

Pressure and function test of BHHF actuators

Application:

The instruction is applicable in connection with manual pressure and function test of hydraulic actuators type BHHF125 - 16000 (incl. FO - Fail Open)

System connection:

Bettis Standard: QS0555 (Final inspection and test).

Test conditions:

Max. working pressure:	135 bar	(1960 PSi)
Test pressure:	250 bar	(3625 PSi)
Test medium:	Hydraulic oil	
Test is carried out:	Before coating and before mounting of shaft cover.	

Procedure:

Function test: Actuator is operated as follows:

- Fail Close and B port:**
 - Rotation anti-clockwise: Hydraulically at test pressure
 - Rotation clockwise: Spring force
 - (4 double movements are made.)
- Fail Open and A port:**
 - Rotation clockwise: Hydraulically at test pressure
 - Rotation anti-clockwise: Spring force
 - (4 double movements are made.)
- Acceptance criteria:** Actuator shall rotate a quarter turn. Smooth rotation.

Test of indicator cam: Cam is measured with depth micrometer. Cam shall travel 4.2 +/-0.4 mm. (.16 +/- .02 in.)

Leakage test:

- 1) Actuator is rotated hydraulically at test pressure.
- 2) Test pressure is maintained for 1 minute and inspection for leakage is carried out.

Marking: Name plate is marked with the correct test pressure.

Documentation:

Test certificate shall not be issued, as it is a "GO-NOGO" test and only approved units are released for stock and/or dispatch.

Note: Not Certified dimensional drawings. Such drawings are available on request. Contact factory with correct model designation and serial number.
Important: Due to Emerson's continuing commitment to engineered product advancement, data presented herein is subject to change.

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