

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.
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