

# 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:

<b>Fail Close and B port:</b>	Rotation anti-clockwise:	Hydraulically at test pressure
	Rotation clockwise:	Spring force
(4 double movements are made.)		
<b>Fail Open and A port:</b>	Rotation clockwise:	Hydraulically at test pressure
	Rotation anti-clockwise:	Spring force
(4 double movements are made.)		
<b>Acceptance criteria:</b>	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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