

PRESSURE TESTING, HYDRAULIC
2500 psig

1. SCOPE: This specification provides requirements and procedures for hydraulic-pressure leak testing of parts.
2. APPLICABLE DOCUMENTS: None.
3. TECHNICAL REQUIREMENTS:
 - 3.1 Equipment:
 - 3.1.1 Fixtures: Test fixtures shall not seal off areas of possible leakage or create excessive stresses on parts.
 - 3.1.2 Gaskets: Suitable gasket material shall be used with plugs or blanking plates to prevent damage to finished surfaces.
 - 3.1.3 Valves: Bleeder valves shall be provided to release entrapped air.
 - 3.1.4 Gauges: Pressure gauges shall have sufficient dial divisions to permit monitoring of pressure specified.
 - 3.1.5 Safety Tank or Screen: A suitable tank or screen shall be provided to protect the operator in case of failure of a part.
 - 3.1.6 Drying Oven: A circulating-air oven is required for drying corrodible parts.
 - 3.2 Test Media: Either water, hydraulic fluids, or suitable petroleum-base test fluids shall be used.
 - 3.3 Preparation:

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AMS 2625B

- 3.3.1 Cleaning: The part shall be thoroughly cleaned and dried before testing, so that any leaks will be visible. Loose particles, machine shop chips, oils, and other foreign materials shall be removed before pressure testing.
- 3.3.2 Processes: The part or subassembly shall be tested following all machining, forming, straightening, welding, brazing, anodizing, etc, and prior to application of protective finishes such as paint, plating, coating, or surface finishes that may mask or blank off areas of possible leakage.
- 3.3.3 Chemical Films: Chemical film protective finishes on aluminum may be applied either before or after pressure testing.
- 3.3.4 Impregnation: Impregnation of castings shall not be permitted except as authorized by purchaser and then only to correct general seepage leaks. Impregnants shall not be used to correct poor foundry techniques, visible holes, or excessive porosity. Impregnation, when permitted or authorized, shall be conducted after all heat treatment, brazing, and welding have been completed.
- 3.3.5 Preliminary Tests: Tests may be performed at any stage of manufacture in order to establish in-process integrity.
- 3.3.6 Material Removal: Sand blasting, pickling, or any other operation which may remove metal from surfaces shall be done before pressure tests.
- 3.4 Procedures: Parts shall be fitted up for test, surfaces opposite those under pressure shall be dried, and part or passage shall be filled with water or other suitable liquid. After all air has been expelled from internal passages under test, pressure of 2500 psig \pm 125 shall be applied to the fluid and maintained for sufficient time to establish the rate of leakage.
- 3.4.1 Duration: Parts, other than castings, shall be held under pressure for not less than 3 min. to permit complete visual inspection while at the specified pressure. Unless a specific time is specified, castings also shall be held for not less than 3 min. at the specified pressure.
- 3.4.2 Entrapped Air: Care shall be exercised that no air or other gas is trapped in the part being tested or any of the feeder lines associated with the testing fixture. Bleeders shall be provided to release entrapped air or gas so the entire part volume is filled with liquid.
- 3.4.3 Cleaning: Parts which have been tested with water or hydraulic fluid shall be cleaned and dried, immediately after test, to prevent corrosion due to entrapment of moisture. Visible moisture shall be removed by air blast. Parts containing areas of entrapment and all magnesium parts shall be dried in a circulating-air oven at 250°F \pm 25 for at least one hour.
- 3.4.4 Orientation: The part shall be exposed to permit overall visual inspection during static pressure application.