6.5 Flux leakage — multiple transducer technique

When using the multiple magnetic transducer flux leakage technique, the reference tube shall contain a transverse reference notch on the external surface of the reference tube or, by agreement, a reference hole as listed in Table 1.

6.6 Dimensions of the reference standards

6.6.1 Reference hole

The diameter of the reference holes related to the tube outside diameter shall not exceed the requirements of Table 1; the holes shall be formed by machining, spark erosion or other methods.

Table 1 — Specified tube diameter related to the diameter of the reference holes

Specified tube outside diameter D mm	**Maximum hole diameter** Acceptance level mm
$4 \leqslant D \leqslant 15{,}8$	1,20
$15{,}8 < D \leqslant 26{,}9$	1,40
$26{,}9 < D \leqslant 48{,}3$	1,70
$48{,}3 < D \leqslant 63{,}5$	2,20
$63{,}5 < D \leqslant 114{,}3$	2,70
$114{,}3 < D \leqslant 139{,}7$	3,20
$139{,}7 < D$	3,70

For those products requesting a more severe inspection, e.g. for stainless steel pipes, by agreement between the customer and manufacturer, Table 2 may be adopted.

Table 2 — Specified tube diameter related to the diameter of the reference holes

Specified tube outside diameter D mm	**Maximum hole diameter** Acceptance level mm
$4 \leqslant D \leqslant 15{,}8$	1,00
$15{,}8 < D \leqslant 26{,}9$	1,20
$26{,}9 < D \leqslant 48{,}3$	1,40
$48{,}3 < D \leqslant 63{,}5$	1,70
$63{,}5 < D \leqslant 114{,}3$	2,20
$114{,}3 < D \leqslant 139{,}7$	2,70
$139{,}7 < D$	3,20