

6.3.3 Alternatively, only one hole shall be drilled through the full thickness of the reference tube and during calibration and calibration checking the reference tube shall be passed through the equipment with the hole positioned at 0°, +90° and -90° for the 180° segment coil and at 0°, +45° and -45° for the 100° segment coil. These operations shall be repeated for each segment coil.

6.4 Fixed and rotating coil/pancake technique

When using the fixed or rotating coil/pancake technique, the reference tube shall contain a longitudinal reference notch on the external surface.

6.5 Dimensions of the reference standards

6.5.1 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 outside diameter and corresponding diameters of the reference holes for possible acceptance levels

Specified tube outside diameter D mm	Acceptance level hole diameter			Specified tube outside diameter D mm	Acceptance level hole diameter mm E4H
	E1H	E2H	E3H		
$4 \leq D \leq 10$	0,60	0,70	0,80	$4 \leq D \leq 15,8$	1,20
$10 < D \leq 20$	0,70	0,80	1,00	$15,8 < D \leq 26,9$	1,40
$20 < D \leq 44,5$	0,80	1,00	1,30	$26,9 < D \leq 48,3$	1,70
$44,5 < D \leq 76,1$	1,00	1,20	1,60	$48,3 < D \leq 63,5$	2,20
$76,1 < D \leq 180$	1,20	1,40	2,00	$63,5 < D \leq 114,3$	2,70
$180 < D$	1,40	1,80	2,20	$114,3 < D \leq 139,7$	3,20
				$139,7 < D$	3,70

6.5.2 Reference notch

6.5.2.1 General

- The reference notch shall be of the "N" type (see Figure 5) and shall lie parallel to the major axis of the tube. The sides shall be nominally parallel and the bottom shall be nominally square to the sides.
- The reference notch shall be formed by machining, spark erosion or other methods.

NOTE The bottom or the bottom corners of the notch can be rounded.