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Standard Practice for Analysis of In-Service Lubricants Using a Particular Five- Part (Dielectric Permittivity, Time-Resolved Dielectric Permittivity with Switching Magnetic Fields, Laser Particle Counter, Microscopic Debris Analysis, and Orbital Viscometer) Integrated Tester¹

This standard is issued under the fixed designation D7416; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This practice covers procedures for analysis of in-service lubricant samples using a particular five-part (dielectric permittivity, time-resolved dielectric permittivity with switching magnetic fields, laser particle counter, microscopic debris analysis, and orbital viscometer) integrated tester to assess machine wear, lubrication system contamination, and lubricant dielectric permittivity and viscosity. Analyzed results trigger recommended follow-on actions which might include conducting more precise standard measurements at a laboratory. Wear status, contamination status, and lubricant dielectric permittivity and viscosity status are derived quantitatively from multiple parameters measured.

1.2 This practice is suitable for testing incoming and in-service lubricating oils in viscosity grades ~~32 mm²/s~~ $32 \text{ mm}^2/\text{s}$ at ~~40°C~~ $40 \text{ }^\circ\text{C}$ to ~~680 mm²/s~~ $680 \text{ mm}^2/\text{s}$ at ~~40°C~~ $40 \text{ }^\circ\text{C}$ having petroleum or synthetic base stock. This practice is intended to be used for testing in-service lubricant samples collected from pumps, electric motors, compressors, turbines, engines, transmissions, gearboxes, crushers, pulverizers, presses, hydraulics and similar machinery applications. This practice addresses operation and standardization to ensure repeatable results.

1.3 This practice is not intended for use with crude oils.

1.4 The values stated in SI units are to be regarded as standard. No other units of measurement are included in this standard.

1.5 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[D341 Practice for Viscosity-Temperature Charts for Liquid Petroleum Products](#)

[D445 Test Method for Kinematic Viscosity of Transparent and Opaque Liquids \(and Calculation of Dynamic Viscosity\)](#)

[D924 Test Method for Dissipation Factor \(or Power Factor\) and Relative Permittivity \(Dielectric Constant\) of Electrical Insulating Liquids](#)

[D1298 Test Method for Density, Relative Density, or API Gravity of Crude Petroleum and Liquid Petroleum Products by Hydrometer Method](#)

[D4057 Practice for Manual Sampling of Petroleum and Petroleum Products](#)

[D4177 Practice for Automatic Sampling of Petroleum and Petroleum Products](#)

[E617 Specification for Laboratory Weights and Precision Mass Standards](#)

[E1951 Guide for Calibrating Reticles and Light Microscope Magnifications](#)

[D6300 Practice for Determination of Precision and Bias Data for Use in Test Methods for Petroleum Products and Lubricants](#)

¹ This practice is under the jurisdiction of ASTM Committee D02 on Petroleum Products, Liquid Fuels, and Lubricants and is the direct responsibility of Subcommittee D02.96 on In-Service Lubricant Testing and Condition Monitoring Services.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

2.2 ISO Standards:³

ISO 11171 Hydraulic fluid power—Calibration of automatic particle counters for liquids[Automatic Particle Counters for Liquids](#)

3. Terminology

3.1 Definitions:

3.1.1 *integrated tester*, *n*—automated, or semi-automated stand alone instrument utilizing multiple technologies to provide diagnostic recommendations (on-site or in-line) for condition monitoring of in-service lubricants.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *chemistry index (Chem Index)*, *n*—parameter computed from dielectric permittivity increase compared to new oil. The value is equal to dielectric difference multiplied by 100.

3.2.2 *chemistry status (Chem Status)*, *n*—diagnostic severity ranking having 0 to 100 score based on the highest alarm indication of dielectric permittivity and viscosity measurements.

3.2.3 *counts* ≥ 4 , *n*—sensor 3 measured particle counts per mL for particles \geq ~~4 μm~~ 4 μm .

3.2.4 *counts* ≥ 6 , *n*—sensor 3 measured particle counts per mL for particles \geq ~~6 μm~~ 6 μm .

3.2.5 *counts* ≥ 10 , *n*—sensor 3 measured particle counts per mL for particles \geq ~~10 μm~~ 10 μm .

3.2.6 *counts* ≥ 14 , *n*— sensor 3 measured particle counts per mL for particles \geq ~~14 μm~~ 14 μm .

3.2.7 *counts* ≥ 18 , *n*— sensor 3 measured particle counts per mL for particles \geq ~~18 μm~~ 18 μm .

3.2.8 *counts* ≥ 22 — sensor 3 measured particle counts per mL for particles \geq ~~22 μm~~ 22 μm .

3.2.9 *counts* ≥ 26 —sensor 3 measured particle counts per mL for particles \geq ~~26 μm~~ 26 μm .

3.2.10 *counts* ≥ 32 — sensor 3 measured particle counts per mL for particles \geq ~~32 μm~~ 32 μm .

3.2.11 *counts* ≥ 38 —sensor 3 measured particle counts per mL for particles \geq ~~38 μm~~ 38 μm .

3.2.12 *contaminant status (Cont Status)*, *n*—diagnostic severity ranking having 0 to 100 score based on the highest alarm indication of all contamination related parameters.

3.2.13 *dual-screen patch maker*, *n*—apparatus with screens to support individual (most often) or stacked (occasionally for size segregation) filter patches used to extract solid particles from in-service lubricating fluid as the fluid is evacuated from sensor 2 test chamber. This item is often referred to simply as “patch maker.”

3.2.14 *ferrous index (Fe Index)*, *n*—ferrous density type parameter measuring relative concentration and size of magnetically responsive iron particles \geq ~~5 μm~~ 5 μm collected on a dielectric permittivity sensor.

3.2.15 *large contaminant droplet (LCont D)*, *n*—indication reporting sensor 2 detects presence of free-water drops in oil.

3.2.16 *large contaminant ferrous (LCont Fe)*, *n*—indication reporting sensor 2 detects presence of very large ferrous-metal particles in oil, which are often the kind produced by abrasive wear mechanisms.

3.2.17 *large contaminant non-ferrous (LCont NF)*, *n*—indication reporting sensor 2 detects presence of very large non-ferrous-metal particles in oil, which are often the kind produced by abrasive wear mechanisms.

3.2.18 *orbital viscometer*, *n*—four-pole, magnetically driven, orbital viscometer.

3.2.19 *new oil*, *n*—sample of as-purchased new oil as supplied by a manufacturer for use to measure baseline reference values for the following reference oil properties: dielectric permittivity, specific gravity (Test Method **D1298**), kinematic viscosity at 40°C (Test Method **D445**), kinematic viscosity at 100°C (Test Method **D445**), and sensor 2 water factor.

3.2.20 *particular five-part integrated tester*, *n*—integrated tester including these five parts:^{4,5} sensor 1 (dielectric permittivity sensor), sensor 2 (time-resolved dielectric permittivity sensor with switching magnetic fields),^{5,6} sensor 3 (laser particle counter),^{5,7} dual-screen patch maker (initial step in microscopic debris analysis),^{5,8} and orbital viscometer.^{5,9}

3.2.21 *particle count ppm by volume* $<$ ~~6 μm~~ 6 μm (*PC Vol* $<$ ~~6 μm~~ 6 μm), *n*—volume of particulate debris detected using a laser particle counter in size range \geq ~~4 μm~~ 4 μm and $<$ ~~6 μm~~ 6 μm compared to volume of oil $\times 10^{-6}$.

³ Available from International Organization for Standardization (ISO), 1, ch. de la Voie-Creuse, Case postale 56, CH-1211, Geneva 20, Switzerland, <http://www.iso.ch>. ISO Central Secretariat, Chemin de Blandonnet 8, CP 401, 1214 Vernier, Geneva, Switzerland, <http://www.iso.org>.

⁴ The analyzer is described in and covered by the following U.S. Patents: 5,262,732; 5,394,739; 5,604,441; 5,614,830; 5,656,767; 5,674,401; 5,817,928; 6,064,480; 6,418,799; 6,582,661; 7,027,959; and 7,065,454. The sole source of supply of the apparatus known to the committee at this time is Machinery Health Management, Emerson Process Management, 835 Innovation Drive, Knoxville, TN 37932.

⁵ If you are aware of alternative suppliers, please provide this information to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee,¹ which you may attend.

⁶ The time-resolved dielectric sensor with switching electromagnets is described in and covered by U.S. Patent 5,604,441.

⁷ Sensor 3 uses methods described in and covered by U.S. Patents 6,064,480 and 7,065,454.

⁸ The patch maker with dual screens is described in and covered by U.S. Patent 6,418,799.

⁹ The orbital viscometer is described in and covered by U.S. Patent 5,394,739. The sole source of supply of the apparatus known to the committee at this time is Machinery Health Management, Emerson Process Management, 835 Innovation Drive, Knoxville, TN 37932.

3.2.22 *particle count ppm by volume $\geq 6\ \mu\text{m}$ – $6\ \mu\text{m}$ and $< 14\ \mu\text{m}$ – $14\ \mu\text{m}$ (PC Vol ~~6–14 μm~~), ~~6–14 μm~~* , *n*—volume of particulate debris detected using a laser particle counter in size range $\geq 4\ \mu\text{m}$ – $4\ \mu\text{m}$ and $< 6\ \mu\text{m}$ – $6\ \mu\text{m}$ compared to volume of oil $\times 10^{-6}$.

3.2.23 *particle count ppm by volume $\geq 14\ \mu\text{m}$ – $14\ \mu\text{m}$ (PC Vol ~~$\geq 14\ \mu\text{m}$~~), ~~$\geq 14\ \mu\text{m}$~~* , *n*—volume of particulate debris detected using a laser particle counter in size range $\geq 14\ \mu\text{m}$ – $14\ \mu\text{m}$ compared to volume of oil $\times 10^{-6}$.

3.2.24 *particle count ppm by volume total (PC Vol Total)*, *n*—volume of all particulate debris detected using a laser particle counter in size range $\geq 4\ \mu\text{m}$ – $4\ \mu\text{m}$ compared to volume of oil $\times 10^{-6}$.

3.2.25 *Sensor 1*, *n*—dielectric permittivity sensor having oil-filled cavity between central oscillating electrode and grounded concentric-shell.

3.2.26 *Sensor 2*, *n*—concentric-electrical-trace-type time-resolved dielectric permittivity sensor using a ceramic fiber filled printed circuit board and including pair of coaxial, switching electromagnets proximate to the underside of the surface supporting the concentric electrical traces.

3.2.27 *Sensor 2 water factor*, *n*—proportional measure of time-resolved-dielectric permittivity per ~~1%~~1% emulsified water-in-oil.

3.2.28 *Sensor 3*, *n*—light-blocking-type (also called light-extinction-type) laser particle counter sensor.

3.2.29 *system debris*, *n*—calculated volume of debris in entire oil compartment (PC Vol Total multiplied by volume of oil compartment).

3.2.30 *orbital viscosity at 25°C – 25°C (Visc 25C)*—orbital viscometer viscosity measurement reported as absolute viscosity (mPa \times s at ~~25°C~~ : 25°C).

3.2.31 *orbital viscosity at 40°C – 40°C (Visc 40C)*—orbital viscometer viscosity measurement reported as kinematic viscosity (mm²/s) at ~~40°C~~ : 40°C .

3.2.32 *percent change in viscosity at 40°C – 40°C (Visc%Chng)*—parameter comparing Visc 40C between new in-service oil.

3.2.33 *wear debris analysis classification (WDA classification)*—microscopic debris analysis classification method that closely identifies particulate debris from an oil sample.

3.2.34 *wear debris analysis severity (WDA severity)*—score-type parameter or alarming system assigned by an analyst that reflects a qualitative assessment of risk to machine health as evidenced by microscopic viewing of collected contamination and wear debris.

3.2.35 *wear status*—diagnostic severity ranking having 0 to 100 score based on the highest alarm indication of all wear related parameters.

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4. Summary of Practice

4.1 *Measurements Made*—The particular five-part integrated tester sequentially measures viscosity, dielectric permittivity, water-in-oil, ferrous debris, particle count and distribution, and microscopic wear debris analysis for in-service oil samples.

4.1.1 Absolute viscosity is measured based on speed of an orbiting steel ball forced by controlled magnetic fields. Temperature of fluid under test is also measured.

4.1.2 Dielectric permittivity is measured using a concentric-shell-type capacitive sensor.

4.1.3 Water-in-oil and ferrous debris are each measured using time-resolved dielectric sensor and are differentiated by using a switching dual-coil electromagnet.

4.1.4 Particle counting is measured using a laser particle counter gated to detect and count individual particles at eight size ranges.

4.1.5 Microscopic wear debris analysis is performed after collecting solids on a filter patch and placing the filter patch under an optical microscope.

4.2 *Computer Application Software*—A computer application software program guides the test sequence and provides analysis, diagnostic determination, data storage, and reporting.

5. Significance and Use

5.1 *In-plant Oil Analysis*—The particular five-part integrated tester practice is primarily used by plant maintenance personnel desiring to perform on-site analysis of as-received and in-service lubricating oils.

5.2 *Detect Common Lubrication Problems*—The software application interprets data from integration of multiple sensing technologies to detect common lubrication problems from inadvertent mixing of dissimilar lubricant viscosity grades and from particulate or moisture contamination. The redundant views of ferrous particulates (sensor 2), all particulates larger than ~~4– μm~~ 4 μm (sensor 3), and all solid particulates larger than filter patch pore size (patch maker) provides screening for oil wetted mechanical system failure mechanisms from incipient to catastrophic stages.

TABLE 1 Oil and Solvent Solubility^A

NOTE 1—Y=Yes, N=No

Oil Class	Dielectric	Original Lamp Oil or Kerosine	Ultra Pure Lamp Oil	Original Lamp Oil + Fluid B	Toluene	Hexane	Fluid A	Fluid B	Fluid C	
Mineral Oil	2.1–2.4	Y	Y	Y	Y	Y	Y	Y	N	Most industrial lubricants
PAO	2.1– 2.4	Y	Y	Y	Y	Y	Y	Y	N	
Diester	3.4– 4.3	Y	Y	Y	Y	Y	Y	Y	Y	Synthetic Hydrocarbon Diester
POE + PAG	4.6– 4.8	Y	Y	Y	Y	Y	Y	Y	Y	
PAG	6.6–7.3	N	N	N	Y	Y	N	N	N	Polyol Ester + Polyalkylene Glycol
PhE	6.0–7.1	sometimes	N	Y	Y	Y	N	Y	Y	

^A (Warning—Both Toluene and Isopropyl Alcohol have flash points below room temperature. They require an explosion proof vacuum pump.)

5.3 *Supported by Off-Site Lab Analysis*—The particular five-part integrated tester is normally used in conjunction with an off-site laboratory when exploring the particular nature of an alarming oil sample. An off-site laboratory should be consulted for appropriate additional tests.

6. Interferences

6.1 *Wrong Solvent Selection*—The particular five-part integrated tester testing almost always requires the use of dilution with a solvent that is soluble with the in-service lubricant being tested. All petroleum-based and most synthetic lubricants dissolve very well in kerosine or lamp oil, so this is most often used. However, certain synthetics remain immiscible in these solvents. See 8.3 and Table 1. It is therefore very important to verify solubility of synthetic-based lubricants being tested with the diluents and cleaning solvents being used. To do this, add a 50:50 mixture of solvent and sample in a bottle, shake vigorously, and allow settling for 1 min. Layered fluids or emulsion are signs of insolubility. This is likely to cause erroneous measurements using sensors 2 and 3.

6.2 *Improper Sampling Techniques*—Interferences can be produced by improper sampling techniques. Practice D4177 should be followed. Samples collected from cold, not operating machinery are not likely to properly represent contaminants and wear debris since these settle when the system is not hot and flowing. Interferences may be produced by contaminated bottles, uncapped new bottles, and incorrectly labeled sample bottles.

6.3 *Particle Count Interferences*—Sensor 3 is a light obscuration type laser particle counter and is therefore subject to interferences from air bubbles, dark fluids, and emulsified water. Follow manufacturer recommended procedures to avoid these interferences. Interference caused by false counts from air bubbles may be caused by inadequate degassing with the 30 mL 30 mL syringe in an inverted position. For very dark in-service lubricants, when sensor 3 gives an alert that oil sample may be too dark, retest with additional dilution. Avoid false counts from emulsified water-in-oil by using the water masking step in 8.4.

6.4 *Coincidence Errors*—Sensor 3 laser particle counter will experience abnormally high coincidence errors when it attempts to count more than 20 000 particles per mL, millilitre. Coincidence errors result when more one particle is in the laser window at one time. When two small particles are coincidentally in the laser window, they are effectively counted like they are a single particle having double cross-section. This artificially lowers measured counts at small sizes and inflates the counts at larger sizes. Coincidence errors $\gt;10\%$ are not acceptable. Avoid coincidence by performing second dilution prior to sensor 3 testing. For example, if you dilute 4-to-1, then you can expect to detect less than $5 \times 20\,000$ or 100 000 particles per mL, millilitre.

7. Apparatus

7.1 *Bench Top Setup*—The particular five-part integrated tester^{5, 10} with example arrangement shown in Fig. 1.

7.2 *Core Analyzer*—The core analyzer as shown on right in Fig. 1 incorporates sensor 1 (dielectric permittivity sensor), sensor 2 (time-resolved-dielectric-permittivity measurement with switching electromagnet), sensor 3 (laser particle counting sensor), and a patch maker as outlined in the following paragraphs. The core analyzer connects directly to the balance, orbital viscometer, and computer application. In addition, it creates filter patches for wear debris analysis (WDA) classification and WDA severity determination.

7.2.1 Sensor 1 includes a concentric-shell-type-capacitor dielectric permittivity measurement sensor. Test fluid is injected into a port and pushed up around the annular space between a central metal electrode and the electrically grounded outer metal shell. By filling the cavity from the bottom, air is displaced as the fluid rises to fill the entire volume of the sensor. It takes approximately

¹⁰ The sole source of supply of the apparatus known to the committee at this time is A520010 Comprehensive Minilab, apparatus, and accessories, available from Machinery Health Management, Emerson Process Management, 835 Innovation Drive, Knoxville, TN 37932.



FIG. 1 Example of Layout for a Particular Five-Part Integrated Tester

8 mL of test fluid to completely fill the tubing and sensor. Dielectric permittivity measurement is made by measuring capacitance of the calibrated sensor. The concentric-shell-type-capacitor dielectric permittivity is calibrated to within $\pm 1\%$ of known values for standardization fluids A, B, and C.

7.2.2 Sensor 2 includes (1) a concentric-trace-type-capacitor dielectric permittivity measurement sensor mounted above (2) a dual-coil electromagnet suitable for introducing switching magnetic fields through the sensing surface.

7.2.2.1 Sensor 2 performs a time-resolved-dielectric-permittivity measurement involving 360 separate measurements taken at 0.5-s intervals covering a total elapsed test time of 3 min. During the first 2 min, the switching electromagnet produces alternating axial-field and then radial-field patterns which orient and re-orient ferrous particles on the sensor surface at 0.5-s intervals, synchronous with the sequential dielectric permittivity measurements. After 2 min, the field patterns are modified to draw ferrous debris entirely away from the concentric-trace-type capacitor sensor. The maximum ferrous concentration on the sensor is detected at the end of 240 measurements (2 min) and the maximum non-ferrous particle and water concentration is detected at the end of 360 measurements (3 min). After the test sequence is completed, the electromagnet coils are pulsed through a demagnetization or degaussing sequence so that ferrous debris are easily flushed away during cleaning.

7.2.2.2 The concentric-trace-type-capacitor dielectric permittivity measuring sensor is constructed using gold plated copper traces on a ceramic-fiber reinforced PTFE (polytetrafluoroethylene) substrate with a grounded metal backplane. The sensor is calibrated to within $\pm 2\%$ of standard values for standardization fluids A, B, and C.

7.2.2.3 The dual-coil electromagnet is used to collect and manipulate ferrous debris on the sensor surface. The dual-coil electromagnet produces $300\text{--}300\text{ G} \pm 30\text{--}30\text{ G}$ field strength on the sensor surface above the center-post when both coils are powered with fields adding, and it produces $70\text{--}70\text{ G} \pm 2\text{--}2\text{ G}$ field strength when the polarity of the outer coil is reversed so it effectively overpowers the inner coil. These relative field strengths allow the analyzer to gather ferrous debris above the center-post, orient ferrous debris in axial and radial geometric pattern, and sweep ferrous debris off the sensor surface.

7.2.3 Sensor 3 includes a laser particle counting sensor mounted immediately below a Luer-tip injection port. Sample test fluid is diluted, homogenized, drawn into 30 mL syringe, degassed, and then injected via the Luer-tip port through the laser window. Flow rate through the particle counter is maintained at constant 50 mL/min using a stepper-motor controlled syringe pump. Sensor 3 is standardized using MTD standardization fluid in accordance with ISO 11171.

7.3 *Orbital Viscometer*—The orbital viscometer measures absolute viscosity, also called dynamic viscosity, at a particular temperature in units of centigrade ($^{\circ}\text{C}$). A cross section of the orbital viscometer is shown in Fig. 2. The 12 mL sample test cup is filled with test fluid and contains a steel ball that orbits around the base of the test cup under the influence of four sequentially powered electromagnets. Under the circular path of the ball are four ball-position sensors. Each time the ball passes over one sensor, the next electromagnet is energized, thereby the orbital speed of the ball is a function of test fluid absolute viscosity. A temperature sensor in the center-bottom of the sample test cup measures temperature. A fan inside the orbital viscometer constantly pulls air around the electromagnet coils to keep the orbital viscometer from self heating. The computer application software processes and controls the orbital viscometer, and uses the viscosity-temperature relationship as defined in Test Method D341 to translate values from room temperature absolute viscosity ($\text{mPa} \times \text{s}$) into 25°C absolute viscosity ($\text{mPa} \times \text{s}$) and into 40°C kinematic viscosity (mm^2/s). To do this, the application software uses laboratory measured values from its new oil database: specific gravity, kinematic viscosity at 40°C , and kinematic viscosity at 100°C .

NOTE 1—The viscosity measurement is performed at room temperature and converted to 40°C using calculation based on user supplied new oil information.

7.4 *Microscope*—A microscope enables the operator to perform analytical wear debris analysis of 25 mm diameter filter patches. As a minimum the microscope shall provide viewing stage with top-lighting and magnification from 300x to 230x. The

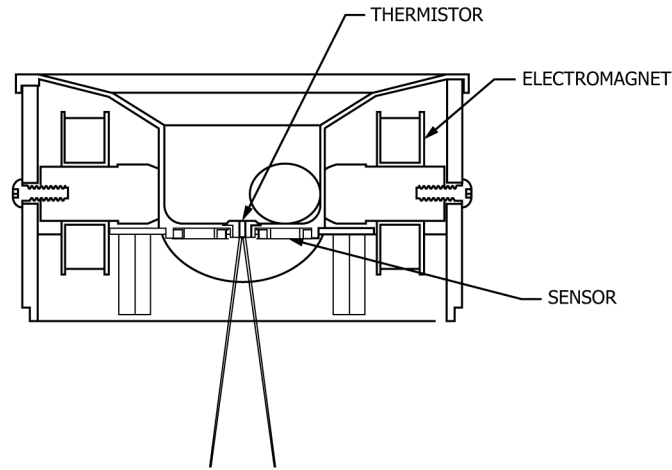


FIG. 2 Cross Section View of Orbital Viscometer

microscope imaging system is standardized on the computer display (pixels per micron) using application software and a captured image from a NIST traceable length standard (see 12.5).

7.5 *Computer Application Software*—The computer application software provides the functionality for the particular five-part integrated tester: an electronic user interface, hierarchical equipment database to store and analyze and manage data, step-by-step testing guide, imbedded logic for data interpretation, and automatic reporting tools.

7.6 *Solvent Filtration Device*—This device is used for dispensing the diluting and cleaning solvents. The device filters solvents from the pressurized dispenser by passing the fluid through a $0.8\text{-}\mu\text{m}$ (typical) filter patch.

8. Reagents and Materials

8.1 *Disposable Luer-tip 10-mL 10 mL Syringes*—Syringes shall be supplied individually wrapped to prevent contamination. Syringes are all plastic with no rubber seals on plunger. Rubber materials may have material compatibility problems with some solvents. Syringes are not reusable.

8.2 *Disposable Luer-tip 30-mL 30 mL Syringes*—Syringes shall be supplied individually wrapped to prevent contamination. Syringes are all plastic with no rubber seals on plunger. Rubber materials may have material compatibility problems with some solvents. Syringes are not reusable.

8.3 *Cleaning and Diluting Solvent*—Sensors 1, 2, and 3 are all cleaned using a solvent that is soluble with the base oils tested. See Table 1 for oil and solvent solubility. Fluids A, B, and C are standardization fluids. See 12.2.1.

8.4 *Water Masking Solvent*—Water masking eliminates false particle count interference from water droplets. Water masking solvents are selected to dissolve water-in-oil. See Table 2 for water masking solvent materials and procedures.^{5,11}

8.5 *Filter Patches*—The WDA filter patches are 25-mm diameter circular patches with $\sim 5\text{-}\mu\text{m}$ pore size or another pore size selected to retain desired size range of particulate debris of interest when performing analytical WDA.

8.6 *Cleaning Swabs*—These are used to clean sensor 2.

8.7 *Paper Goods*—Paper goods often used with the particular five-part integrated tester include label stock, printer paper, and tissue papers.

9. Hazards

9.1 *Flammable Solvents*—All particular five-part integrated tester setup and operations shall be approved by an on-site industrial hygiene specialist considering the particular situation. One should be particularly cautious if optional highly flammable solvents such as heptane, hexane, toluene, or isopropyl alcohol are used. Among other safety practices, be sure to keep the area well ventilated, and eliminate spark sources in the vicinity of highly flammable solvents. Those wishing to minimize flammability risks may prefer to use kerosine or lamp oil for diluents and cleaning solvents, and to use dipropylene glycol n-butyl ether for water masking.

10. Sampling, Test Specimens, and Test Units

10.1 *Sample Bottles*—The sample bottles, typically 100-mL in size, are used for testing. Occasionally, sample bottles should be tested using solvent to determine the particle count contribution from the bottles. It is important to use bottles that are

¹¹ This water masking method is described in and covered by U.S. Patent 6,064,480.