



**SLOVENSKI STANDARD**  
**SIST ISO 6403:1998**

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Hydraulic fluid power -- Valves controlling flow and pressure -- Test methods

Transmissions hydrauliques -- Régulateurs de débit et de pression -- Méthodes d'essai

**Ta slovenski standard je istoveten z: ISO 6403:1988**

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## Hydraulic fluid power — Valves controlling flow and pressure — Test methods

*Transmissions hydrauliques — Régulateurs de débit et de pression — Méthodes d'essai*

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## ISO 6403 : 1988 (E)

## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 6403 was prepared by Technical Committee ISO/TC 131, *Fluid power systems*.

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Users should note that all International Standards undergo revision from time to time and that any reference made herein to any other International Standard implies its latest edition, unless otherwise stated.

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# Hydraulic fluid power — Valves controlling flow and pressure — Test methods

## 0 Introduction

In hydraulic fluid power systems, power is transmitted and controlled through a liquid under pressure within an enclosed circuit. Hydraulic valves may be used to control the direction, pressure or flow rate of the working fluid by adjusting or controlling their resistance to flow.

ISO 4411, in which methods for determining the steady-state differential pressure/flow characteristics of hydraulic valves are specified, forms part of the same series of International Standards.

The test requirements for production purposes may differ from those specified in this International Standard.

## 1 Scope and field of application

This International Standard specifies methods for testing hydraulic valves which are used for the control of flow or pressure in a circuit in order to determine their steady-state and dynamic performance.

Requirements for test installations and procedures, measurements and presentation of results are specified. This International Standard does not establish limits of performance since the suitability of the valve for its intended purpose should be agreed between the manufacturer and the user.

Accuracy of measurement is divided into three classes (A, B and C) which are explained in annex A. Guidance as to the use of practical units for the presentation of results is given in annex B.

Proportional control valves are not dealt with in this International Standard. Electrohydraulic servovalves are dealt with in ISO 6404.

## 2 References

ISO 1219, *Fluid power systems and components — Graphic symbols*.

ISO 4411, *Hydraulic fluid power — Valves — Determination of pressure differential/flow characteristics*.

ISO 5598, *Fluid power systems and components — Vocabulary*.

IEC Publication 85, *Thermal evaluation and classification of electrical insulation*.

## 3 Definitions

For the purposes of this International Standard, the definitions given in ISO 5598, together with the following, apply.

**3.1 bleed-off:** A circuit condition where there is control over the inlet flow to a component by diverting part of that flow to a reservoir or part of a circuit having lower pressure.

**3.2 meter-in:** A circuit condition where there is control over the inlet flow to a component.

**3.3 meter-out:** A circuit condition where there is control over the outlet flow from a component.

**3.4 volumetric stiffness:** The stiffness of a given portion of a hydraulic circuit, which is determined by the value of the partial differential  $\frac{\partial p}{\partial V}$  for the fluid contained in that part of the circuit.

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## 4 Symbols and units

4.1 The units and symbols used throughout this International Standard are as shown in table 1.

Table 1 — Symbols and units

Quantity	Symbol	Dimension <sup>1)</sup>	SI unit <sup>2)</sup>
Nominal diameter of valve	$D$	L	m
Force	$F$	$MLT^{-2}$	N
Control element — linear displacement	$L$	L	m
Control element — angular displacement	$\beta$	—	rad
Volume flow rate	$q_V$	$L^3T^{-1}$	$m^3/s$
Internal diameter of pipe	$d$	L	m
Pressure, differential pressure	$p, \Delta p$	$ML^{-1}T^{-2}$	Pa
Time	$t$	T	s
Mass density of fluid	$\rho$	$ML^{-3}$	$kg/m^3$
Kinematic viscosity	$\nu$	$L^2T^{-1}$	$m^2/s$
Temperature (customary)	$\theta$	$\Theta$	$^{\circ}C$
Isentropic bulk modulus	$K_s$	$ML^{-1}T^{-2}$	Pa
Volume	$V$	$L^3$	$m^3$

1) M = mass; L = length; T = time;  $\Theta$  = temperature

2) The practical units which may be used for the presentation of results are tabulated in annex B.

4.2 The graphical symbols used in the figures depicting test circuits are in accordance with ISO 1219.

## 5 Test installation — General requirements

## 5.1 Test circuit

5.1.1 A test circuit similar to those shown in figure 1 and figures 5 to 13 and suitable for the type of valve being tested in accordance with the relevant clauses in this International Standard shall be used.

## NOTES

1 Although figure 1 and figures 5 to 13 illustrate basic circuits which are specific to one or more tests and which utilize the minimum number of components, it is acceptable to use an integrated test circuit which embraces two or more test conditions.

2 The figures in this International Standard showing basic test circuits do not incorporate all the safety devices necessary to protect against damage in the event of component failure. It is important that those responsible for conducting these tests give due consideration to safeguarding both personnel and equipment.

5.1.2 A fluid supply with a controllable flow which has a higher maximum than the rated flow of the valve being tested shall be used.

5.1.3 A pressure control valve in the supply line shall be installed to protect the circuit from excess pressure.

Further control valves, as necessary, shall be installed to regulate the flow or pressure, as required, in various parts of the circuit.

5.1.4 The inside diameters of pipes and fittings that interface with the test valve, and which include pressure tapping points, shall be consistent with the diameters of the ports.

5.1.5 Drain ports shall be connected to a reservoir.

## 5.2 Pressure- and temperature-sensing points

## 5.2.1 Location of pressure tappings

NOTE — In the case of measurements to class C standard of accuracy (see annex A), pressure readings taken for expediency at other points other than those described in this sub-sub-clause will give sufficient accuracy providing that, where appropriate, correction is made for pipe losses.

Pressure tappings shall be provided both upstream and downstream of the valve being tested and, if required, at other points.

5.2.1.1 The inlet pressure tapping point shall be

- not less than  $10d$  downstream of any perturbation-producing element, such as a valve or a bend, and
- not less than  $5d$  upstream of the test valve.

5.2.1.2 The outlet pressure tapping point shall be not less than  $10d$  downstream of the test valve.

5.2.1.3 The measured data for pipe losses shall be corrected using the method described in ISO 4411.

## 5.2.2 Pressure tappings

5.2.2.1 The tappings shall have diameters equal to or less than  $0,1d$  but not less than 1 mm nor greater than 6 mm.

5.2.2.2 The internal pipe surface at the tapping shall be deburred without the sharp edge of the tapping hole being removed.

5.2.2.3 The length of the tapping hole shall be not less than twice the diameter.

5.2.2.4 The bore of the pipe containing the tapping shall be clean and smooth.

5.2.2.5 The instrument-connecting pipes shall have bores not less than 3 mm.



**5.2.2.6** Any entrained air between each tapping point and the measuring instrument shall be purged.

### 5.2.3 Location of temperature-sensing point

The fluid temperature at the inlet to the test valve shall be measured at a distance not greater than  $15d$  upstream of the inlet pressure tapping.

### 5.3 Filtration and contamination level

**5.3.1** Filters shall be installed which provide a standard of filtration which is at least equal to that recommended by the test valve manufacturer.

**5.3.2** The position and specific description of each filter used in the test circuit shall be stated in the test report.

**5.3.3** During tests conducted in accordance with clauses 7 to 11, where inconsistencies may arise due to silting, the standard of filtration shall be such that test measurements can be made within 60 s; the actual interval in the test report shall be stated in the test report.

**5.3.4** The actual contamination level of the test fluid from samples taken during the test shall be determined; the test method used shall be stated in the test report.

## 6 General test conditions

### 6.1 Test fluid

**6.1.1** The following information relating to the test fluid shall be included in the test report:

- a description of test fluid;
- the kinematic viscosity,  $\nu$ , and density,  $\rho$ , of the test fluid at the controlled temperature of the test;
- the isentropic bulk modulus,  $K_s$ , of the test fluid (if dynamic tests are performed).

**6.1.2** If it is necessary to determine the effect of viscosity, the tests shall be carried out at agreed fixed temperature(s), using fluids of different viscosity of the same fundamental type; details shall be included in the test report.

### 6.2 Test temperatures

**6.2.1** Tests shall be carried out at agreed fluid inlet temperatures. The fluid inlet temperature(s) shall be selected within the range recommended by the valve manufacturer; details shall be included in the test report.

**6.2.2** When selecting temperatures, due consideration shall be given to whether the valve to be tested is to be examined for temperature compensation.

**6.2.3** If the selected test temperature is 25 °C or higher, the equipment and the working fluid shall be stabilized at that temperature prior to commencement of the test. The temperature shall be maintained throughout the test.

**6.2.4** If the selected test temperature is less than 25 °C (considered as a cold-start condition), the temperature of the fluid shall be allowed to rise after the start of the test. Temperature, pressure and flows against time shall be recorded.

### 6.3 Steady-state conditions

**6.3.1** Each set of measurements shall be taken when the values of controlled parameters are within the tolerances given in table 2.

**6.3.2** The number of readings taken and their disposition over the range shall be selected so as to give a representative indication of the performance of the unit over the full range of the function being varied.

**6.3.3** In order to ensure repeatable results, the mean values of the parameters being measured shall be established over an agreed interval of time.

**Table 2 — Limits of permissible variation of mean indicated values of controlled parameters**

Controlled parameter	Limits of permissible variation of mean indicated values of controlled parameters for class of measurement accuracy <sup>1)</sup>		
	A	B	C
Flow rate, %	± 0,5	± 1,5	± 2,5
Pressures, %	± 0,5	± 1,5	± 2,5
Fluid temperature, K	± 1	± 2	± 4
Viscosity, %	± 5	± 10	± 15

1) See annex A.

### 6.4 Proof pressure

**6.4.1** A proof pressure test in accordance with 6.4.1.1 to 6.4.1.5 shall be carried out to examine the integrity of the valve assembly being tested before any further tests are carried out.

**6.4.1.1** Apply to each port (other than drain ports) a proof pressure 1,5 times the maximum operating pressure for that port.

**6.4.1.2** Increase the pressure at a rate of approximately 2 % of proof pressure per second and maintain the proof pressure for 5 min.

**6.4.1.3** There shall be no external leakage throughout this period.

**6.4.1.4** Subject to any limitation on pressure in the outlet port imposed by the manufacturer, simultaneously subject the inlet and outlet ports to their respective proof pressure(s) for 5 min.

**6.4.1.5** There shall be no external leakage throughout this period.

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**7 Test procedure for directional control valves****7.1 Test circuit**

A test circuit similar to that shown in figure 1 shall be used.

**7.2 Steady-state pressure differential/flow characteristics**

At stated control element positions, determine the pressure differential/flow characteristics in accordance with the relevant clauses in ISO 4411.

**7.3 Internal leakage**

**7.3.1** Immediately before conducting the test, operate the valve over the full range of movement at least 10 times in quick succession.

**7.3.2** In order to determine the rate of leakage between the ports, apply agreed pressures to each port at which these tests are to be made.

**7.4 Switching envelope****7.4.1 General**

The purpose of these tests is to determine the operating threshold, i.e. the maximum pressure and associated maximum flow values at which the control element can be operated over the full range of its displacement in both directions of travel (see figure 2).

The movement of the control element shall be monitored by displacement transducers.

The test methods specified in 7.4.2 to 7.4.5 for valves in which the control element is displaced by an electrical solenoid, pilot pressure or force, and with or without spring return, respectively, shall be complied with.

In order to avoid inconsistencies due to silting, complete each set of measurements within 60 s of setting the control element position.

**7.4.2 Direct-operated solenoid valves**

**7.4.2.1** Tests shall be carried out at the maximum stable temperature for the solenoid; this temperature shall be within the limits recommended in IEC Publication 85 for the class of insulation used for the coil winding.

**7.4.2.2** Determine the temperature of the continuously energized winding at its nominal operating voltage under the condition of zero flow with the complete valve soaked in an ambient temperature equal to the temperature agreed for the test fluid by following the procedure outlined in 7.4.2.2.1 to 7.4.2.2.4. The mean winding temperature is calculated from the change in resistance of the winding after various periods of energization.

**7.4.2.2.1** Measure the basic resistance after the de-energized valve has soaked for not less than 4 h at the agreed ambient temperature.

**7.4.2.2.2** Energize the solenoid for 1 h. At the end of this period, measure the resistance 15 s after de-energization and at each 15 s interval thereafter over 90 s.

**7.4.2.2.3** Repeat the step outlined in 7.4.2.2.2 as often as is necessary until the temperature has stabilized.

**7.4.2.2.4** Determine the temperature at the instant of de-energization by regression analysis; this temperature is the continuously energized winding temperature.

**7.4.2.3** All subsequent tests shall be carried out after a period of energization which is sufficient to ensure that the temperature has stabilized.

**7.4.2.4** The operating thresholds of the valve shall be determined at a voltage 10 % below the nominal rating, unless other values are agreed.

**7.4.2.5** The tests shall be carried out over the agreed ranges of pressure and flow to determine the limiting conditions at which the control element just fails to complete its full displacement under the force produced by the solenoid and/or under the return force exerted by the spring or reverse direction solenoid.

**7.4.2.6** From this data obtained over an agreed number of tests, which shall be not less than six in total, determine the limiting values at which operation is consistently satisfactory.

**7.4.2.7** In order to demonstrate that the voltage has been maintained at the intended value at all current levels, record time-based readings of the current taken by the solenoid and the voltage at the terminals of the coil.

**7.4.3 Solenoid-controlled two-stage valves**

**7.4.3.1** Tests shall be carried out to determine the pilot pressure at which the final control element just fails to complete its full displacement.

**7.4.3.2** The test shall be carried out over the agreed ranges of pressure and flow and the ranges used shall be stated in the test report.

**7.4.3.3** The solenoid voltage shall be set at 10 % below the nominal rating, unless other values are agreed.

**7.4.3.4** From this data obtained over an agreed number of tests, which shall be not less than six in total, determine the limiting values at which operation is consistently satisfactory.

**7.4.3.5** In order to demonstrate that the voltage has been maintained at the intended value at all current levels, record time-based readings of the current taken by the solenoid and the voltage at the terminals of the coil.

#### 7.4.4 Pilot-pressure-operated valves

**7.4.4.1** Tests shall be carried out to determine the minimum pilot pressure at which the final control element just fails to complete its full displacement under the force exerted by the pilot and/or the return spring, or the reverse direction pilot piston.

**7.4.4.2** These tests shall be carried out over the agreed ranges of pressure and flow and the ranges used shall be stated in the test report.

**7.4.4.3** By agreement, these tests shall be carried out as follows:

- a) either apply a gradually increasing pilot pressure at a rate not exceeding 2 % of the maximum rated pilot pressure per second, or
- b) dynamically apply the pilot pressure at a rate of not less than 700 MPa/s (7 000 bar/s), or
- c) follow both procedures outlined in a) and b).

**7.4.4.4** From this data obtained over an agreed number of tests, which shall be not less than six in total, determine the limiting values at which operation is consistently satisfactory.

#### 7.4.5 Mechanically operated valves

**7.4.5.1** The tests shall be carried out over the agreed ranges of pressure and flow and the ranges used shall be stated in the test report.

**7.4.5.2** From this data obtained over an agreed number of tests, which shall be not less than six in total, determine the limiting values of control operating effort at which operation is consistently satisfactory.

#### 7.5 Transient characteristics

**7.5.1** Determine the transient characteristics of the valve at a flow rate equivalent to 80 % of the switching threshold at the maximum rated pressure and, where applicable, at the stated pilot pressure.

**7.5.2** For these tests, the capacitance of the circuits on the output side of the valve shall be limited to the volume enclosed by the valve, including its associated manifolds.

**7.5.3** The ports shall be blocked off in a manner appropriate to the pressures to be applied and the volumes shall be prefilled with the operating fluid.

**7.5.4** In the case of solenoid controlled valves, the test shall be carried out at the nominal rated voltage and at the temperature conditions of the solenoid, as specified in 6.2, the switching being initiated at the moment of zero voltage in the case of a.c. operation.

**7.5.5** In the case of pilot-pressure-operated valves, the rate of change of pressure in the pilot circuit shall be arranged so as to achieve rapid operation of the control element, for example by operating the mechanism by means of a falling weight.

**7.5.6** If practicable, obtain the delay times  $t_1$  and  $t_2$  and the response times  $t_3$  and  $t_4$  from recorded data indicating the spool displacement in response to the command signal to the control element (see figure 3).

**7.5.7** When presenting this data, the technique used for measuring the displacement shall also be described.

**7.5.8** Alternatively, obtain the delay times  $t_5$  and  $t_6$  and the response times  $t_7$  and  $t_8$  from recorded data indicating the rate of change of pressure in the outlet ports in response to the command signal to the control element (see figure 4).

### 8 Test procedure for non-return (check) valves

#### 8.1 Test circuits

**8.1.1** Test circuits similar to those shown in figures 5 and 6, for direct-acting non-return valves, and in figure 7, for pilot-pressure-operated non-return valves, shall be used.

**8.1.2** When testing pilot-pressure-operated non-return valves for which the flow is from port A to port B, the tests shall be carried out with and without pressure applied to port X. When the flow is reversed, i.e. from port B to port A, the pilot pressure shall be applied to port X.

#### 8.2 Pressure differential/flow characteristics

Determine the pressure differential/flow characteristics in accordance with the relevant clauses in ISO 4411.

#### 8.3 Pilot pressure

**8.3.1** The purpose of this test is to establish

- a) the minimum pilot pressure,  $p_{X, \text{open}}$ , necessary both to open the valve and to maintain it fully open;
- b) the maximum pilot pressure,  $p_{X, \text{closed}}$ , which will allow the valve to reseal, over an agreed range of pressures  $p_A$  and  $p_B$ , and flow  $q_V$ .

NOTE — Establish  $p_A$  before the valve is opened.

**8.3.2** With the system parameters  $p_A$ ,  $p_B$  and  $q_V$  under steady-state conditions, raise the pilot pressure,  $p_X$ , from zero to a value at which the flow reaches  $q_V$ .

**8.3.3** Record pilot pressure,  $p_X$ , and flow,  $q_V$ , on a suitable recording instrument and from the reading determine the minimum pilot pressure,  $p_{X, \text{open}}$  necessary to open the valve and to permit the selected flow conditions.

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**8.3.4** With the system parameters  $p_A$  as low as possible and  $p_B$  and  $q_V$  under steady-state conditions, lower the pilot pressure,  $p_X$ , at least until the valve closes.

**8.3.5** Record the pilot pressure,  $p_X$ , and flow,  $q_V$ , on a suitable recording instrument and from the reading determine the maximum pilot pressure,  $p_{X, \text{closed}}$ , to permit the valve to close.

## 8.4 Leakage

The leakage tests outlined in 8.4.1 and 8.4.2 shall be carried out for periods of 5 min and the quantities measured shall be recorded.

### 8.4.1 Direct acting valves

Measure the leakage from port A with the agreed range of pressure applied to port B and with port A at atmospheric pressure.

### 8.4.2 Pilot-pressure-operated valves

Measure the leakage from port A with the agreed range of pressure applied to port B and with ports A and X at atmospheric pressure; in addition, where applicable, measure the leakage from drain port Y.

## 9 Test procedure for valves controlling pressure

### 9.1 Test circuits

**9.1.1** Test circuits for pressure-relief and pressure-reducing valves similar to those shown in figures 8 and 9 respectively shall be used.

**9.1.2** The amplitude of the pressure ripple measured in the supply circuit shall not exceed  $\pm 0,5$  MPa (5 bar).

**9.1.3** The volumetric stiffness of the relevant parts of the test valve and circuit shall be such that the rate of change of pressure, with the maximum agreed input flow, lies within the limits of one agreed range selected from the following:

- 3 000 to 4 000 MPa/s (30 000 to 40 000 bar/s)
- 600 to 800 MPa/s ( 6 000 to 8 000 bar/s)
- 120 to 160 MPa/s ( 1 200 to 1 400 bar/s)

### 9.2 Control setting

**9.2.1** Immediately before the measurements specified in 9.2.2 are taken, operate the valve over the full cycle of its range of adjustment at least 10 times in quick succession.

**9.2.2** Measure the torque, force, pressure or electrical input necessary to change the control setting position throughout the pressure range from minimum to maximum and back to

minimum over the agreed range of flows through the valve. Record these values in the test report.

**9.2.3** In order to avoid inconsistencies due to silting, complete each set of measurements within 60 s of setting the control element position.

## 9.3 Pressure-relief valves

### 9.3.1 Steady-state pressure/flow characteristics

**9.3.1.1** Measure the inlet pressure  $p_a$ , as recorded by instrument **5a** of figure 8, for the range of flows from zero to the agreed maximum for both increasing flow and decreasing flow, at an agreed number of settings of the control element of the test valve, including the minimum and maximum adjustments provided on the valve.

**9.3.1.2** The pressure  $p_b$  in the return line, as recorded by instrument **5b**, at the outlet of the test valve in figure 8 shall be adjusted, by operating valve **8** so that it remains constant at agreed level(s).

### 9.3.2 Transient characteristics

**9.3.2.1** Measure the transient pressure  $p_a$  for any given setting of the control valve at agreed values of flow, by using valve **3a** (as shown in figure 8), which, when in the unloaded condition, shall reduce the pressure at the inlet of the test valve to not more than 20 % of the required operating pressure. The pressure  $p_a$  is indicated by instrument **5a** of figure 8.

**9.3.2.2** During pressure transient characteristic tests, the restrictor **8** in figure 8 shall be fully open.

**9.3.2.3** Record the pressure/time curve and deduce or record the rate of change of pressure. Record the mean linear rise value, in megapascals per second (MPa/s) [bars per second (bar/s)], over the portion from the operation of valve **3a** to the point of discontinuity, i.e. the point at which the valve starts to lift, as indicated in figure 17. Verify that, at the maximum agreed flow, this linearized rate falls within the selected range specified in 9.1.3.

**9.3.2.4** The operating time of valve **3a** in figure 8 shall not exceed 10 % of the linearized portion of the pressure/time curve as described in 9.3.2.3.

**9.3.2.5** The instrument used to measure the pressure gradient due to oil compressibility, as calculated from the expression  $\frac{dp}{dt} = \frac{q_V \cdot K_s}{V}$ , where  $V$  is the volume of fluid between test valve **6** and valves **3a** and **3b**, shall have a response capability at least 10 times the measured gradient.

NOTE — The response time and transient recovery time of the valve being tested are defined in figure 17.