

Delphi

DELPHI

PNEUMATIC TEST PROCEDURE

1. SCOPE

This document outlines the procedure to be followed for the Pneumatic testing of sample lines and components for leakage. It includes criteria for acceptance of work done.

2. PROCEDURE

This procedure is to be performed after all piping has been completed and final connections made. Test gauges are calibrated against calibrate master gauges before each test, and readings recorded on test data sheet (11.D.5.6 2). Instruments or gauges which may be damaged by test pressure must be bypassed or isolated before the test. All piping, tubing, valves, and fittings shall be pressurized with clean, dry air or nitrogen to a test pressure not less than 1.20 nor more than 1.25 times the design pressure of the piping subassembly system. Each joint shall be inspected for leaks using a soap bubble type test fluid such as "Snoop" manufacture by Nupro Company or equal. Pressure shall be applied for a minimum of ten (10) minutes. Detectable leakage shall not be permitted. Leaks shall be repaired and the equipment retested.

After passing the above test, instruments and gauges shall be reconnected to the sample system and the system repressurized to the maximum allowable pressure for the most pressure sensitive instrument or gauge and the joints on the instruments and gauges tested as outlined above.

All pneumatic control lines shall be tested with clean, dry air or nitrogen at the maximum expected air signal pressure. Each joint shall be inspected for leaks as outlines above, and test data recorded on test data sheet (11.D.5.6 2).

3. ACCEPTANCE

After all lines have been tested and no detectable leakage observed, the assembly is acceptable; Test Operator and Quality Control Inspector will indicate acceptance of test by signing the designated section of form 11.D.5.6 2 and the "Traveler" (11.D.8.9).

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Procedure Approved By: *J Lewis*

Date: 6/18/75

Revision: B

PNEUMATIC TEST REPORT

JOB 80-410

Doc't. No. 410-CC

TEST DATE 6-29-79

Rev. 1

CALIBRATION:

TEST GAUGE	CALIBRATION GAUGE
0	
50	
100	
200	

TEST RESULTS:

LINE NO.	DESIGN PRESSURE	TEST PRESSURE 1.25 X D. P.	DETECTABLE LEAKS
cell	atmospheric pressure	60 psig	no pressure drop in 20 minutes, but some foam was evident a Reference-side seal.

This system has been tested and found to be free from leaks at the above conditions.

TEST INSPECTOR

T. J. Belle 6/29/79

Q.C. INSPECTOR

[Signature]

FORM APPROVED BY:

[Signature]

DATE:

6/18/75

REVISION:

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