



### 1. Screw locking varnish presence control on female threads

The presence of a thread lock fluid should be controlled on inside threads. For this purpose a color sensor type **SPECTRO-3-FIO-SL** in connection with an optical fiber type **R-S-A2.0-(2.5)-1200-67°** and an optical frontend type **KL-M18-XL-A2.0** are used. At this, the distance of the frontend to the inside screw is approximately 120mm and the angle to the horizontal is around 33°. The spot size at this distance is roughly 4mm in diameter. The screw locking varnish can be proper detected as shown in the screen shots.

