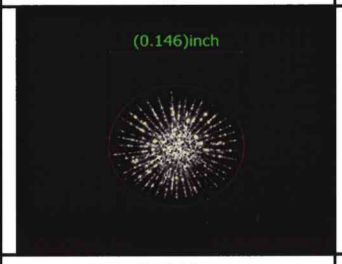
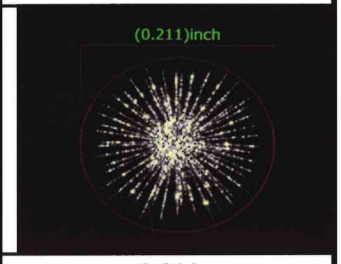
1. Clean panel to specified "REL TAM Panel Cleaning Procedure"
2. Apply Fluorescent Penetrant by brush
    a. Magnaflux Zyglo ZL-37 Level 4, Post-Emulsifiable, Fluorescent Penetrant
3. Penetrant Dwell: 20 minutes @ ambient temperature (50-90°F)
4. Penetrant Rinse: 1 minute maximum wash/rinse 90°F @ 20psi, 18" from part
5. Dip application Emulsifier/Remover:
    a. Magnaflux Zyglo ZR-10E Hydrophilic Emulsifier (Maximum 20% solution)
6. Emulsifier Dwell: 1 minute maximum in 20% ZR-10E Emulsifier solution
7. Emulsifier Wash/Rinse: 1 minute maximum wash/rinse 90°F @ 20psi, 18" from part
8. Oven Dry: Dry for 5 minutes @ 60°C (140°F)
9. Apply Dry Developer:
    a. Place panel in Developer Chamber
    b. Magnaflux Zyglo ZP-4D Dry Powder Developer (formerly ZP-4B)
    c. Agitate air in chamber to ensure complete coverage
10. Developer Dwell: 10 minutes
11. Remove excess Developer
    a. Air spray @ 5psi
12. Inspect, Measure, & Document Panel
    a. Pratt & Whitney TAM146040
    b. ASTM E1417
13. Lab environmental conditions
    a. Temperature 73 F
    b. Humidity 39%

NIST Traceable Process Instrumentation:

1. UV-A & White Light Meter
2. Mini alarm timer/stopwatch
3. Water pressure gauge
4. Water temperature gauge
5. Refractometer
6. Thermocouple
7. Dryer controller
8. Air pressure gauge
9. Keyence IM-8010 Microscope
10. UV-A inspection lamps
11. All instruments used during panel processing procedure are NIST Traceable

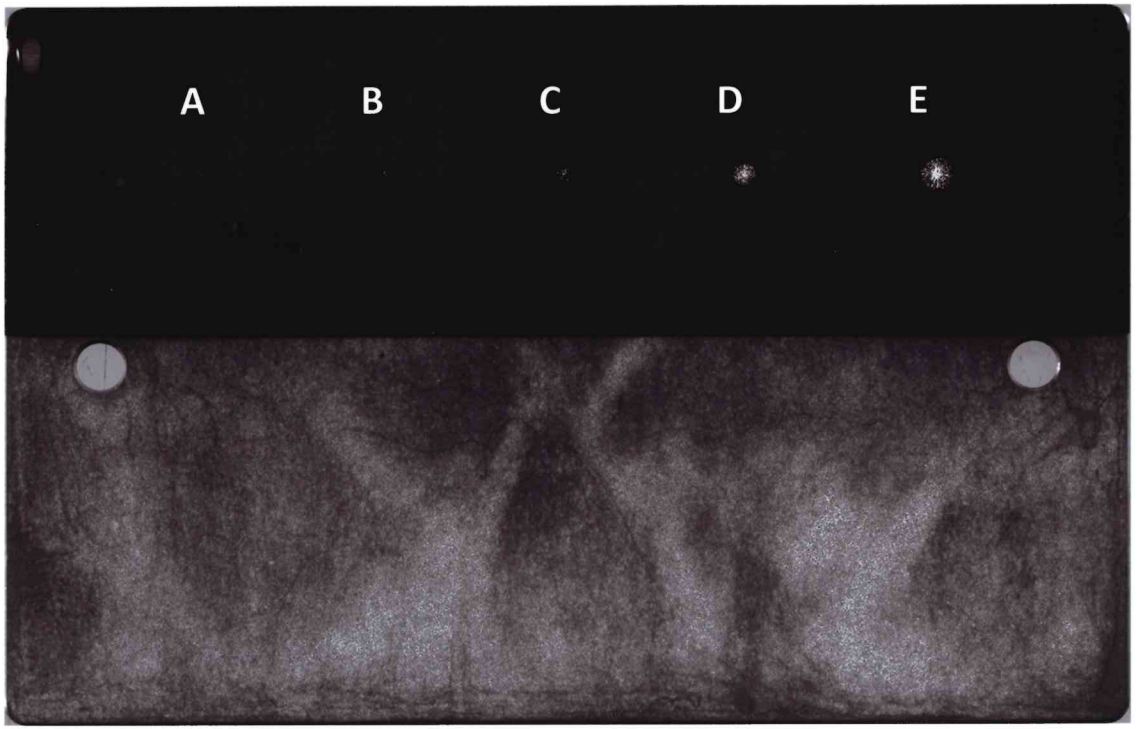
Penetrant System Monitoring Panel Documentation

SN# 290714-176_A

Crack Position	A	B	C	D	E
Photo of Defect Magnification Factor: 1 : 3.5					
Measured Size (Inch)	**0.031**	**0.062**	**0.088**	**0.146**	**0.211**
Specification (Inch)	0.015 - 0.031	0.046 - 0.062	0.075 - 0.093	0.125 - 0.171	0.180 - 0.250
Measured Size (mm)	**0.79**	**1.57**	**2.24**	**3.71**	**5.36**
Specification (mm)	0.38 - 0.79	1.17 - 1.57	1.91 - 2.36	3.18 - 4.34	4.57 - 6.35

Crack Depth	.0025" ± .0001"	63 µm ± 2.5µm

This panel has been tested to conform to all requirements of:
TAM146040-1



Measured with Keyence IM 8010
Calibration No. RM4133305C

Inspector: RWB

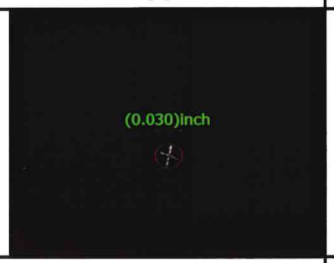
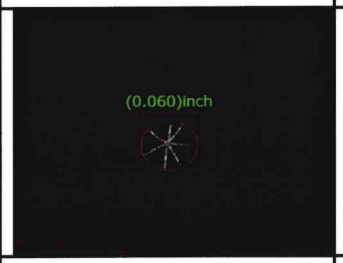
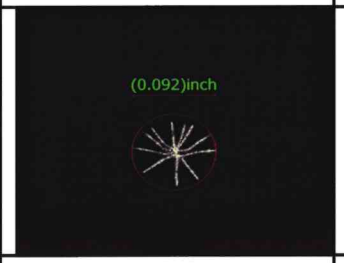
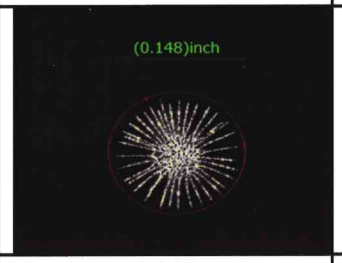
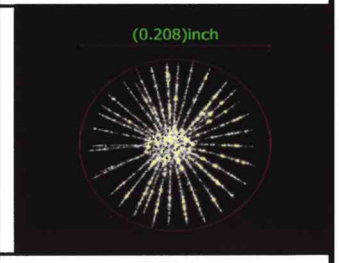
Date of Certification: 9/14/26

This panel does not contain hexavalent chromium.

This photo is actual size. (1:1)

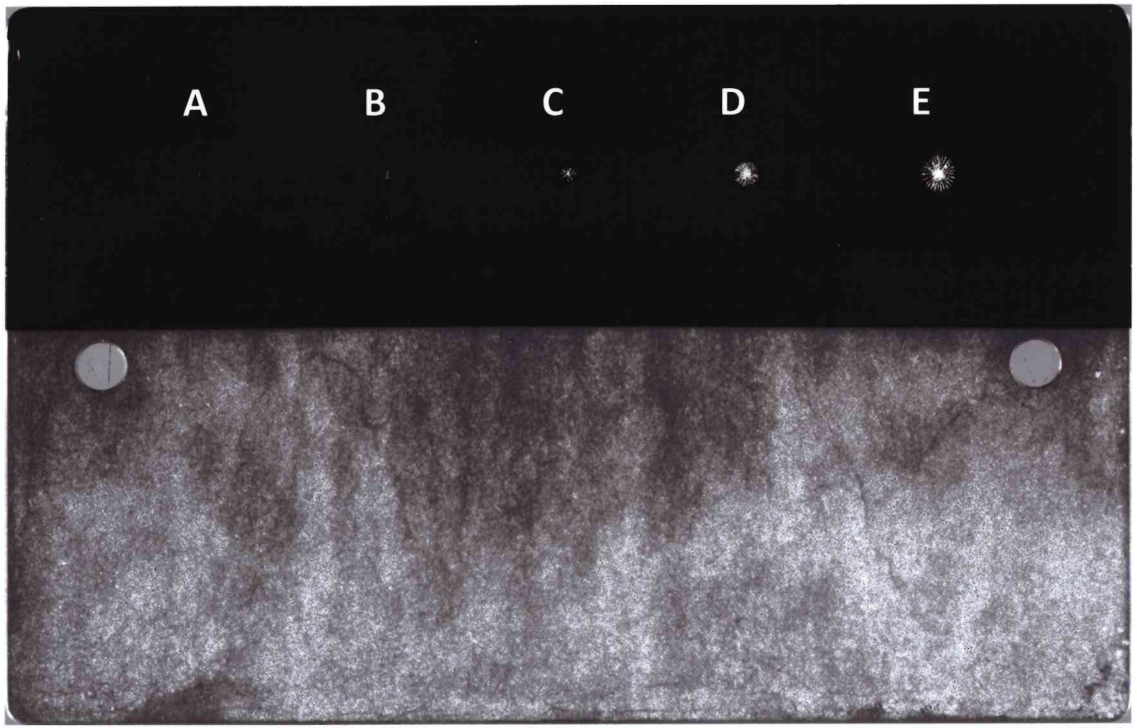
Penetrant System Monitoring Panel Documentation

SN# 290714-176_B

Crack Position	A	B	C	D	E
Photo of Defect Magnification Factor: 1 : 3.5					
Measured Size (Inch)	**0.030**	**0.060**	**0.092**	**0.148**	**0.208**
Specification (Inch)	0.015 - 0.031	0.046 - 0.062	0.075 - 0.093	0.125 - 0.171	0.180 - 0.250
Measured Size (mm)	**0.76**	**1.52**	**2.34**	**3.76**	**5.28**
Specification (mm)	0.38 - 0.79	1.17 - 1.57	1.91 - 2.36	3.18 - 4.34	4.57 - 6.35

Crack Depth	.0025" ± .0001"	63 µm ± 2.5µm

This panel has been tested to conform to all requirements of:
TAM146040-1



Measured with Keyence IM 8010
Calibration No. RM4133305C

Inspector: RWB

Date of Certification: 9/14/26

This panel does not contain hexavalent chromium.

This photo is actual size. (1:1)