

INTERNATIONAL
STANDARD

ISO
10767-1

First edition
1996-04-01

**Hydraulic fluid power — Determination of
pressure ripple levels generated in systems
and components —**

iTeh STANDARD PREVIEW

Part 1:

Precision method for pumps

ISO 10767-1:1996

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*Transmissions hydrauliques — Détermination des niveaux d'onde de
pression engendrés dans les circuits et composants —*

Partie 1: Méthode de précision pour les pompes



Reference number
ISO 10767-1:1996(E)

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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 voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 10767-1 was prepared by Technical Committee ISO/TC 131, *Fluid power systems*, Subcommittee SC 8, *Product testing and contamination control*.

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ISO 10767 consists of the following parts under the general title *Hydraulic fluid power — Determination of pressure ripple levels generated in systems and components*:

- Part 1: *Precision method for pumps*
- Part 2: *Simplified method for pumps*
- Part 3: *Method for motors*

Annexes A and B form an integral part of this part of ISO 10767. Annexes C and D are for information only.

Introduction

In hydraulic fluid power systems, power is transmitted and controlled through a liquid under pressure within an enclosed circuit. Positive-displacement pumps are components that convert rotary mechanical power into hydraulic fluid power. During the process of converting mechanical power into hydraulic power, flow and pressure fluctuations and structure-borne vibrations are generated.

These fluid-borne and structure-borne vibrations, which are generated primarily by the unsteady flow produced by the pump, are transmitted through the system at levels depending upon the characteristics of the pump and the circuit. Thus, the determination of the pressure ripple generated by a pump is complicated by the interaction between the pump and the circuit. The method adopted to measure the pressure ripple levels of a pump should, therefore, be such as to eliminate this interaction.

The measurement technique described in this part of ISO 10767 isolates the pump flow and/or pressure ripple from the effects of such circuit interactions, by mathematical processing of pressure ripple measurements (see refs. [1] to [8]). A figure of merit for the pump is obtained which allows pumps of different types and manufacture to be compared as pressure ripple generators. This will enable the pump designer to evaluate the effect of design modifications on the pressure ripple levels produced by the pump in service. It will also enable the hydraulic system designer to avoid selecting pumps having high pressure ripple levels.

The method is based upon the application of plane wave transmission line theory to the analysis of pressure fluctuations in hydraulic systems^[9]. By evaluating the impedance characteristics of the circuit into which the pump discharges and the impedance of the pump itself, it is possible to isolate the source flow ripple and/or pressure ripple of the pump from the interactions of the circuit. The impedance characteristics of the circuit can be evaluated by analysis of pressure ripple measurements at two or more positions along a pipe, where the pipe is connected to the discharge port of the pump. However, to characterize the impedance of the system completely, it is not sufficient to measure the pressure ripple generated by the pump alone, as insufficient information is available for the impedance of the pump to be evaluated. The secondary-source method uses another source of pressure ripple at the opposite end of the discharge line. The measurement of this pressure ripple enables the pump source impedance to be evaluated. Sufficient information is then available to evaluate the source flow ripple and pressure ripple of the pump.

Because of the complexity of the analysis, data processing is preferably carried out using a digital computer. Suitable software packages are available from two sources (see annex C).

Hydraulic fluid power — Determination of pressure ripple levels generated in systems and components —

Part 1: Precision method for pumps

1 Scope

This part of ISO 10767 specifies a procedure for the determination of a rating of the source flow ripple, source impedance and pressure ripple levels generated by positive-displacement hydraulic pumps. Ratings are obtained as the following:

- a) the source flow ripple amplitude, in litres per second, over ten individual harmonics of pumping frequency;
- b) the source impedance amplitude, in newton seconds per metre to the power of five $[(N \cdot s)/m^5]$, and phase, in degrees, over ten individual harmonics of pumping frequency;
- c) the anechoic pressure ripple amplitude, in bars¹⁾, over ten harmonics of pumping frequency;
- d) the overall r.m.s. anechoic pressure ripple, in bars;
- e) the blocked acoustic pressure ripple amplitude, in bars, over ten harmonics of pumping frequency;
- f) the overall r.m.s. blocked acoustic pressure ripple, in bars.

This part of ISO 10767 is applicable to all types of positive-displacement pump operating under steady-state conditions, irrespective of size, provided that the pumping frequency is in the range from 50 Hz to 400 Hz.

1) $1 \text{ bar} = 10^5 \text{ Pa} = 10^5 \text{ N/m}^2$

2 Definitions

For the purposes of this part of ISO 10767, the following definitions apply.

2.1 source flow ripple: Fluctuating component of flowrate generated within the pump, which is independent of the characteristics of the connected circuit.

2.2 flow ripple: Fluctuating component of flowrate in the hydraulic fluid, caused by interaction of the source flow ripple with the system.

2.3 pressure ripple: Fluctuating component of pressure in the hydraulic fluid, caused by interaction of the source flow ripple with the system.

2.4 anechoic pressure ripple: Pressure ripple that would be generated at the pump discharge port when discharging into an infinitely long rigid pipe of the same internal diameter as the pump discharge port.

2.5 blocked acoustic pressure ripple: Pressure ripple that would be generated at the pump discharge port when discharging into a circuit of infinite impedance.

2.6 impedance: Complex ratio of the pressure ripple to the flow ripple occurring at a given point in a hydraulic system and at a given frequency.

2.7 source impedance: Impedance of a pump at the discharge port.

2.8 harmonic: Sinusoidal component of the pressure ripple or flow ripple occurring at an integral multiple of the pumping frequency.

NOTE 1 A harmonic may be represented by its amplitude and phase, or alternatively by its real and imaginary components.

2.9 pumping frequency: Frequency given by the product of shaft rotational frequency and the number of pumping elements on that shaft. It is expressed in hertz.

2.10 shaft rotational frequency: Frequency (in hertz) given by the shaft rotational speed (in r/min) divided by 60.

3 Instrumentation

3.1 Static measurements

The instruments used to measure

- a) mean fluid flow,
- b) mean fluid pressure,
- c) shaft rotational speed, and
- d) fluid temperature

shall meet the temperature for "industrial class" accuracy of measurement, i.e. class C given in annex A.

3.2 Dynamic measurements

The instruments used to measure pressure ripple shall have the following characteristics:

- a) resonant frequency ≥ 30 kHz;
- b) linearity $< \pm 1$ %.

The instruments need not respond to steady-state pressure, and it may be advantageous to filter out any steady-state signal component using a high-pass filter. This filter shall not introduce an additional amplitude or phase error exceeding 1 % or 2°, respectively, at the pumping frequency.

3.3 Frequency analysis of pressure ripple

A suitable instrument shall be used to measure the amplitude and phase of the pressure ripple, for at least ten harmonics of the pumping frequency.

The instrument shall be capable of measuring the pressure ripple from two or three pressure transducers (6.7) such that, for a particular harmonic, the measurements from each transducer are synchronized in time with respect to each other. This may be achieved by sampling the pressure ripple from each pressure transducer simultaneously, or by sampling each pressure transducer separately but with respect to a trigger signal obtained from a fixed reference on the pump shaft or secondary source drive, as appropriate.

The instruments shall have an accuracy and resolution for harmonic measurements as follows, over the frequency range from 50 Hz to 4 000 Hz:

- a) amplitude within ± 1 %;
- b) phase within $\pm 1^\circ$;
- c) frequency within $\pm 0,5$ %.

Compliance with the above tolerances will result in an uncertainty in the overall r.m.s. pressure ripple rating of within ± 10 %.

4 Pump installation

4.1 General

The pump shall be installed in the attitude recommended by the manufacturer and mounted in such a manner that the response of the mounting-to-pump vibration is minimized.

4.2 Drive vibration

The prime mover and associated drive couplings shall not generate torsional vibration in the pump shaft. If necessary, the pump and the driving unit shall be isolated from each other to eliminate vibration generated by the prime mover.

4.3 Reference signal

A means of producing a reference signal relative to the pump shaft rotation shall be included. The signal shall be an electrical pulse occurring once per revolution, with sharply defined rising and falling edges. This signal is used as a measure of the shaft rotational speed and may be used, if necessary, to provide a

trigger signal and/or phase reference for the pressure ripple analysis instrument.

5 Test conditions

5.1 General

The required operating conditions shall be maintained throughout each test within the limits specified in table 1.

5.2 Fluid temperature

The temperature of the fluid shall be that measured at the pump inlet.

5.3 Fluid density and viscosity

The density and viscosity of the fluid shall be known to an accuracy within the limits specified in table 2.

5.4 Fluid bulk modulus

The isentropic tangent bulk modulus of the fluid shall be known to an accuracy within the limits specified in table 2. As this is not always feasible, B.4.2 details a method by which the bulk modulus may be evaluated with a sufficiently high accuracy.

Table 1 — Permissible variations in test conditions

Test parameter	Permissible variation
Mean flow	$\pm 2 \%$
Mean pressure	$\pm 2 \%$
Shaft rotational frequency	$\pm 1 \%$
Temperature	$\pm 2 \text{ }^\circ\text{C}$

Table 2 — Required accuracy of fluid property data

Property	Required accuracy
Density ¹⁾	$\pm 2 \%$
Viscosity ¹⁾	$\pm 5 \%$
Isentropic tangent bulk modulus ²⁾	$\pm 5 \%$
1) See reference [10].	
2) See reference [11].	

6 Test rig

6.1 General

The test rig shall be installed generally as shown in figure 1. The test rig shall include all fluid filters, fluid coolers, reservoirs, loading valves and any ancillary pumps required to meet the pump hydraulic operating conditions. Specific features are described in 6.2 to 6.13.

6.2 Test fluid

The type of test hydraulic fluid and the quality of filtration shall be in accordance with the pump manufacturer's recommendations.

6.3 Pump

The pump shall be installed in the "as-delivered" condition.

6.4 Inlet line

The internal diameter of the inlet line to the pump shall be in accordance with the pump manufacturer's recommendations. To prevent air leaking into the circuit, care shall be exercised when assembling the inlet lines. The supply pressure shall be in accordance with the pump manufacturer's recommendations and, if necessary, a boost pump shall be used.

6.5 Inlet pressure gauge

The inlet pressure gauge shall be mounted at the same height as the inlet fitting or shall be calibrated for any height difference therefrom.

6.6 Pump discharge port connection

The adaptor connecting the pump discharge port to the discharge pipe shall have an internal diameter which does not differ from the discharge pipe diameter by more than 10 % at any point. Any such variations in internal diameter shall occur over a length not exceeding twice the internal diameter of the pipe. The adaptor shall be arranged in order to prevent the formation of air pockets in it. The discharge pipe shall be mounted in line with the pump discharge port without any changes in direction.

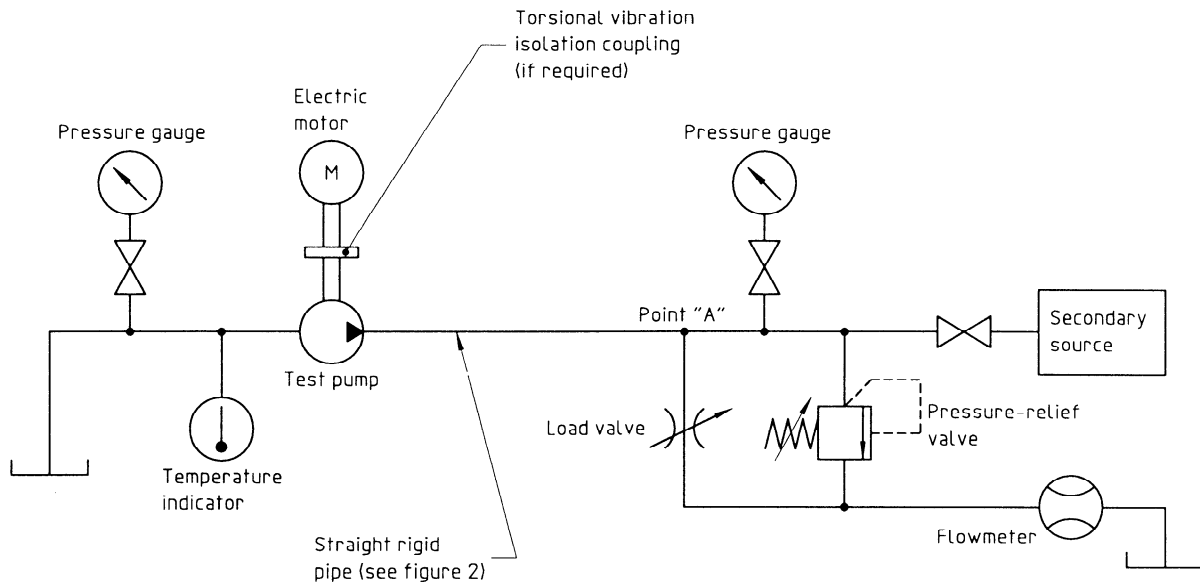


Figure 1 — Circuit diagram for secondary-source test rig

6.7 Pump discharge line

The discharge pipe shall be a uniform, rigid, straight metal pipe. Pressure transducers shall be mounted along its length, as shown in figure 2. The internal diameter of the pipe shall be between 80 % and 120 % of the diameter of the pump discharge port. The pipe shall be supported in such a manner that pipe vibration is minimized.

The pressure transducers shall be mounted such that their diaphragms are flush with the inner wall of the pipe to within $\pm 0,5$ mm. No valves, pressure gauges or flexible hoses shall be installed between the pump discharge port and point "A" as shown on figure 1.

Two alternative specifications for the pump discharge line are given, depending on whether the isentropic tangent bulk modulus of the fluid is known within the limits specified in table 2. These alternatives are henceforth known as "method 1" and "method 2". Method 1 is acceptable for use in all situations. However, if the isentropic tangent bulk modulus is known within the limits specified in table 2, economies can be made by using method 2.

If method 1 is used, set up the pump discharge line as specified in 6.7.1. If method 2 is used, set it up as specified in 6.7.2.

6.7.1 Method 1

Three pressure transducers are required for this method, set up as shown in figure 2. The dimensions of the discharge pipe shall be selected according to

the pumping frequency. When the series of tests includes a range of pump speeds, the dimensions shall be selected in relation to the minimum pumping frequency, $f_{0,min}$, in that series. The overall length of the discharge pipe, l , and the distance of the pressure transducers from the pump, x_1 , x_2 and x_3 , are specified in table 3.

Table 3 — Pipe length and transducer positions: Method 1

Pipe length and transducer positions	Minimum pumping frequency, Hz	
	$50 \leq f_{0,min} \leq 100$	$100 < f_{0,min} \leq 400$
x_1	$0,15 \text{ m} \pm 1 \%$	$0,1 \text{ m} \pm 1 \%$
x_2	$0,85 \text{ m} \pm 1 \%$	$0,43 \text{ m} \pm 1 \%$
x_3	$1,85 \text{ m} \pm 1 \%$	$0,9 \text{ m} \pm 1 \%$
l	at least 2 m	at least 1 m

6.7.2 Method 2

Two pressure transducers are required for this method, set up as shown in figure 2. The length of the discharge pipe and the positions of the pressure transducers shall be selected according to the pumping frequency. When the series of tests includes a range of pumping frequencies, the dimensions shall be selected in relation to the maximum pumping frequency in that series. The ratio of maximum to minimum speed for a selected transducer spacing shall not exceed 4:1. If the speed range of a test series exceeds this limit, different transducer spacings will be required.

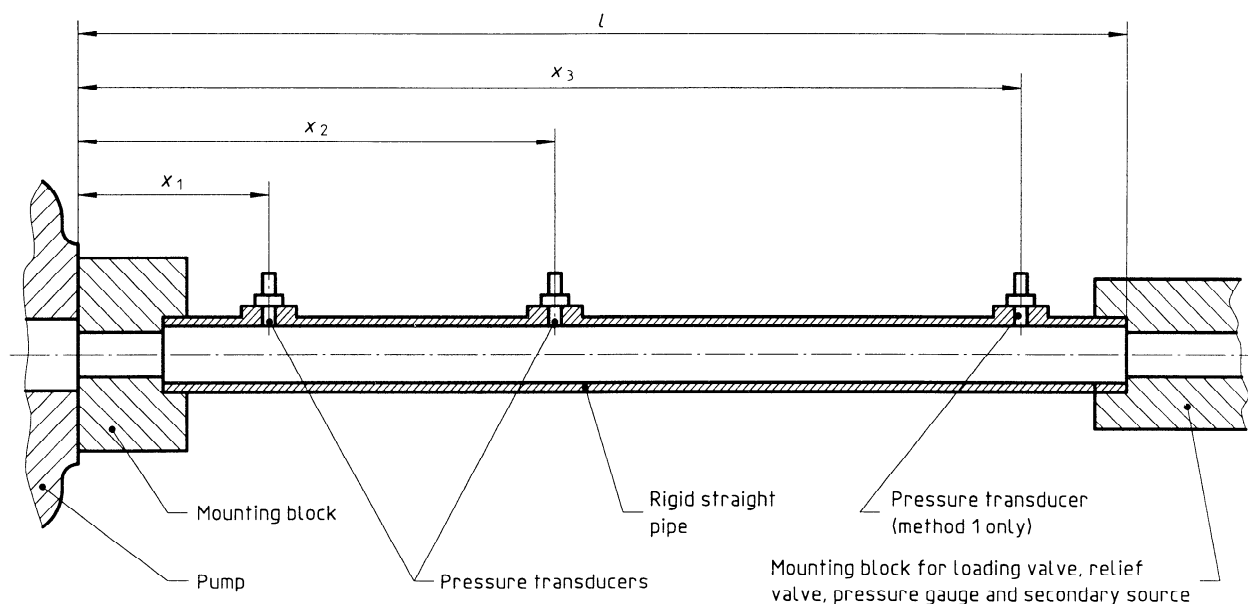


Figure 2 — Arrangement of discharge pipe

The distance between the pressure transducers shall be as given by the following equation, to within 1 %:

$$x_2 - x_1 = \frac{\sqrt{(B_{\text{eff}} \times 10^5 / \rho)}}{(67 \times f_{0, \text{max}})}$$

where

- $f_{0, \text{max}}$ is the maximum pumping frequency, in hertz;
- B_{eff} is the effective bulk modulus, in bars (see B.3);
- ρ is the density, in kilograms per cubic metre.

The first pressure transducer shall be located as close as possible to the pump flange and no more than $(x_2 - x_1)$ m away. The length l shall be at least $(x_2 + 10d)$ m, where d is the internal diameter of the pipe.

6.7.3 Calibration of pressure transducers

Calibration of the pressure transducers and signal conditioning is necessary. Relative calibration shall be performed by mounting the pressure transducers in a common block such that they measure the same pressure ripple. This common block shall be such that the pressure transducers are at the same axial position and not more than 20 mm apart.

Use the secondary source (6.11) to generate pressure ripple. Measure the amplitude and phase relationship between the pressure transducers for a range of frequencies spanning the complete range of interest (7.3.2) with one transducer used as a reference. For piezo-resistive transducers, the reference transducer can be calibrated statically using, for example, a dead-weight testing machine. If piezo-electric transducers and charge amplifiers are employed, a calibrated piezo-resistive transducer may be used as a reference for dynamic calibration purposes. The amplitude and phase differences at each frequency shall be known to an accuracy of within 3 % and 2° for method 1, or 3 % and 0,5° for method 2. These differences shall be corrected in the tests (see clause 7).

6.8 Load valve

Loading of the pump shall be effected using a needle valve or equivalent. A valve with freely moving parts, such as a pressure-relief valve, shall not be used for loading purposes.

6.9 Relief valve

A relief valve may be fitted for safety purposes. The valve shall be set to relieve at a pressure at least 20 % greater than the mean test pressure.

6.10 Pressure gauge

A pressure gauge shall be fitted as shown in figure 1, together with a throttling valve to reduce gauge oscillation. Alternatively, a pressure transducer may be used.

6.11 Secondary source

6.11.1 A device capable of generating pressure ripple shall be fitted as shown in figure 1.

6.11.2 The pressure ripple from the secondary source shall span the frequency range from the pumping frequency of the test pump to at least ten times the pumping frequency.

6.11.3 The pressure ripple from the secondary source shall have a periodic waveform. The secondary source may produce either a multi-harmonic pressure ripple waveform or a pressure ripple waveform which may be swept in discrete frequency steps to cover the range specified in 6.11.2. Pressure ripple shall be measurable at a minimum of ten frequencies over this range. The harmonic frequencies from the secondary source shall not vary by more than 0,5 % once a stable running condition has been achieved.

6.11.4 It is necessary that the frequencies of the components of the pressure ripple from the secondary source be different from those of the test pump, in order that they may be measured without interference.

6.11.5 Devices which are suitable for the secondary source include the following.

- a) **Positive-displacement pump:** a piston pump is likely to provide strong harmonic components over a broader frequency range than, for example, a gear pump, and is thus likely to be more suitable.
- b) **Intermittent bleed-off,** such as valve with a rotating spool allowing flow to pass to the return line over part of its rotation.
- c) **Electromechanical vibrator and piston arrangement.**

6.12 Ball valve

A ball valve shall be used to isolate the secondary source from the high-pressure part of the circuit. This valve shall be sufficiently large to present negligible

restriction to flow when open, in order to prevent excessive attenuation of the pressure ripple from the secondary source.

6.13 Mounting

The discharge pipe, valves and secondary source shall be mounted such as to prevent excessive vibration, and shall be adequately supported.

7 Test procedure

7.1 General

The test procedure involves two separate parts: evaluation of the source impedance and of the source flow ripple. The source flow ripple cannot be evaluated without first evaluating the source impedance. Data acquisition and data reduction are normally performed separately.

Prior to the commencement of a series of tests, operate the pump for a sufficient period of time to purge air from the system and to stabilize all variables, including the condition of the fluid, to within the limits given in table 1.

7.2 Test series

For each test, repeat the procedure described in 7.3 to 7.5.

The test is invalid if the peak-to-peak value of the pressure ripple at any one pressure transducer is greater than 50 % of the value of the mean pressure. [If necessary, it may be possible to avoid this condition by altering the pipe length l (6.7).]

7.3 Evaluation of source impedance

In this part of the test the pressure ripple from the secondary source is considered. It is essential that this be measured in isolation from the pressure ripple produced by the test pump. This may be achieved by satisfying each of the following criteria.

- a) The pressure ripple shall be measured only at harmonic frequencies of the secondary source. If a trigger signal is required by the instrument, this is also taken from the secondary source.
- b) The pressure ripple analysis instrument shall sample the pressure ripple signals over a sufficiently long period of time to provide the required frequency resolution.

- c) The harmonic frequencies of the secondary source shall not coincide with those of the pump (6.11).

7.3.1 Open the ball valve (6.12). Operate the secondary source for a sufficient period of time for it to reach a stable condition before taking any measurement.

7.3.2 Measure at least ten frequency components from the pressure transducers, sufficient to span the frequency range from the pumping frequency of the test pump to beyond ten times that pumping frequency.

7.3.3 If method 1 is used (6.7.1), analyse the pressure ripple using the procedure described in B.4.

7.3.4 If method 2 is used (6.7.2), analyse the pressure ripple using the procedure described in B.5.

7.3.5 Select whether a distributed-parameter or lumped-parameter mathematical model is to be used, as described in B.6. Apply a mathematical model to the source impedance using the procedure described in B.6.1 for a distributed-parameter model or B.6.2 for a lumped-parameter model.

7.3.6 In certain circumstances it may be possible to obtain good correlation between the experimentally measured source impedance and the mathematical model. Should this be the case, the curve-fitting technique is inappropriate. It is then necessary to evaluate the source impedance at the harmonic frequencies of the pump by linear interpolation. In order to perform this, the source impedance at a pump harmonic frequency shall be evaluated by interpolating between the measured source impedance at the nearest frequency above and below the pump harmonic frequency, providing that these frequencies comply with the following:

$$(f_i - f_0/10) < f_L < f_i$$

$$f_i < f_H < (f_i + f_0/10)$$

where

- f_i is the frequency of the i th harmonic from the test pump;
- f_0 is the fundamental frequency of the test pump;
- f_L is the nearest harmonic frequency from the secondary source above the i th harmonic frequency from the test pump;

- f_H is the nearest harmonic frequency from the secondary source above the i th harmonic frequency from the test pump.

It should be noted that a variable-speed secondary source will normally be necessary to comply with the above requirements.

7.4 Evaluation of source flow ripple, anechoic pressure ripple and blocked acoustic pressure ripple

Stop the secondary source and close the ball valve. If a trigger signal is required by the pressure ripple analysis instrument, this shall be from the shaft of the test pump (4.3).

At each pressure transducer, measure ten harmonics of the pressure ripple from the test pump.

7.4.1 Method 1

If method 1 is used (6.7.1), evaluate the speed of sound using the procedure described in B.4.2. Evaluate the harmonic amplitudes of the source flow ripple using the procedure described in B.7.1.

7.4.2 Method 2

If method 2 is used (6.7.2), evaluate the harmonic amplitudes of the source flow ripple using the procedure described in B.7.2.

NOTE 2 A close approximation to the waveform of the source flow ripple can be obtained by summing the individual sinusoidal components taking their relative phases into account. It is sometimes desirable to be able to reconstruct the waveform of the source flow ripple in this way. In order to do this, the values of the phase of the source flow ripple are required in addition to the amplitude. If a distributed-parameter source impedance model was used in the analysis, more representative results will be obtained by referring the measured source flow ripple from the pump discharge port to a point within the pump. A procedure for performing this is described in reference [2]. This is not necessary to comply with this part of ISO 10767.

7.5 Calculation of anechoic pressure ripple rating

Evaluate the harmonic amplitudes of the anechoic pressure ripple using the procedure described in B.8.

Use the harmonic components of the anechoic pressure ripple to provide the overall anechoic pressure ripple rating for the pump. Determine the overall anechoic pressure ripple rating, in bars, from the expression