

CONTENTS

INTRODUCTION TO RADIOGRAPHY AND RADIATION TESTING	1	SECTION 1: RADIATION AND PARTICLE PHYSICS	62
INTRODUCTION	2	INTRODUCTION	63
PART 1, THE MANAGEMENT OF NDT AND ITS INFLUENCE ON PRODUCT QUALITY AND ECONOMICS	3	PART 1, INTRODUCTION TO ELEMENTARY PARTICLES	64
Effective NDT Application	4	The Electron	64
PART 2, QUALITY CONTROL AND QUALITY ASSURANCE	7	The Proton	65
Quality Assurance Program	7	The Neutron	65
PART 3, RELATION OF INDUSTRIAL AND MEDICAL RADIOGRAPHY	9	The Positron	66
PART 4, APPLICATIONS OF NONDESTRUCTIVE TESTING	10	The Neutrino	66
Summary	10	Mesons	66
Purpose	10	Other Particles	66
Mode of Presentation	10	Antiparticles	66
Technique Description Format	11	PART 2, NUCLEAR STRUCTURE	67
PART 5, NONDESTRUCTIVE TESTING TECHNIQUE CATALOG	13	Basic Elements	67
Technique Name Index	13	Isotopes-Isobars	67
Mechanical-Optical Technique Tables	25	PART 3, ATOMIC STRUCTURE	69
Penetrating Radiation Technique Tables	30	Basic Concepts	69
Electromagnetic-Electronic Technique Tables	33	PART 4, ELECTROMAGNETIC RADIATION	71
Sonic-Ultrasonic Technique Tables	38	The Photon	71
Thermal Technique Tables	44	X Rays and Gamma Rays	71
Chemical-Analytical Technique Tables	45	Generation of X Rays	72
Image Generation Technique Tables	49	Generation of Gamma Rays	73
Image Analysis Technique Tables	56	Natural Radioactive Substances	74
REFERENCES	57	Artificially Produced Radioactive Isotopes	75
BIBLIOGRAPHY	61	PART 5, RADIATION ABSORPTION	76
		Categories of Absorption	76
		Absorption of Photons	76
		Scattering of Photons	77
		Attenuation Coefficients of the Elements	80
		Attenuation Coefficients of Compounds and Mixtures	80
		PART 6, ABSORPTION OF CHARGED PARTICLES	81
		Mechanisms of Absorption	81
		Ionization	81

Bremsstrahlung	82	Inverse Square Law	122
Scattering of Charged Particles	83	Half-Value Layer	122
PART 7, SECONDARY RADIATION	85	PART 3, SPECIFIC ISOTOPES	
Sources of Secondary Radiation	85	FOR RADIOGRAPHY	124
Thick Target Bremsstrahlung	85	Selection of Radiographic Sources	124
PART 8, NEUTRON IRRADIATION	87	Cobalt-60	124
Production of Neutrons	87	Iridium-192	126
Neutron Absorption Process	87	Thulium-170	127
Nuclear Cross Sections	88	Cesium-137	129
REFERENCES	90	PART 4, SOURCE HANDLING	
		EQUIPMENT	131
SECTION 2: CONVENTIONAL		Requirements	131
ELECTRONIC RADIATION		Classification	131
SOURCES	91	Manual Manipulation of Sources	132
INTRODUCTION	92	Remote Handling Equipment	132
PART 1, PHYSICAL PRINCIPLES	93	Reliability	136
Conservation of Energy	93	Safety Considerations	137
Bremsstrahlung	93		
Characteristic X Rays	93	PART 5, RADIOISOTOPES FOR	
Thermionic Emission	94	OTHER TESTING METHODS	142
Absorption	95	Other Testing Methods	142
PART 2, BASIC GENERATOR		Transmission Gages	142
CONSTRUCTION	96	Backscatter Gages	143
X-ray Tubes	96	Neutron Gages	143
High-Energy Sources	101	X-ray Emission Gages	145
Control Unit	106	PART 6, TRANSPORTATION OF	
PART 3, GENERAL OPERATING		RADIOGRAPHIC SOURCES	147
RECOMMENDATIONS	108	Introduction	147
Baseline Data	108	Classification	147
Selecting a Unit	109	Containers	147
Tube Warm-up	109	Radiation Levels	148
Maintenance	110	Shipping Labels	148
Electrical Safety	110	REFERENCES	149
Radiation Safety	110	BIBLIOGRAPHY	150
BIBLIOGRAPHY	112		
SECTION 3: ISOTOPE RADIATION		SECTION 4, RADIATION DETECTION	
SOURCES	113	AND RECORDING	152
PART 1, RADIOACTIVITY	115	INTRODUCTION	153
Historical Background	115	PART 1, BASIC PRINCIPLES	154
Natural Radioactivity	115	PART 2, GAS IONIZATION	
Half-Life	115	DETECTORS	155
Artificially Produced Radioisotopes ...	117	Principles of Ionization	155
Disintegration Mechanisms	118	Ionization Chambers	155
Secondary Processes	119	Output Current Measurements	156
PART 2, MEASUREMENTS OF		Vibrating Reed Electrometers	157
ISOTOPES	121	Integrating Instruments	157
Definitions	121	Personnel Monitoring Instruments	158
		Proportional Counters	159
		PART 3, GEIGER MUELLER	
		COUNTERS	161

Operating Voltage Level	161	The Reciprocity Law	200
Properties	161	Exposure Factor	201
Resolving Time	161	Determination of Exposure	
Dead Time	161	Factors	201
Quenching	162	Contrast	202
Design Variations	163	Choice of Film	202
Personnel Monitors	163	Radiographic Sensitivity	202
Applications	163	PART 2, ABSORPTION AND	
PART 4, SCINTILLATION		SCATTERING	203
DETECTORS	165	Radiation Absorption in the	
Scintillation Process	165	Specimen	203
Materials and Characteristics	165	Scattered Radiation	205
Photomultiplier Tubes	166	Reduction of Scatter	206
PART 5, THERMOLUMINESCENT		Mottling Caused by X-ray	
DOSIMETRY	167	Diffraction	211
LiF Properties	167	Scattering in 1- and 2-Million Volt	
TLD Readout Systems	168	Radiography	212
PART 6, NEUTRON DETECTION	169	PART 3, RADIOGRAPHIC SCREENS	213
Characteristics	169	Functions of Screens	213
Neutron Sources	169	Lead Foil Screens	213
Neutron Detectors	169	Lead Oxide Screens	216
PART 7, SEMICONDUCTORS	171	Fluorescent Screens	217
Diffused <i>p-n</i> Junction Detector	171	PART 4, INDUSTRIAL X-RAY FILMS	219
Surface Barrier Detectors	171	Selection of Films for Industrial	
Lithium Drifted Detectors	173	Radiography	220
PART 8, RECORDING THE		Photographic Density	221
RADIOGRAPHIC LATENT IMAGE	174	Densitometers	221
Introduction	174	X-ray Exposure Charts	221
Radiographic Latent Images	176	Gamma-ray Exposure Charts	224
Development	177	The Characteristic Curve	224
Contrast	178	PART 5, RADIOGRAPHIC IMAGE	
Influence of Film Speed	181	QUALITY AND DETAIL VISIBILITY	227
Density-exposure Relation	182	Controlling Factors	227
Effect of Development Time on		Subject Contrast	228
Speed and Contrast	182	Film Contrast	229
Graininess	182	Film Graininess and Screen Mottle	229
X-ray Spectral Sensitivity	183	Penetrameters	229
Reciprocity Law Failure	184	Viewing and Interpreting	
BIBLIOGRAPHY	185	Radiographs	232
SECTION 5: FILM AND PAPER		PART 6, FILM HANDLING AND	
RADIOGRAPHY	186	STORAGE	234
INTRODUCTION	187	Identifying Radiographs	234
PART 1, FILM EXPOSURE	188	Shipping of Unprocessed Film	234
Making a Radiograph	188	Storage of Unprocessed Film	235
Factors Governing Exposure	189	Storage of Exposed and Processed	
Geometric Principles	190	Film	237
Relations of Milliamperage,		PART 7, INTRODUCTION TO	
Distance and Time	198	PAPER RADIOGRAPHY	239
		Viewing Paper Radiographs	239
		Interpreting Paper Radiographs	241

PART 8, INDUSTRIAL RADIOGRAPHY ON RADIOGRAPHIC PAPER	242	PART 5, DEFINITION AND UNSHARPNESS	273
Introduction	242	Definition	273
Characteristic Curves for Paper Radiography	242	Unsharpness	273
Relative Speed	243	PART 6, SENSITIVITY AND IMAGE QUALITY	275
Contrast	243	Sensitivity	275
Exposure Latitude	243	Intensifying Screens	276
Exposure Charts	245	Metal-phosphor Screens	277
Exposure Information for Different Paper Speeds	247	PART 7, X-RAY FILM CHARACTERISTICS AND RADIOGRAPHIC VARIABLES ..	279
Sharpness of the Radiographic Image on Paper	252	Film Speed	279
Processing of Radiographic Paper	252	Collimation	279
Storing and Handling Paper Radiographs	253	Magnification and Image Sharpness ..	279
Conclusions	254	Blocking	280
SECTION 6: HIGH-ENERGY RADIOGRAPHY	256	Filters	280
INTRODUCTION	257	PART 8, RADIOGRAPHIC APPLICATIONS	281
PART 1, DESCRIPTION OF EQUIPMENT	258	Discussion of Requirements	281
Resonant Transformer X-ray Machines	258	Safety	281
Electrostatic Generators	259	Radiation Precautions	281
Betatrons	260	Electrical Shock Precautions.....	283
Electron Linear Accelerators	261	General Requirements	283
PART 2, CHARACTERISTICS OF HIGH-ENERGY RADIATION	263	Exposure Room Equipment	284
Basic Principles	263	Accessory Equipment	284
Advantages	263	Film Processing Facilities	284
Measurement of High-energy Radiation	263	Radiography of Castings or Welds ...	284
Target Characteristics	264	Radiography of Propellants	285
Focal Spot Size Determination.....	264	Radiography of Explosives	290
PART 3, RADIATION ATTENUATION AND SCATTERING	265	Radiography of Assemblies	290
Radiation Attenuation	265	Special Applications	291
Half-value Layers	266	Conclusion	292
Scatter Radiation	267	PART 9, HIGH-ENERGY EXPOSURE CURVES	293
Latitude	268	BIBLIOGRAPHY	298
PART 4, BEAMING AND FIELD FLATNESS	270	SECTION 7: RADIOGRAPHIC LATENT IMAGE PROCESSING	299
Beaming	270	INTRODUCTION	300
Target Thickness	271	PART 1, THE CHEMISTRY OF RADIOGRAPHY	301
Compensators	271	The Latent Image	301
Field Flattening	271	The Chemistry of Film	301
Intensity Distribution.....	272	Exposing a Film	302
Exposure Curves	272	The Chemistry of Processing	302
		PART 2, THE DARKROOM	312
		Darkroom Technique.....	312
		Equipment and Practice	313

PART 3, MANUAL PROCESSING		
TECHNIQUE	317	
Principle	317	
Equipment and Practice	317	
Working in the Darkroom	318	
Hot Weather Processing	325	
Safety	326	
Other Helpful Information	326	
PART 4, AUTOMATIC PROCESSING ...	327	
Introduction	327	
Understanding the Systems	328	
Automatic Processor Chemistry	331	
Silver Recovery	334	
Operating Procedures	338	
Cleanup and Inspection	341	
Solution Services	341	
Processor Quality Control	343	
Archival Quality	343	
Other Helpful Information	346	
Processing Roll Film	346	
PART 5, AUTOMATIC RADIOGRAPHIC		
FILM PROCESSORS	348	
Advantages of Automatic Processing ..	348	
Types of Equipment	348	
Automatic Processing Quality		
Control Outline	348	
PART 6, PREVENTIVE MAINTENANCE	351	
Introduction	351	
Transport System	351	
Electrical System	352	
Tempering System	352	
Chemistry System	352	
Air/Dryer System	352	
Circulation/Filtration System	353	
Replenishment System	353	
Cleaning	354	
Caring for Stainless Steel	355	
Lubrication	355	
Correct Hose Installation	356	
Processing Maintenance Schedules	356	
PART 7, TOOLS	359	
Suggested List of Tools for Working		
on Automatic Processors	359	
PART 8, PROBLEM SOLVING GUIDE ..	360	
Transport Problems	360	
Electrical Problems	361	
Tempering Problems	361	
Film	362	
Drying	362	
		Processor Trouble-Shooting
		Checklists
		363
	PART 9, OTHER SYSTEMS	369
	Paper Processing (Stabilization	
	Process)	369
	Glass Plate Processing	371
	Instant Processing	374
	REFERENCES	375
	SECTION 8: RADIOGRAPHIC	
	INTERPRETATION	377
	INTRODUCTION	378
	PART 1, FUNDAMENTALS	379
	Specifying Nondestructive Tests	379
	PART 2, STANDARDS, CODES AND	
	SPECIFICATIONS	381
	PART 3, VISUAL ACUITY	382
	PART 4, RADIOGRAPHIC VIEWING	
	CONDITIONS AND EQUIPMENT	384
	High Intensity Illuminators	384
	Magnifiers	386
	Other Viewing Accessories	386
	Viewing Paper Radiographs	386
	PART 5, DENSITOMETERS	388
	Procedure	388
	Precautions	389
	Density of Paper Radiographs	389
	Scanning Microdensitometers	389
	PART 6, RADIOGRAPHIC	
	INTERPRETATION REPORTING	393
	PART 7, RADIOGRAPHIC ARTIFACTS	394
	Indication Description	394
	False Indications (Film Artifacts) ...	394
	Artifacts Caused Prior to Processing ..	394
	Artifacts Caused During Processing ..	398
	Artifacts Caused After Processing	401
	Real-time Artifacts	401
	PART 8, DISCONTINUITY	
	INDICATIONS	402
	Discontinuity Indications for Welds ..	402
	Void-type Discontinuity Indications	
	for Castings	411
	Inclusion Indications for Castings	412
	Crack-type Discontinuities for	
	Castings	413
	Other Casting Discontinuities	414
	Conclusion	416
	REFERENCES	417

SECTION 9: RADIOGRAPHIC CONTROL OF WELDS	418	PART 9, RADIOGRAPHY OF PIPE WELD DISCONTINUITIES	449
INTRODUCTION	420	Arc Strikes	449
PART 1, MECHANICS OF WELD RADIOGRAPHY	421	Drop-through	449
Butt Joints with Square Groove	421	Unconsumed Insert	449
Butt Joints with Prepared Groove	422	PART 10, SPECIAL RADIOGRAPHIC IMAGES OF WELDS	452
Other Joints and Welds	424	Thermit Process	452
Welding Position	425	Socket Welds	452
PART 2, WELDMENT MATERIAL AND THICKNESS	428	Inadvertent Indication	453
Material Density and Atomic Number	428	Overlap of Film	453
Material Thickness	428	Drop-through	454
PART 3, RADIATION SOURCES FOR RADIOGRAPHY OF WELDS	429	Stainless Steel Pipe	454
Standard X-ray Generators	429	Incomplete Penetration	455
Radioactive Isotopes	429	Conclusion	456
Frequency Distribution	431	REFERENCES	457
PART 4, RECORDING MEDIA	433	SECTION 10: RADIOGRAPHIC CONTROL OF CASTINGS	458
Film	433	INTRODUCTION	459
Paper	433	PART 1, BASIC PRINCIPLES OF CASTING RADIOGRAPHY	460
PART 5, TECHNIQUE DEVELOPMENT	434	The Casting Process	460
Sensitivity	434	PART 2, GENERAL TECHNIQUES OF CASTING RADIOGRAPHY	461
Setup for Exposure of Various Weld Types	434	Radiation Sources Used	461
Use of Penetrameters	439	Specification Requirements	463
Area Coverage	440	Radiographic Set-up	464
Screens	440	Penetrameters	464
Section Thickness	440	Defect Detection and Radiographic Sensitivity	467
Identifying Welds and Films	441	Special Considerations for Radiography of Castings	468
Film Handling	442	Standards	469
PART 6, IN-HOUSE AND FIELD RADIOGRAPHY OF WELDS	443	PART 3, RADIOGRAPHIC INDICATIONS FOR CASTINGS	472
PART 7, DISCONTINUITIES IN WELDS	444	Radiographic Indications for Casting Repair Welds	475
Porosity	444	PART 4, RADIOGRAPHIC TESTING AND PROCESS SCHEDULING	478
Slag	445	Factors Influencing Choice of Acceptance Criteria	478
Incomplete Penetration	445	PART 5, IMPROVEMENT OF CASTING RADIOGRAPHY	479
Lack of Fusion	445	Future Developments	480
Cracks	446	PART 6, SPECIAL APPLICATIONS OF CASTING RADIOGRAPHY	481
Dense Inclusion	446	Flash Radiography in Casting Control	481
Undercut	446		
Arc Strikes	447		
PART 8, CODES, STANDARDS AND SPECIFICATIONS FOR RADIOGRAPHY OF WELDS	448		
Radiographic Requirements for Welds in Selected Standards	448		

PART 7, TYPICAL PROBLEMS ENCOUNTERED IN CASTING		SECTION 12: NEUTRON RADIOGRAPHY	532
RADIOGRAPHY	484	INTRODUCTION	533
The Radiographic Source	484	PART 1, PRINCIPLES OF NEUTRON RADIOGRAPHY	534
Radiographic Coverage	484	Development	534
Radiographic Scheduling	484	Principles	534
Radiographic Interpretation	485	PART 2, EQUIPMENT AND PROCEDURES	536
Choice of Reference Radiographs	485	Neutron Sources	536
Conclusion	485	Neutron Energies	536
PART 8, GLOSSARY OF CASTING TERMINOLOGY	486	Moderation	539
REFERENCES	490	Neutron Collimation	539
SECTION 11: FLASH RADIOGRAPHY	491	Types of Neutron Sources	541
INTRODUCTION	492	Application Considerations of Sources	543
PART 1, FLASH X-RAY SYSTEMS	494	Neutron Image Detectors	546
Methods of X-ray Generation	494	PART 3, APPLICATIONS	552
Flash X-ray Tubes	495	General	552
Pulsed High Voltage Sources for Flash Radiography	496	Explosives	552
PART 2, FLASH RADIOGRAPHY TECHNIQUES	501	Turbine Blades	552
Film Recording	501	Electronic Devices	552
Electro-Optical Systems	501	Assemblies	552
Triggering Methods	503	Contrast Agents	553
Protection of Equipment and Film	504	Metallurgy	554
PART 3, FLASH CINERADIOGRAPHY	505	Nuclear Industry	554
Small Number of Images at Very High Frame Rates	505	Application Summary	555
Large Number of Images at Low to Moderately High Frame Rates	507	PART 4, NEUTRON RADIOGRAPHY STANDARDS, RECOMMENDED PRACTICES AND CONTROL	556
PART 4, SPECIAL HIGH SPEED RADIATION IMAGING TECHNIQUES	511	Personnel Qualification	556
Soft X-rays	511	System Performance Standards	556
Very Low Voltage Flash X-rays	511	Regulatory Control	556
Multiple Film Cassettes	512	PART 5, NEUTRON CROSS SECTIONS, ATTENUATION	558
Flash Betagraphy	512	Half-Value Layers	562
Super Radiant Light	514	Tenth-Value Layers	562
PART 5, APPLICATIONS OF FLASH RADIOGRAPHY	516	Conclusion	562
Ballistics	516	BIBLIOGRAPHY	563
Detonation Phenomena	522	SECTION 13: IMPLEMENTATION OF NEUTRON RADIOGRAPHY	564
Industrial Applications	522	INTRODUCTION	565
Biomedical Applications	524	PART 1, FUNDAMENTALS OF IMPLEMENTATION	566
Nuclear Technology	524	Approaches to Implementation	566
X-ray Backlighting for Pellet Implosion Studies	525	Approaches to Interpretation	568
Flash X-ray Diffraction	525	PART 2, IMPLEMENTATION OF LOW-YIELD SYSTEMS	569
Conclusion	527		
REFERENCES	528		

<i>d, T</i> Accelerator Systems	569	Operational Characteristics	609
Californium-252 Systems	569	Recommended Practice	613
Comparisons	569	PART 5, REMOTE VIEWING SYSTEMS	614
PART 3, IMPLEMENTATION OF		Image Intensifiers	615
MEDIUM-YIELD SYSTEMS	572	Spectral Matching	618
Subcritical Multiplier	572	Statistics	619
Van de Graaff System	573	Television Cameras, Image Tubes	
The Mini-Reactor	574	and Peripherals	619
PART 4, IMPLEMENTATION OF		Optical Coupling	624
HIGH-YIELD SYSTEMS	576	Viewing and Recording Systems	625
Source Choice	576	System Evaluation	626
Procurement	576	System Design	628
Safety	577	PART 6, IMAGE ENHANCEMENT IN	
System Description	577	REAL-TIME RADIOGRAPHY	629
PART 5, NUCLEAR INDUSTRY SYSTEMS	581	Digital Processing	629
System Descriptions	581	Analog Enhancement	637
Automated System	581	Conclusion	638
Transportable Systems	582	REFERENCES	639
Neutron Hodoscope	582		
Reference Items	583	SECTION 15: IMAGE DATA ANALYSIS	641
PART 6, SPECIAL SYSTEMS	586	INTRODUCTION	644
Static Cold Neutron Radiography	586	PART 1, DIGITIZING THE IMAGE	645
In-motion Cold Neutron Radiography	587	Signal-to-Noise Ratio (S/N)	645
High-speed Motion Thermal		Scatter and Noise	647
Neutron Radiography	587	PART 2, IMAGE ENHANCEMENT	
Neutron Computerized Tomography	588	METHODS	648
REFERENCES	592	Brightness Transfer Functions	648
		Gradient Removal	649
SECTION 14: REAL-TIME		Digital Filters	650
RADIOGRAPHY	593	Transforms	651
INTRODUCTION	594	PART 3, EXAMPLES OF IMAGE	
PART 1, FUNDAMENTALS OF		ENHANCEMENT APPLICATIONS	652
REAL-TIME RADIOGRAPHY	595	Edge Enhancement	653
Principles	595	Spatial Filtering	654
Background	595	Histograms	655
PART 2, FLUORESCENT SCREENS	597	Pseudocolor Enhancement	656
Principle of Operation	597	PART 4, ALGORITHMS FOR THE	
Construction and Materials	597	AUTOMATIC EVALUATION OF	
Characteristics of Screens	597	RADIOGRAPHS	657
Radiation Energy Effects	599	Field-Flattening	658
Special Screens for Use in Real-Time	600	Low-Pass Filtering	660
PART 3, IMAGE QUALITY AND		Thresholding Operation	660
RADIOGRAPHIC PARAMETERS	602	Defect Measurement	661
Contrast	602	Detection of Base Separation	662
Definition	604	Unsharp Masking for Major	
Radiation Sources	606	Defect Detection	663
Radiation Energy Selection	607	PART 5, HARDWARE FOR IMAGE	
PART 4, FLUOROSCOPY	608	DATA PROCESSING	665
Basic Technique	608	Input Device	665
Radiation Barrier Windows	608		

TV Scanner Requirements	666	Probe Configuration	700
Display Memory and Monitor	666	Normalization	701
Digital Computer and Peripherals	666	Measurement Error	701
Array Processor	666	Conclusion	703
Requirements for Analog Video and Digital Interfaces	667	REFERENCES	704
PART 6, MEASUREMENTS BETWEEN FUZZY INTERFACES	668	SECTION 17: X-RAY DIFFRACTION AND FLUORESCENCE	705
Measurement Technique	668	INTRODUCTION	706
Conclusion	671	PART 1, X-RAY ANALYTICAL METHODS	707
REFERENCES	672	Basic Principles	707
SECTION 16: RADIATION GAGING	674	Role of Crystal Structure in X-ray Scattering and Diffraction	708
INTRODUCTION	675	X-ray Spectra	709
PART 1, OVERVIEW OF RADIATION GAGING METHODS	676	Positioning of Analytical Instrumentation	711
Gamma and X-ray Gaging	676	PART 2, INSTRUMENTATION FOR POWDER DIFFRACTION	712
Gaging with Nuclear Particles	676	Basis of the Powder Method	712
PART 2, PRINCIPLES OF GAMMA AND X-RAY ATTENUATION GAGING	678	The Powder Camera	712
Attenuation Coefficient	678	The Powder Diffractometer	713
Statistical Accuracy Limits	679	PART 3, PHASE CHARACTERIZATION BY X-RAY DIFFRACTION	716
PART 3, GAMMA AND X-RAY SOURCES	682	Qualitative Analysis of Polycrystalline Materials	716
Radioisotope Sources	682	Quantitative Methods	717
Electronic X-ray Sources	683	Limitations of the Diffraction Method	718
PART 4, DETECTORS	684	PART 4, OTHER APPLICATIONS OF THE POWDER METHOD	719
Gas-filled Detectors	684	Phase Changes	719
Scintillator Phototubes	685	Study of Chemical Reactions	719
Semiconductor Detectors	685	Use of Line Profile Data	720
Selection of Detector Type	686	Measurement of Solid Solutions and Eutectics	721
PART 5, DETECTOR ELECTRONICS	689	Measurement of Stress	721
Current Measurements	689	PART 5, ELEMENTAL ANALYSIS BY X-RAY FLUORESCENCE	722
Spectrometry Instrumentation	689	Principles of X-Ray Fluorescence	722
PART 6, FIXTURING AND CONTROLS	691	Qualitative Analysis with the X-Ray Spectrometer	722
Collimation	691	Quantitative Methods	722
Fixturing and Positioning Equipment	692	Trace Analysis	723
Data Analysis and Controls	692	PART 6, INSTRUMENTATION FOR X-RAY FLUORESCENCE ANALYSIS	724
PART 7, TOMOGRAPHY	693	The Wavelength Dispersive Spectrometer	724
Basic Principles	693	The Energy Dispersive Spectrometer	724
Tomographic Equipment	695		
Applications	695		
PART 8, OTHER X-RAY AND GAMMA GAGES	697		
Absorption Edge Densitometry	697		
X-ray Fluorescence	697		
Compton Scattering	697		
PART 9, BETA BACKSCATTER	700		
Beta Backscatter Principles	700		

PART 7, COMPARISON OF X-RAY FLUORESCENCE WITH OTHER ELEMENTAL METHODS	726	SECTION 19: SPECIALIZED RADIOGRAPHIC METHODS	759
PART 8, COMBINATIONS OF X-RAY DIFFRACTION AND FLUORESCENCE	727	PART 1, HIGH-SPEED VIDEOGRAPHY FOR OPTICAL AND X-RAY IMAGING	760
PART 9, SAFETY CONSIDERATIONS ...	728	High-speed Video System	760
PART 10, FUTURE TRENDS FOR X-RAY DIFFRACTION AND FLUORESCENCE	730	High-speed Video Combined with Dynamic Radiography	761
REFERENCES	731	PART 2, HIGH-SPEED CINE X-RAY DEVELOPMENTS	763
SECTION 18: RADIATION PROTECTION	732	Development of the IMAX System ...	767
INTRODUCTION	733	Use of Multi-cathode Heads	770
PART 1, DOSE DEFINITIONS AND EXPOSURE LEVELS	734	Use of Channel Plate Intensifiers	771
Radiation Quantities and Units	734	System for Study of Shaped Charge Development	771
Permissible Doses	734	PART 3, GEOMETRIC ENLARGEMENT RADIOGRAPHY	775
PART 2, RADIATION PROTECTION MEASUREMENTS	736	Definition and Principles	775
Choice and Use of Personnel		Reasons for Direct Enlargement Radiography	776
Dosimetry	736	Applications	776
Radiation Detection and Measurement	737	PART 4, RADIOGRAPHY OF RADIOACTIVE SUBJECTS	777
Choice and Use of Instruments	738	Definitions	777
PART 3, BASIC EXPOSURE CONTROL PRINCIPLES AND TECHNIQUES	746	Subject Information	777
Physical Safeguards and Procedural Controls	746	Requisites for X-ray Radiography ...	777
Classes of Installations (X and Gamma Rays)	746	Neutron Radiography	777
Output of Radiation Sources	748	PART 5, AUTORADIOGRAPHY	778
Working Time	748	Definition and Basic Principles	778
Working Distance	748	Specimen Information	778
Shielding	749	Recording Media	778
Protective Exposure Enclosures	751	Specialized Area Requirements	778
Thickness of Shielding Walls	752	Maintaining Specimen Recorder Contact	779
PART 4, NEUTRON RADIOGRAPHY ...	754	Handling Radioactive Materials	779
Introduction	754	Exposure Time	779
Neutron Sources	754	Combining Radiography and Autoradiography	779
Shielding	754	Autoradiographic Marking	780
PART 5, SKYSHINE	756	PART 6, ELECTRON RADIOGRAPHY ..	781
PART 6, MANAGEMENT CONSIDERATIONS	757	Principles	781
Government Licensing	757	Electron Transmission Radiography ..	781
Radiation Safety Officer	757	Electron Emission Radiography	781
Transportation of Radioactive Materials	757	Techniques	782
Disposal	757	PART 7, IN-MOTION RADIOGRAPHY ..	783
REFERENCES	758	Introduction	783
		Definitions	784
		In-motion Radiography Theory	784
		Examples of In-motion Radiography ..	792
		Applications of IMR	795
		Summary	799

PART 8, PROJECTION MICROFOCUS RADIOGRAPHY	801	SECTION 20: ATTENUATION COEFFICIENT TABLES	837
Real-time Projection Microfocus Radiography.....	802	TABLE 1. Hydrogen (Z = 1)	839
Zoom Technique	802	TABLE 2. Beryllium (Z = 4)	840
Automatic Defect Recognition Applications	804	TABLE 3. Carbon (Z = 6)	841
High Power Applications	806	TABLE 4. Nitrogen (Z = 7)	842
Limited Field of View.....	806	TABLE 5. Oxygen (Z = 8)	843
Special Applications.....	807	TABLE 6. Sodium (Z = 11)	844
Projection Microfocus Radiography — Film Imaging	807	TABLE 7. Magnesium (Z = 12)	845
Conclusion.....	807	TABLE 8. Aluminum (Z = 13).....	846
PART 9, RADIOGRAPHIC FLAW DEPTH DETERMINATION	808	TABLE 9. Silicon (Z = 14)	847
Introduction and Background	808	TABLE 10. Argon (Z = 18).....	848
The Parallax Principle.....	808	TABLE 11. Calcium (Z = 20).....	849
Rigid Formula	810	TABLE 12. Titanium (Z = 22)	850
Single Marker Approximate Formula ..	813	TABLE 13. Vanadium (Z = 23)	851
Double Marker Approximate Formula ..	813	TABLE 14. Chromium (Z = 24)	852
Effects of Flaw Geometry on Parallax Accuracy	815	TABLE 15. Manganese (Z = 25)	853
Source Movement	816	TABLE 16. Iron (Z = 26)	854
PART 10, THICKNESS MEASUREMENT RADIOGRAPHY	817	TABLE 17. Cobalt (Z = 27)	855
Direct Thickness Measurement.....	817	TABLE 18. Nickel (Z = 28)	856
Indirect Thickness Measurement	817	TABLE 19. Copper (Z = 29).....	857
PART 11, ROBOTIZED X-RAY INSPECTION STATION	822	TABLE 20. Zinc (Z = 30)	858
Inspection Station.....	822	TABLE 21. Germanium (Z = 32)	859
Robotized Process	824	TABLE 22. Selenium (Z = 34)	860
Benefits	824	TABLE 23. Zirconium (Z = 40)	861
PART 12, HANDLING SYSTEMS FOR REAL-TIME RADIOGRAPHY	825	TABLE 24. Niobium (Z = 41)	862
Introduction	825	TABLE 25. Molybdenum (Z = 42).....	863
Handling System Classification	826	TABLE 26. Silver (Z = 47)	864
Scan Plans	829	TABLE 27. Cadmium (Z = 48)	865
Handling System Design	831	TABLE 28. Tin (Z = 50)	866
Conclusions	833	TABLE 29. Antimony (Z = 51)	867
REFERENCES	834	TABLE 30. Iodine (Z = 53)	868
BIBLIOGRAPHY	835	TABLE 31. Cesium (Z = 55)	869
		TABLE 32. Barium (Z = 56)	870
		TABLE 33. Thulium (Z = 69)	871
		TABLE 34. Tantalum (Z = 73)	872
		TABLE 35. Tungsten (Z = 74)	873
		TABLE 36. Platinum (Z = 78)	874
		TABLE 37. Gold (Z = 79)	875
		TABLE 38. Lead (Z = 82).....	876
		TABLE 39. Uranium (Z = 92)	877
		TABLE 40. Plutonium (Z = 94)	878
		INDEX	879