



# SURFACE VEHICLE RECOMMENDED PRACTICE

J968™-2

SEP2015

Issued 1966-08  
Revised 1991-05  
Reaffirmed 2015-09

Superseding J968-2 DEC2002

## Diesel Injection Pump Testing—Part 2: Orifice Plate Flow Measurement

### RATIONALE

J968-2 has been reaffirmed to comply with the SAE five-year review policy.

1. **Scope**—This part of SAE J968 specifies the flow measuring system, including the fixture, to be used for flow testing the single hole orifice plates used in an orifice plate type nozzle and holder assembly (described in SAE J968-1) which is intended for testing and setting diesel fuel injection pumps on test benches.

The flow measuring system and fixture ensure accurate flow testing of the entire range of orifices from 0.4 to 0.8 mm diameter as specified in SAE J968-1. It is intended primarily for use by the manufacturers of single hole orifice plates.

2. **References**

- 2.1 **Applicable Publications**—The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply.

- 2.1.1 SAE PUBLICATIONS—Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

SAE J967—Calibration Fluid for Diesel Injection Equipment

SAE J968-1—Diesel Injection Pump Testing—Part1: Calibrating Nozzle and Holder Assemblies

- 2.1.2 ISO PUBLICATION—Available from ANSI, 25 West 43rd Street, New York, NY 10036-8002.

ISO 7440/2—Road vehicles—Fuel injection equipment testing—Part 2: Orifice plate flow measurement

3. **Orifice Plate Flow Measuring System**

- 3.1 **General Description**—An orifice plate flow measuring system shall comprise:

- a. Orifice Plate Holding Fixture (shown in Figure 1)
- b. Fluid Supply Circuit and Flow Measuring Device (an example is shown in Figure 2)
- c. Flow Overcheck Device—OPTIONAL. (This device is for periodic overchecking of the accuracy of the primary flow measurement device in (b) and is specified in Appendix A.1.)

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

SAE reviews each technical report at least every five years at which time it may be revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

Copyright © 2015 SAE International

All rights reserved. No part of this publication may be reproduced, stored in a retrieval system or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording, or otherwise, without the prior written permission of SAE.

TO PLACE A DOCUMENT ORDER: Tel: 877-606-7323 (inside USA and Canada)  
Tel: +1 724-776-4970 (outside USA)  
Fax: 724-776-0790  
Email: CustomerService@sae.org  
http://www.sae.org

SAE WEB ADDRESS:

SAE values your input. To provide feedback  
on this Technical Report, please visit  
[http://www.sae.org/technical/standards/J968/2\\_201509](http://www.sae.org/technical/standards/J968/2_201509)

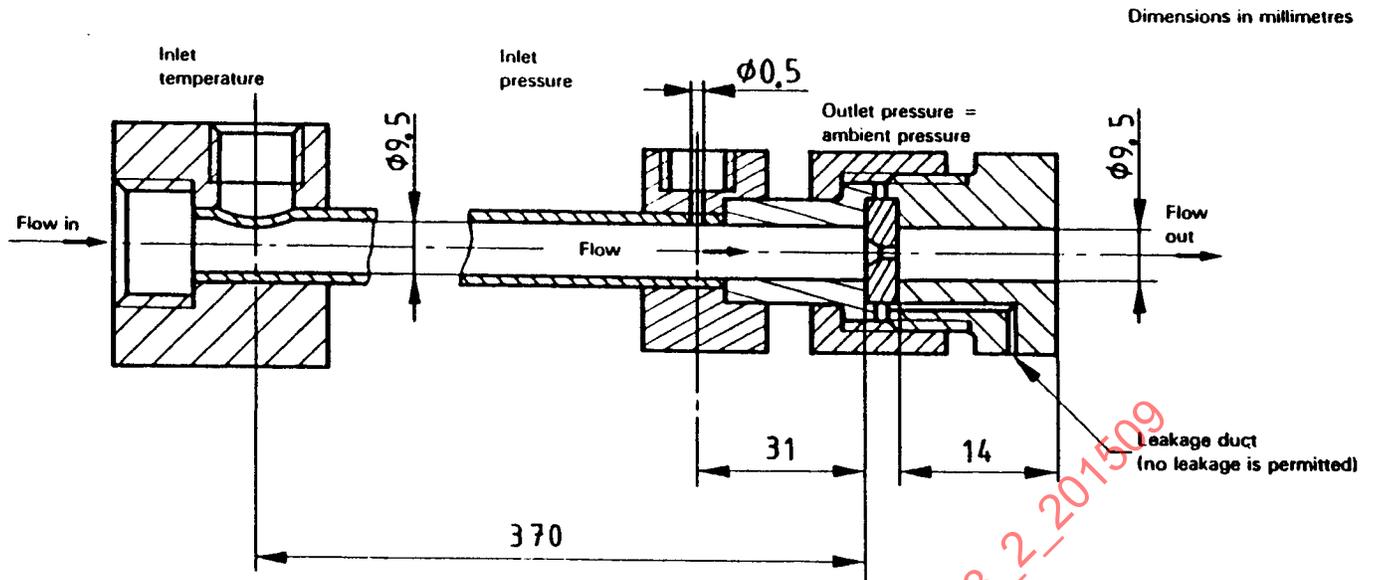


FIGURE 1—ORIFICE PLATE HOLDING FIXTURE FOR FLOW MEASUREMENT

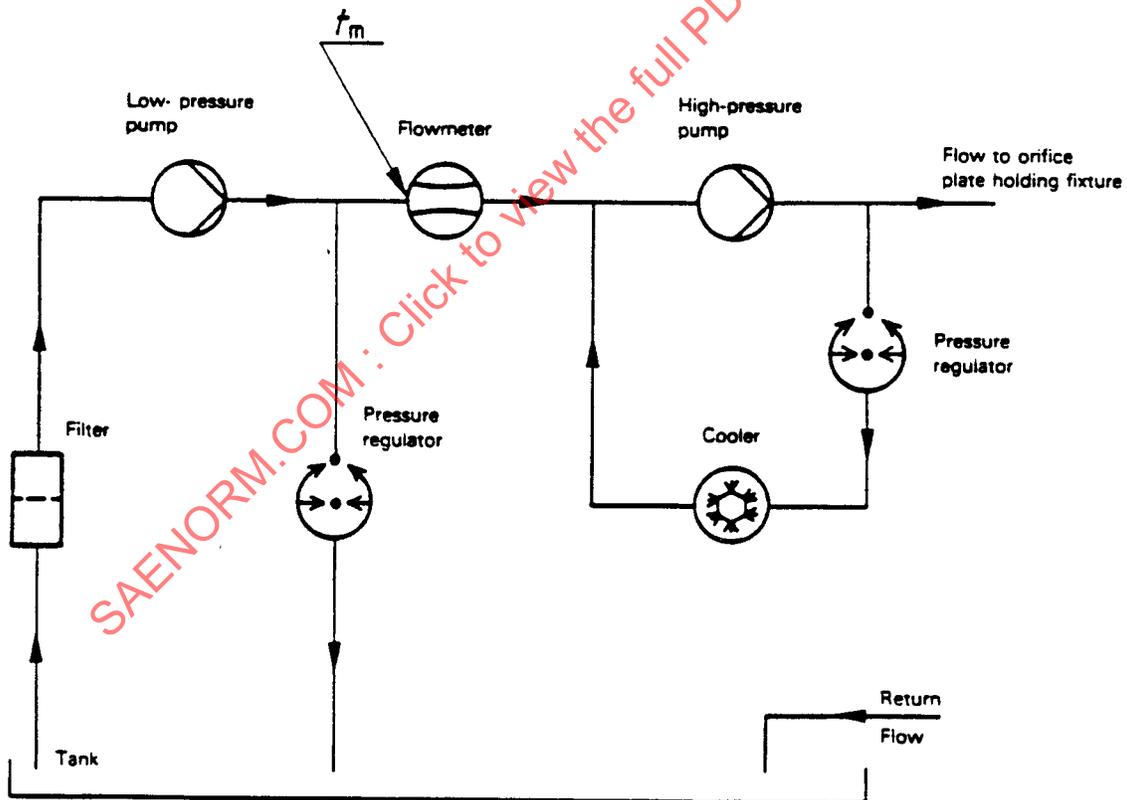


FIGURE 2—FLUID SUPPLY CIRCUIT WITH PRESSURE AND TEMPERATURE CONTROL AND FLOW-MEASURING DEVICE

The system shall be designed and constructed to minimize fluid evaporation, contamination, aeration, and instability of pressure and temperature.

Flow values obtained by alternative systems shall require correlation with values determined using the previous system.

**3.2 Orifice Plate Holding Fixture**—The functionally critical details and dimensions of the fixture are shown in Figure 1. Dimensions not specified and construction techniques are left to the discretion of the manufacturer of the fixture, but shall be such that the fixture has unrestricted and undistributed flow.

#### 4. Flow Measuring Procedure

##### 4.1 General Requirements

- a. The orifice plates shall be clamped in a fixture conforming to Figure 1.
- b. The following monitoring points shall be provided and the values measured or verified:
  1. Orifice inlet temperature
  2. Orifice inlet pressure
  3. Orifice outlet pressure
- c. The fluid shall enter the orifice through the entry cone.
- d. The flow through each orifice plate shall be measured individually.
- e. The fluid in the flow circuit shall conform to SAE J967. Viscosity and specific gravity shall be measured frequently and the fluid shall be discarded if it ceases to conform to SAE J967.

**4.2 Reference Conditions**—The orifice plate flow values stated in Part 1 of this document refer to volumetric flow rate measured (or adjusted to) 40 °C. The other reference conditions shall be as follows:

- a. Inlet pressure minus outlet pressure = 100 bar
- b. Outlet pressure = ambient pressure
- c. Inlet temperature of fluid = 40 °C
- d. Dynamic viscosity at 40 °C =  $2.1 \times 10^{-3}$  Ns/m<sup>2</sup>
- e. Density at 40 °C = 0.808 g/cm<sup>3</sup>

NOTE—Dynamic viscosity at 40 °C = kinematic viscosity at 40 °C x density at 40 °C.

##### 4.3 Accuracy of Measurement

4.3.1 Measurements shall be taken with the following accuracies:

- a. Orifice volumetric flow rate at 40 °C: ±0.2% of reading
- b. Temperature of volume measured: ±0.5 °C
- c. Dynamic viscosity at 40 °C: ±0.1 x 10<sup>-3</sup> Ns/m<sup>2</sup>
- d. Density at 40 °C and at atmospheric pressure: ±0.001 g/cm<sup>3</sup>

NOTE—Density is preferably measured at ambient temperature and is adjusted to 40 °C as follows in Equation 1:

$$\rho_{m40} = \rho_a - 0.00068(40 - t_a) \text{g/cm}^3 \quad (\text{Eq. 1})$$

4.3.2 The following supply conditions shall be maintained taking into account gauge error:

- a. Temperature of fluid at inlet:  $\pm 1$  °C;
- b. Inlet Pressure:  $\pm 0.1$  bar;
- c. Maximum cyclic fluctuation in inlet pressure:  $\pm 1$  bar.

**4.4 Correction Procedure**—To compensate for the effects of temperature, density, and viscosity, the empirical formula in Equation 2 shall be used:

$$\text{Flow} = \text{Flow}_{(\text{measured})} \times \frac{\left[ 1.7 \sqrt{\frac{\rho_{m40}}{\rho}} \right] \times \left[ 1 - \left[ \frac{\mu - \mu_{m40}}{\mu K} \right] \right]}{[1 + \gamma(t_m - 40)]} \quad (\text{Eq. 2})$$

where:

$\rho$  is the reference density = 0.808 g/cm<sup>3</sup>

$\rho_{m40}$  is the fluid density (g/cm<sup>3</sup>) in the circuit at 40 °C

$\mu$  is the reference dynamic viscosity =  $2.1 \times 10^{-3}$  Ns/m<sup>2</sup>

$\mu_{m40}$  is the dynamic viscosity (Ns/m<sup>2</sup>) of fluid in the circuit at 40 °C

$\gamma$  is the coefficient of volumetric expansion of the fluid, equal to 0.000824 °C<sup>-1</sup>

$t_m$  is the fluid temperature (°C) in the flow measuring device

$t_a$  is the fluid temperature (°C) at which density is measured

and

K = 88 for 0.4 orifices

K = 100 for 0.5 orifices

K = 114 for 0.6 orifices

K = 135 for 0.7 orifices

K =  $\infty$  for 0.8 orifices