International Standard ISO 7257

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION•МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ•ORGANISATION INTERNATIONALE DE NORMALISATION

Aircraft — Hydraulic tubing joints and fittings — Rotary flexure test

Aéronautique — Joints et raccords pour tubes hydrauliques — Essai de flexion rotative

First edition — 1983-07-01

UDC 621.643.4 : 629.7 : 620.178.325.3 **Ref. No. ISO 7257-1983 (E)**

Descriptors : aircraft industry, aircraft equipment, hydraulic installation, pipe fittings, couplings, tests, fatigue tests, fatigue (materials).

Price based on 9 pages

Foreword

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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.

International Standard ISO 7257 was developed by Technical Committee ISO/TC 20, *Aircraft and space vehicles*, and was circulated to the member bodies in November 1981.

It has been approved by the member bodies of the following countries:

Australia	Egypt, Arab Rep. of	South Africa, Rep. of
Austria	France	Spain
Belgium	Germany, F.R.	Sweden
Brazil	Italy	United Kingdom
Canada	Mexico	USA
China	Netherlands	
Czechoslovakia	Romania	

The member body of the following country expressed disapproval of the document on technical grounds:

USSR

Aircraft — Hydraulic tubing joints and fittings — Rotary flexure test

0 Introduction

This International Standard describes a flexure fatigue test procedure which allows evaluation of various tube fitting designs or material combinations. This evaluation is performed by fatigue testing the tube joints over a spectrum of bending stresses and then plotting the cycles to failure. This test procedure is intended for comparative evaluation of fatigue characteristics only, the qualification test procedure for tube fittings being specified in ISO 7169. Other test methods may be used as long as they develop the same data as the rotary flexure test.

1 Scope and field of application

This International Standard specifies flexure test procedures to determine and classify the fatigue strengths of reconnectable or permanent hydraulic tube joints.

The procedure is intended for conducting flexure tests of fittings and joints with high strength hydraulic tubes of various alloys such as corrosion resistant steel, Nimonic, titanium and aluminum alloy hydraulic tube for use on commercial and military aircraft.

A mean stress is applied by holding system pressure in the specimens and then flexing in a rotary bending test machine.

2 References

ISO 2964, *Aircraft — Tubing outside diameters and thicknesses, metric dimensions.*

ISO 7169, *Separable tube fittings for fluid systems — General specification.*[1)]

3 Requirements

3.1 Flexure test device

The test device should be capable of testing in-line or bulkhead union test specimens and other configurations such as elbows and tees.

The rotary flexure test device should be similar to that shown in figure 1. Each rotary flexure test device should be capable of testing one specimen, but several specimens may be mounted on one plate.

The device should be capable of constantly maintaining the required operating pressure during the test. The test fluid shall be water or system fluid (working fluid) unless otherwise specified by the responsible authorities. A typical pressurization and automatic shutdown system is shown in figure 2. The shutdown should be automatic in the event of failure or pressure drop. The device should be capable of testing at controlled constant temperature, if specified by the procuring agency. The tailstock of the test device should be designed to permit alignment during initial installation and specimen mounting, and to serve as a pressure manifold. The rotating headstock should have a low-friction, self-aligning bearing and should be designed to permit total deflections of up to 25 mm, and a constant rotational frequency within the range of 1 500 to 3 600 min^{-1}. The base should be of rigid construction.

3.2 Flexure test specimen

The test specimen should consist of an adapter fitting (headstock end), a section of straight tubing, and a test fitting at the tailstock end. Typical test specimens are shown in figure 3. The tubing shall be of a size and wall thickness as specified by the user or procuring agency.

1) At present at the stage of draft.

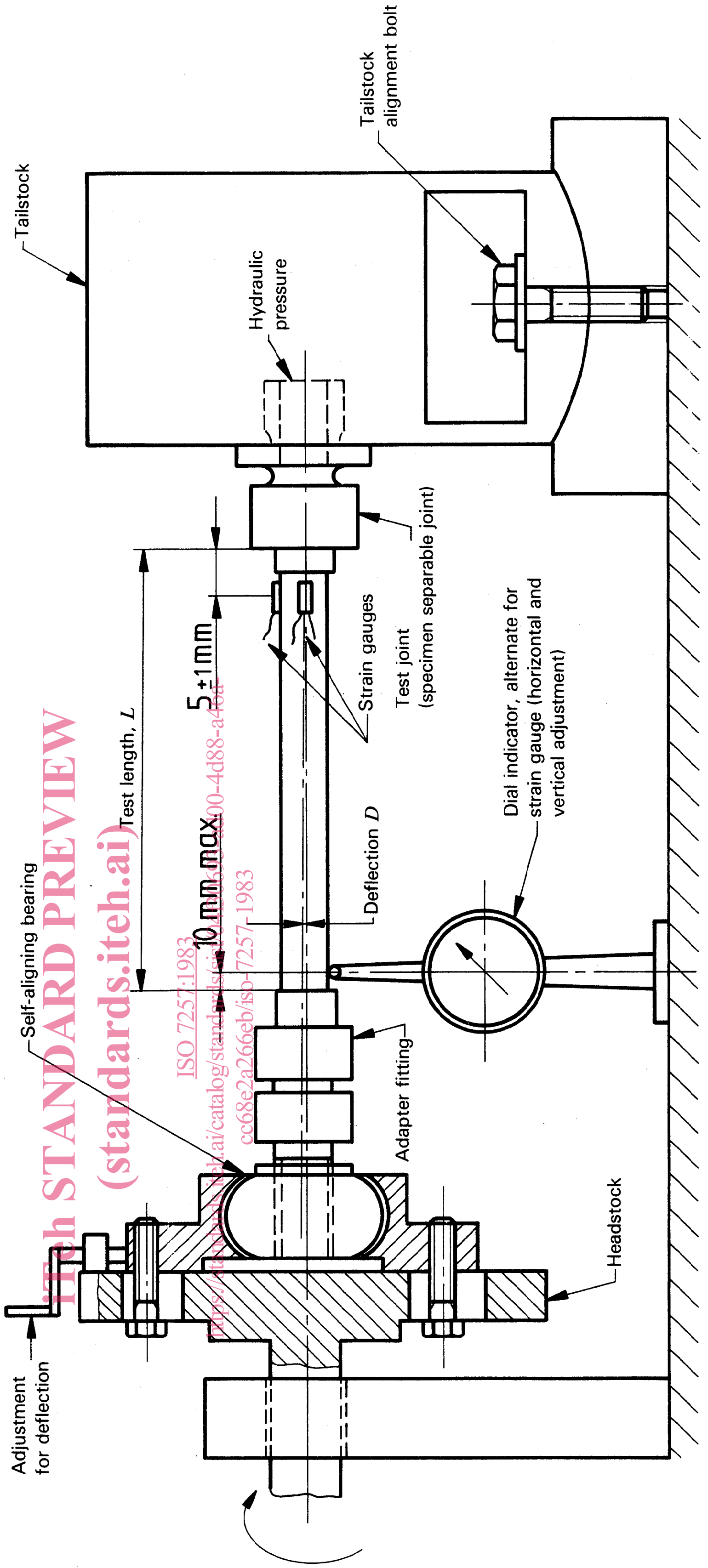


Figure 1 — Typical rotary flexure test schematic

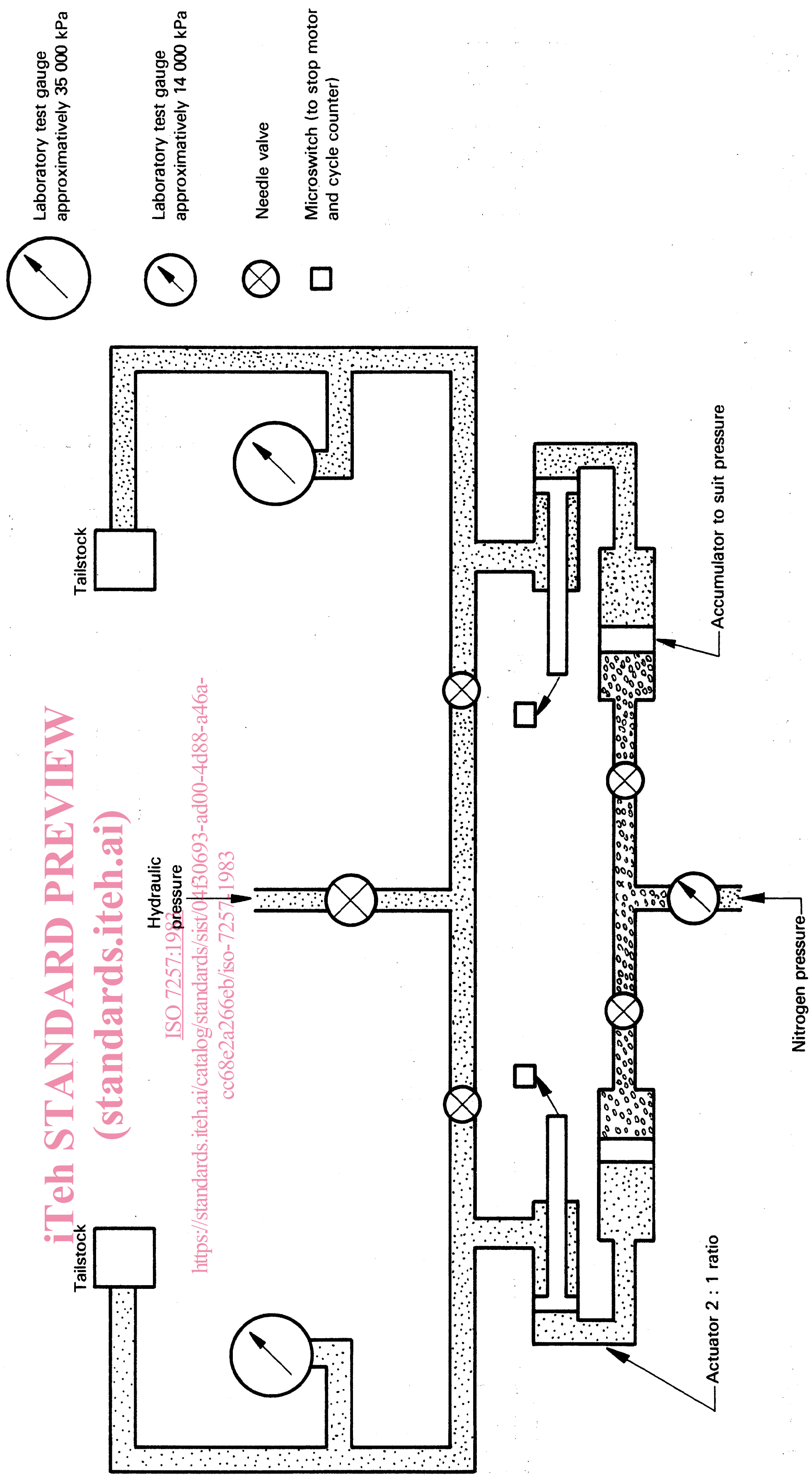


Figure 2 — Typical rotary flexure test hydraulic schematic

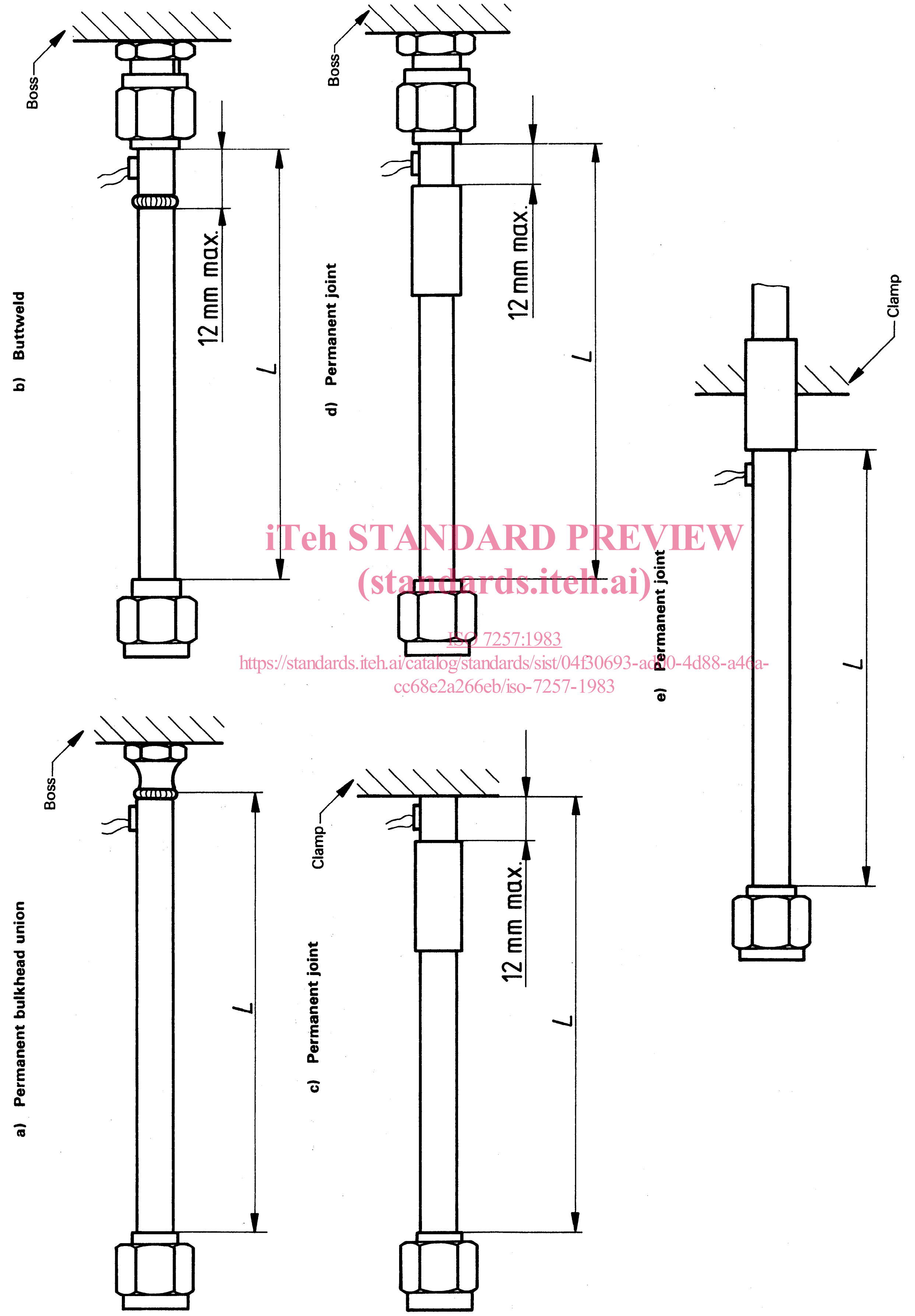
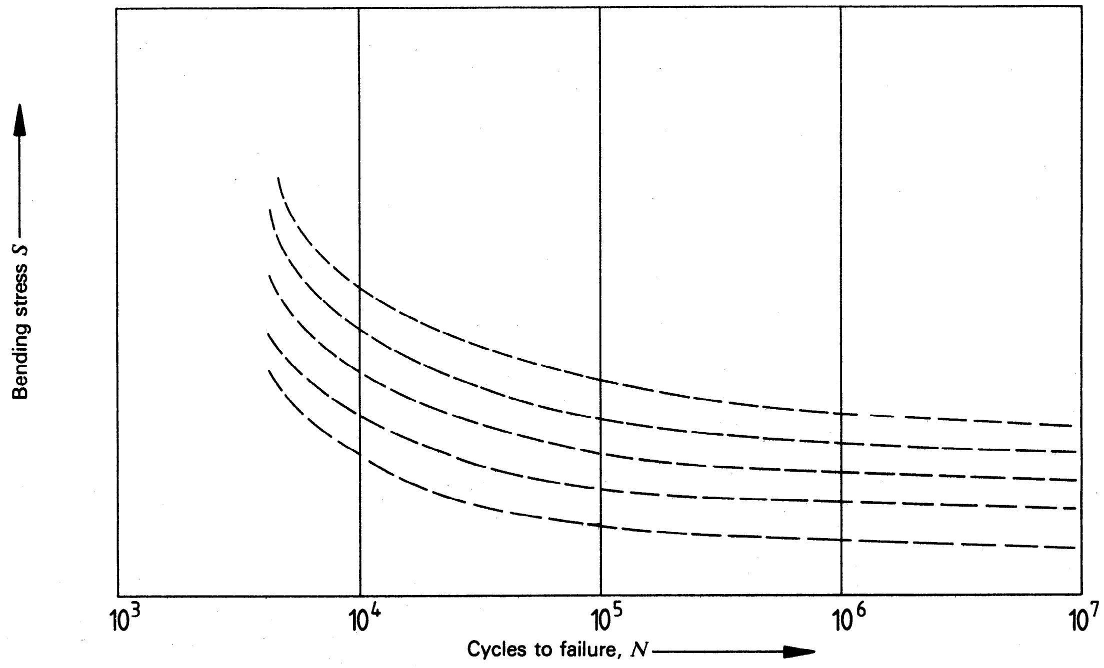


Figure 3 — Alternate specimen mounting for permanent joints



NOTE — Such curves could be established to illustrate possible differences observed in comparison testing of different materials or fitting attachments.

Figure 4 — S/N curves for characterizing various types of tubing or fitting joints

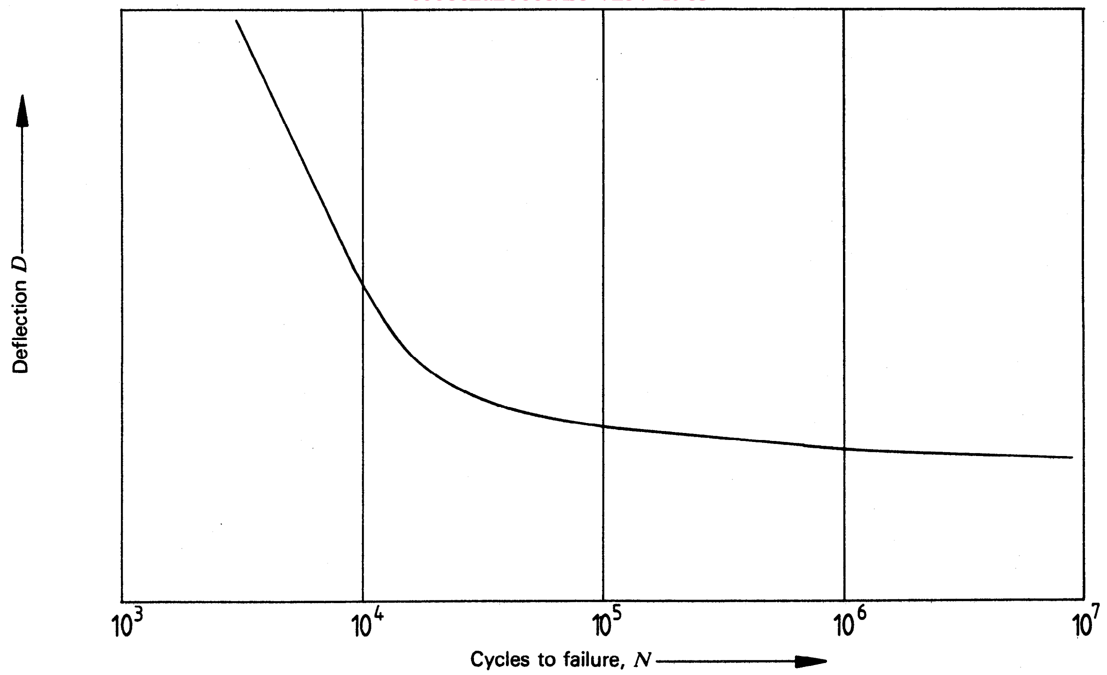


Figure 5 — D/N curve deflection/fatigue strength

NOTE — The correlation between the strain gauge reading and deflection may vary for different fitting designs. For example, a mechanically attached fitting may show some movement in the fitting, whereas a weld joint will be rigid. Also, a significant difference is noted if the S/N and D/N curves are compared for different tubing such as titanium alloy and corrosion resistant steel.

3.3 Specimen length and deflection requirements

3.3.1 Specimen length

The length, L, of the specimens for rotary flexure testing shall be as shown in the table and measured as shown in figure 1 or 3, depending on the fitting design. For intermediate sizes the length L may be interpolated from the table.

3.3.2 Stress determination

The desired strain or bending stress level for each set of specimens is induced by deflection of the specimen in the headstock. The bending stress levels for the various deflection settings should be determined prior to applying pressure, using strain gauges and procedures as outlined in clause 4. Strain gauges should always be used unless continual use of the same specimens and equipment makes settings by dial indicator acceptable. Such settings by dial indicator, however, must be established in prior testing by the use of strain gauges. Strain gauges should be used whenever new test equipment is used. A typical stress cycle is illustrated in figure 6.

3.3.3 Deflection

The specimen deflections required to induce the stress levels indicated in 4.2 are measured by dial indicator at the length, L, as shown in figure 1 or 3.

NOTE — Established deflection settings may be used in lieu of stress determination by strain gauge whenever qualification tests are being conducted, or when deflection plotting is of particular interest, for example, to compare steel and titanium tubing.

3.4 Method of classification of fittings according to S/N flexure performance

Fitting/tubing combinations should be classified by the characteristic curves as shown in figure 4, above which all S/N failure data points lie. Characteristic curves should be established as outlined in 4.2, showing cycles to failure for various bending stress levels.

3.5 Method of determining deflection/fatigue strength

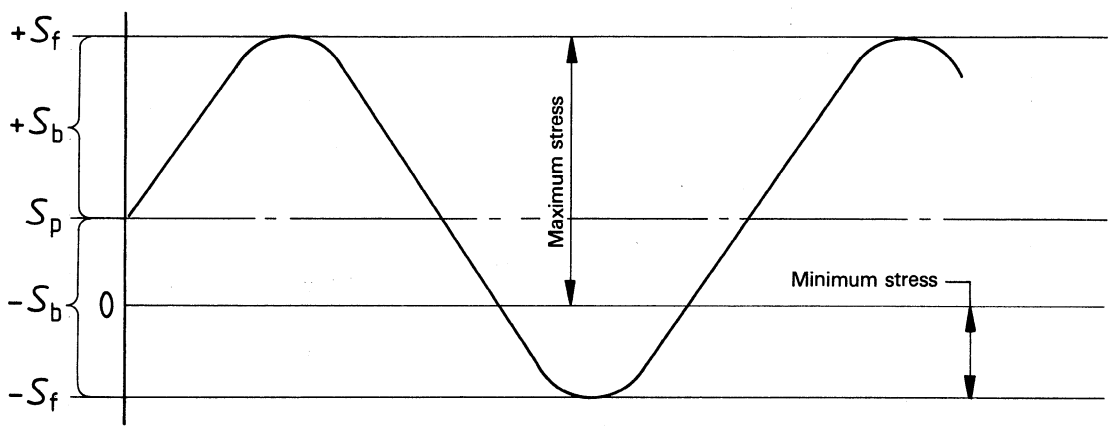
Cycles to failure should be plotted as shown in figure 5, showing cycles to failure for various deflection settings (deflection settings may correspond with bending stress levels used as outlined in 3.4).

NOTE — Plotting of deflection in lieu of stress over cycles may be of interest to evaluate rigidity of fittings or compare the flexibility of different tubing materials such as corrosion-resistant steel and titanium.

Table — Test specimen length

Tube size*	DN 05	DN 06	DN 08	DN 10	DN 12	DN 14	DN 16	DN 20	DN 25	DN 32	DN 40
Length, L mm	130	155	180	190	230	245	255	280	305	355	400

* Selected from ISO 2964. The "DN" designates nominal tube outside diameters, for example, DN 05 designates a 5 mm tube outside diameter.



S_p = mean axial stress produced by internal pressure

S_b = stress caused by bending

S_f = combined stress, $S_p + S_b$

Figure 6 — Typical alternating stress cycle with internal pressure

4 Procedure

4.1 Preparation for test

4.1.1 Instrumentation, strain gauges

Strain gauges should be mounted on each test specimen. The strain gauge type and location should be as follows :

Types : For tube sizes through DN 16 : approximately 4 mm

For tube sizes DN 20 and above : approximately 8 mm

Location : The gauges should be mounted as shown in figure 1, 90° apart.

NOTE — Mounting of four gauges, in pairs, on the X and Y axis is optional.

4.1.2 Rotary flexure test set-up centring

The exact outside diameter and wall thickness of the test specimen should be measured and recorded before the test. It is also recommended to check straightness, and if not straight, to reject or at least to mark the specimen in the plane where the tube end is not aligned.

The tube assembly should be installed into the tailstock and the separate fittings hand tightened to permit subsequent adjustments. The set-up procedure is detailed as follows :

Free-state microstrain readings for the tube specimen should be measured and recorded prior to installation and tightening of the fitting nut.

The self-aligning bearing at the headstock end should be roughly centred and the adapter inserted. The tailstock end should then be carefully tightened so as to avoid moving the test specimen out of line.

The symmetry of the specimen should be maintained during the tightening procedure with the assistance of one, preferably two, dial indicators positioned on the driven end of the tube. After tightening the adjustment bolts in the centred position, the symmetry must be checked in the horizontal and vertical positions. While turning the headstock by hand, each dial indicator should indicate less than ± 0,08 mm nonsymmetrical deflection. For strain gauged specimens the microstrain reading should deviate no more than ± 20 microstrain from the free state microstrain reading referred to above. For each checking the headstock shaft may be moved back and forth in its bearing. The shaft will move freely for properly aligned specimens.

4.1.3 Flexure deflection measurement

The deflection setting is measured by dial indicator as shown in figure 1 and the table.

4.1.4 Operating pressure

After the tube bending settings are completed by using the strain gauge (S/N) or dial indicator (D/N) methods described in clause 3, the specified system pressure is introduced into the specimens.

4.2 S/N testing

4.2.1 A minimum of four sets of at least two specimens (specimen pairs) in each size should be subjected to flexure testing and the test results plotted on a semi-log plot, over a grid of S/N characteristic curves, as shown in figure 4.

4.2.2 A bending stress of 35 % of the ultimate strength should be applied to the first set of specimens.

NOTE — The bend stress settings should be made prior to applying system pressure, which is to be maintained until failure or completion of the test.

4.2.3 If the failure point for the first set lies between 5 000 and 50 000 cycles, the bending stress should be reduced by approximately 25 % of the ultimate strength for the second test set.

4.2.4 If the failure point for the second set lies between 200 000 and 1 million cycles, the bending stress should be lowered by increments of 2 %.

4.2.5 After two or more sets of data points are plotted, an examination of the data will indicate the probable stress level for the last test sets. These levels should be selected to complete the S/N curve form, with the last test set completing or exceeding 10 million flexure cycles. At least three sets should fail at less than 10 million cycles.

NOTE — After a failure, deflection and torque tightness of the fitting nut should be checked and recorded.

4.3 Deflection/fatigue testing

The same basic procedure should be followed as outlined in 4.2, except that the deflection settings are plotted over cycles to failure, as shown in figure 5.

5 Equipment

Suggested test fixtures : photographs of a suggested set-up are shown in figures 7 and 8.