

ASME B40.100-2013
[Revision of ASME B40.100-2005 (R2011)]

Pressure Gauges and Gauge Attachments

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**The American Society of
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Two Park Avenue • New York, NY • 10016 USA

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FOREWORD

ASME Standards Committee B40 is comprised of a group of volunteers representing pressure gauge users, manufacturers, governmental agencies, testing laboratories, and other standards-producing bodies. All are convinced that national standards such as this serve not only to provide product performance and configuration guidelines but also to inform and assist both those who specify and the users regarding the science of pressure gauge production, application, and use. The standards are vehicles by which the Committee as a body can transmit to users the benefits of their combined knowledge and experience as regards the proper and safe use of pressure gauges.

The use of this Standard is entirely voluntary and shall in no way preclude the manufacturer or use of products that do not conform. Neither ASME nor the B40 Committee assumes responsibility for the effects of observance or nonobservance of recommendations made herein.

The 2005 edition, which was approved on September 19, 2005, was issued to include Nonmandatory Appendix C on Supplemental Requirements to B40.1, B40.2, B40.5, and B40.6.

This revision was issued to clarify wording in the B40.1 body document as well as in Nonmandatory Appendix C, now designated as Mandatory Appendix III. Nonmandatory Appendix A was also rewritten to include new gauge performance criteria, and it was designated as Mandatory Appendix I. Nonmandatory Appendix B was designated as Mandatory Appendix II.

This edition of the Standard was approved by the B40 Standards Committee on June 18, 2013 and approved as an American National Standard by the American National Standards Institute on October 14, 2013.

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General. ASME standards are developed and maintained with the intent to represent the consensus of concerned interests. As such, users of this Standard may interact with the Committee by proposing revisions, and attending Committee meetings. Correspondence should be addressed to:

Secretary, B40 Standards Committee
The American Society of Mechanical Engineers
Two Park Avenue
New York, NY 10016-5990

Proposing Revisions. Revisions are made periodically to the Standard to incorporate changes that appear necessary or desirable, as demonstrated by the experience gained from the application of the Standard. Approved revisions will be published periodically.

The Committee welcomes proposals for revisions to this Standard. Such proposals should be as specific as possible, citing the paragraph number(s), the proposed wording, and a detailed description of the reasons for the proposal, including any pertinent documentation.

Attending Committee Meetings. The B40 Standards Committee regularly holds meetings, which are open to the public. Persons wishing to attend any meeting should contact the Secretary of the B40 Standards Committee.

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PREFACE

ORGANIZATION OF THIS DOCUMENT

This Standard compiles the following standards.

<i>Standard</i>	<i>Title</i>
ASME B40.1	Gauges: Pressure Indicating Dial Type — Elastic Element
ASME B40.2	Diaphragm Seals
ASME B40.5	Snubbers
ASME B40.6	Pressure Limiter Valves
ASME B40.7	Gauges: Pressure Digital Indicating

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ASME B40.1

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GAUGES: PRESSURE INDICATING DIAL TYPE — ELASTIC ELEMENT

1 SCOPE

This Standard (B40.1) is confined to analog, dial-type gauges, which, utilizing elastic elements, mechanically sense pressure and indicate it by means of a pointer moving over a graduated scale.

This Standard does not include gauges of special configuration designed for specific applications, edge reading, deadweight or piston gages, or any other gauges not using an elastic element to sense pressure.

2 PRESSURE GAUGES, GENERAL

2.1 Pressure Terms

See Fig. 1.

2.2 Pressure Gauge Components

See Fig. 2.

2.3 Pressure Gauge Terminology

absolute pressure: see *pressure, absolute*.

absolute pressure gauge: see *gauge, absolute pressure*.

accuracy: the conformity of a gauge indication to an accepted standard or true value. Accuracy is the difference (error) between the true value and the gauge indication expressed as a percent of the gauge span. It is the combined effects of method, observer, apparatus, and environment. Accuracy error includes hysteresis and repeatability errors, but not friction error. It is determined under specific conditions (see Table 1).

accuracy, reference: the accuracy of a gauge under reference conditions [normal position at $20^{\circ}\text{C} \pm 1^{\circ}\text{C}$ (approximately $68^{\circ}\text{F} \pm 2^{\circ}\text{F}$) and 101.32 kPa (29.92 in. Hg) barometric pressure].

adjustment, pointer indication: a means of causing a change in indication. The change is approximately equal over the entire scale. Some examples of this type of adjustment are adjustable pointers, rotatable dials, rotatable movements, and other similar items. This adjustment, if provided, is generally accessible to the gauge user (see para. 3.3.4).

adjustment, span: a means of causing a change in the angle of pointer rotation for a given change in pressure. This adjustment is not generally accessible to the gauge user.

ambient pressure: see *pressure, ambient*.

bar: a metric pressure unit equal to approximately 14.50 psi (see paras. 3.3.2.1 and 7.2).

bellows: a thin walled, convoluted elastic pressure-sensing element (see Fig. 3).

bezel: see *ring*.

Bourdon tube: a tubular elastic pressure-sensing element. May have "C," helical, spiral, or other form (see Fig. 3).

brazing: a metal joining process wherein coalescence is produced by use of nonferrous filler metal having a melting point above 425°C (800°F), but lower than that of the base metals joined.

calibration: the process of graduating the pressure scale or adjusting the mechanism to cause the gauge to indicate within specified accuracy limits.

calibration verification: the checking of a gauge by comparison with a given standard to determine the indication error at specified points of the scale.

case: the housing or container that supports, protects, and surrounds the internals.

case, liquid filled: a case that is filled with a liquid such as glycerin or silicone fluid to at least 75% of its total internal volume. Liquid-filled cases may be either open front or solid front types. The purpose of this construction is to exclude ambient corrosives or protect the internals from damage caused by severe vibration or pulsation.

case, open front with case pressure relief: a case with a pressure relief device or openings and no partition between the pressure element and the window [see Fig. 4, illustration (a)]. An alternate construction is a plastic window especially designed to relieve internal case pressure.

case, open front without case pressure relief: a case having no partition between the pressure element and the window, and no pressure relief devices or openings [see Fig. 4, illustration (a)].

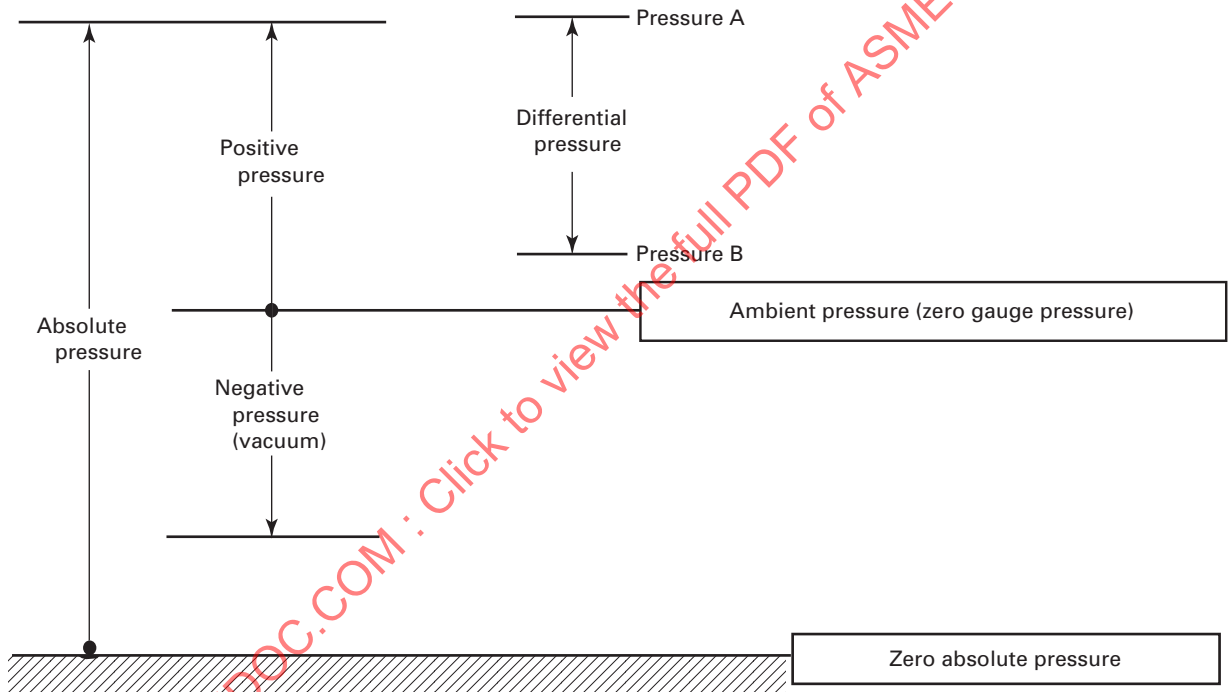
case, pressure tight: a case capable of maintaining a pressure differential between the inside and the outside of the case.

case ring: see *ring*.

case, sealed: a case that is sealed to exclude ambient corrosives.

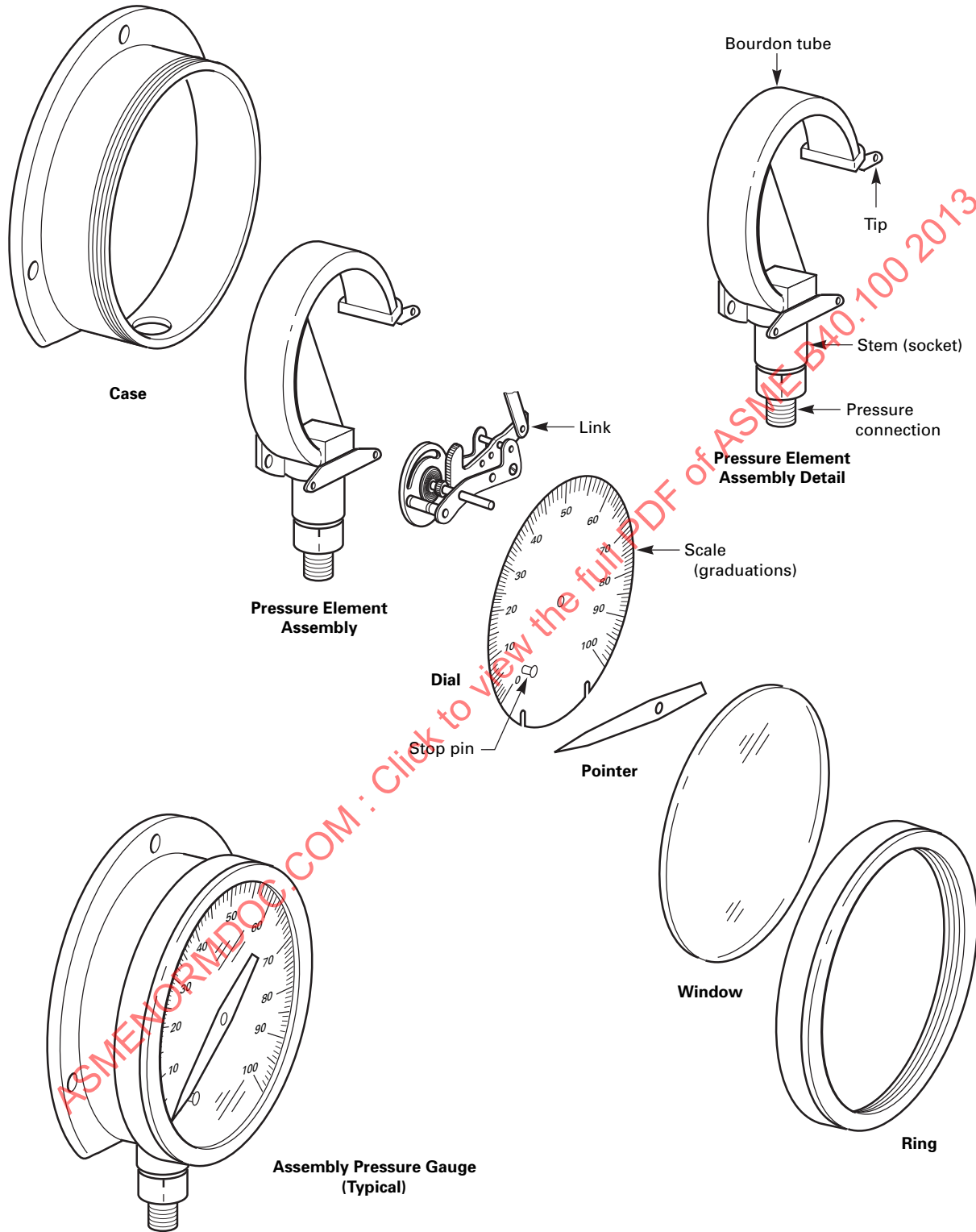
case, size: see *size, gauge*.

Fig. 1 Basic Pressure Terms



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Fig. 2 Pressure Gauge Components (C-Type Bourdon Illustrated)



GENERAL NOTE: The above diagrams are schematic and not intended to show design details.

Table 1 Accuracy Grades/Classes

Accuracy Grade	Permissible Error (± Percent of Span) (Excluding Friction)			Maximum Friction (Percent of Span)	Minimum Recommended Gauge Size (270 deg Dial Arc)
	Lower ¼ of Scale	Middle ½ of Scale	Upper ¼ of Scale		
4A		0.1		[Note (1)]	8½
3A		0.25		0.25	4½
2A		0.5		0.5	2½
1A		1.0		1.0	1½
A	2.0	1.0	2.0	1.0	1½
B	3.0	2.0	3.0	2.0	1½
C	4.0	3.0	4.0	3.0	1½
D	5.0	5.0	5.0	3.0	1½

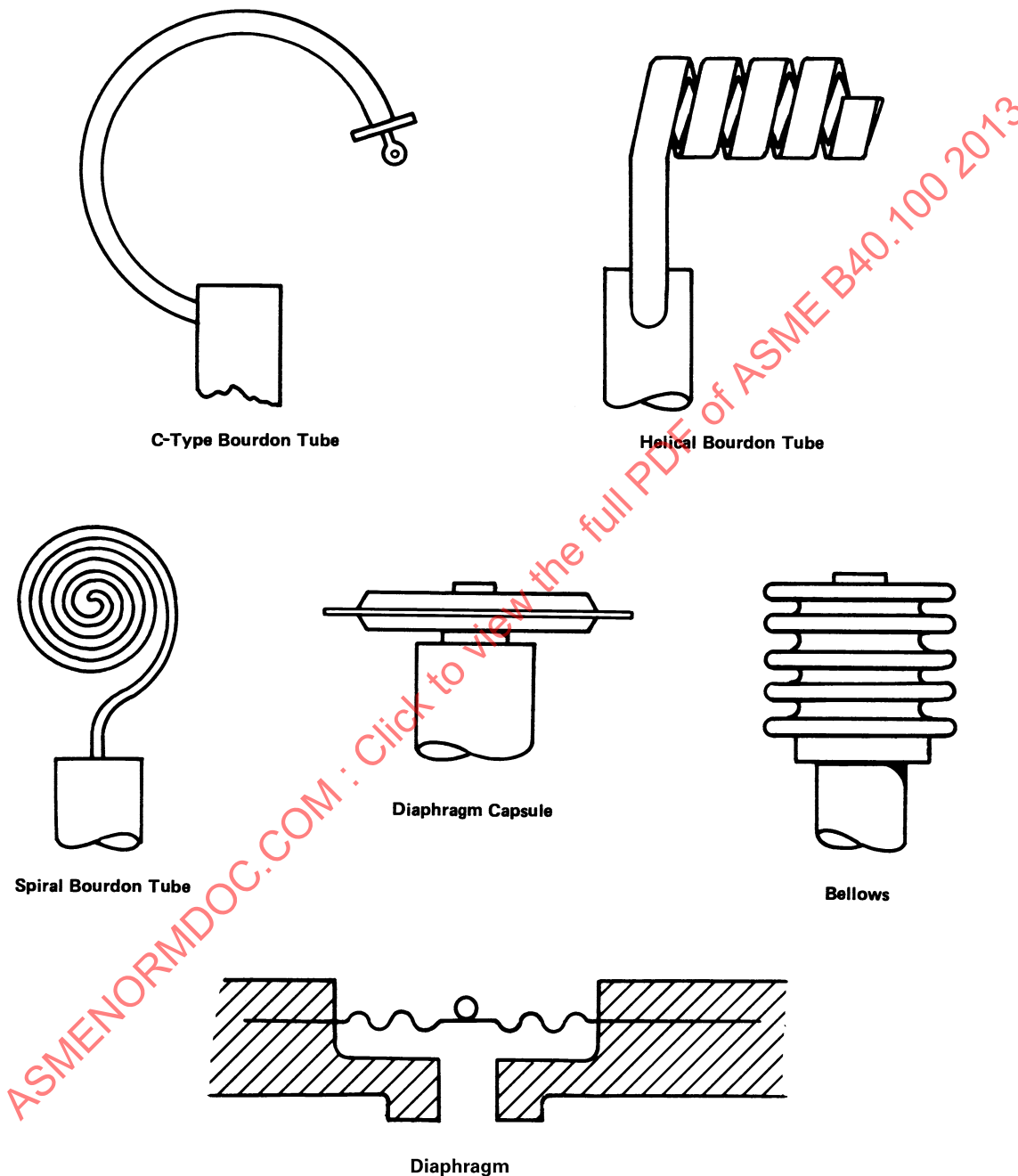
Accuracy Classes (EN 837-1)				
Class	Lower ¼ Scale	Middle ½ of Scale	Upper ¼ of Scale	Maximum Friction
0.1		±0.10%		0.10%
0.25		±0.25%		0.25%
0.6		±0.60%		0.60%
1.0		±1.00%		1.00%
1.6		±1.60%		1.60%
2.5		±2.50%		2.50%
4		±4.00%		4.00%

GENERAL NOTE: Light tapping of the gauge case is permissible at each pressure reading.

NOTE:

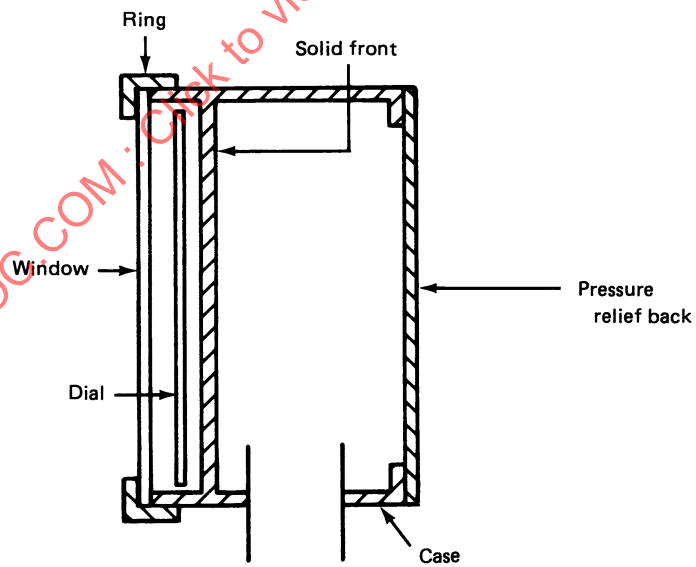
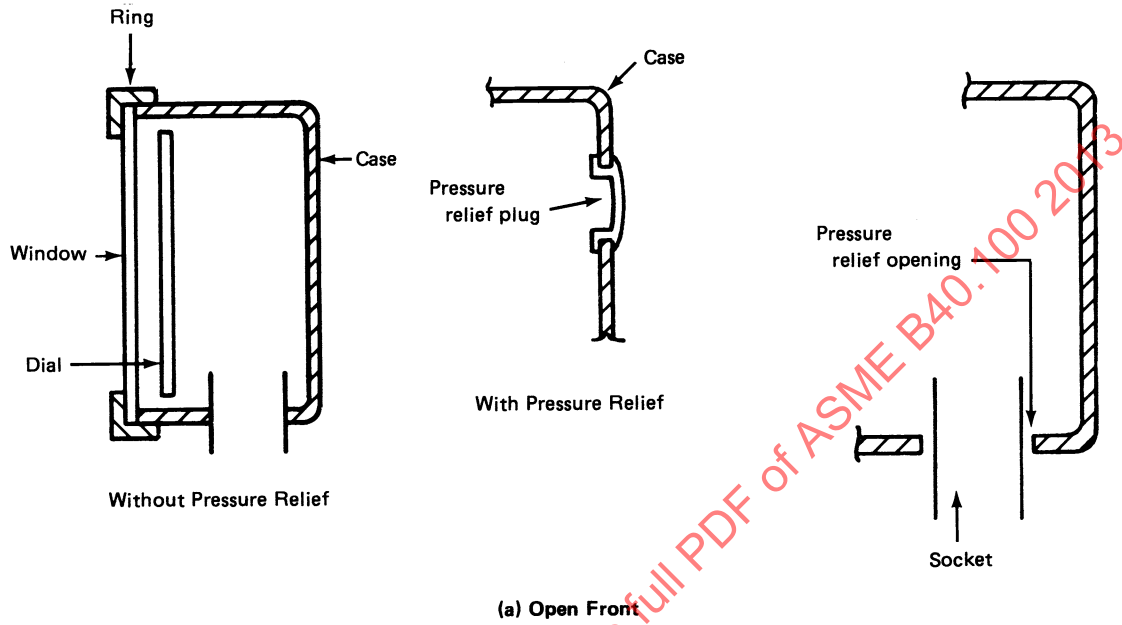
(1) Grade 4A gauges must remain within specified tolerance before and after being lightly tapped.

Fig. 3 Elastic Elements



GENERAL NOTE: The above diagrams of various types of elastic elements used in pressure gauges are schematic and not intended to show design detail.

Fig. 4 Cases



case, solid front with pressure relief back: a case having a partition with minimum opening(s) between the pressure element and the window, and a pressure-relieving back. The partition may be an integral part of the case [see Fig. 4, illustration (b)].

column, liquid: see *liquid column*.

compound gauge: see *gauge, compound*.

conditions, environmental: the conditions external to the gauge, including weather, temperature, humidity, salt spray, vibration, corrosive atmosphere, and other similar conditions that could affect the performance of the gauge.

conditions, extreme operating: the limits of the environmental conditions within which the instrument may be operated. Under these conditions, the stated accuracy does not necessarily apply.

conditions, normal operating: the environmental conditions in which the stated accuracy applies.

correction: the quantity that is algebraically added to an indicated value to obtain the true value. The algebraic sign of the correction is opposite to the sign of the error.

corrosion failure: see *failure, corrosion*.

creep: a progressive change in indication with constant applied pressure, under the same environmental conditions. It is usually expressed as a percentage of span per unit of time.

crystal: see *window*.

dead weight tester: a pressure-testing device by which very accurate known pressures can be generated by means of a pressure source and a piston gage.

dial: the component that contains the scale and nomenclature.

dial, dual scale: a dial indicating pressure in terms of two different units of measure, on concentric arcs, such as kg/cm² and psi. One example of the many different types in common use is illustrated in Fig. 5.

dial graduations: the individual division marks of the scale that indicate pressure magnitude.

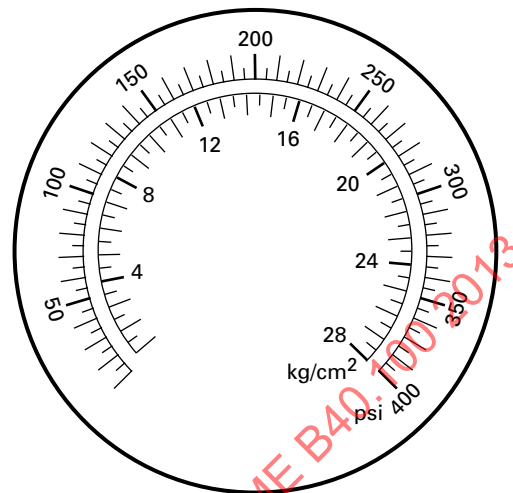
dial, mirror: a dial with a reflector band adjacent to the scale for the purpose of reducing reading-parallax errors.

dial nomenclature: see *nomenclature, dial*.

diaphragm: an elastic element in the form of a single flat or convoluted plate that deforms to provide displacement in response to a change in pressure differential across the plate (see Fig. 3).

diaphragm capsule: an elastic element comprised of two convoluted diaphragm plates jointed to form a capsule or pressure container that expands and contracts in response to a change in pressure differential across the plates. Diaphragm capsule elements may have one or

Fig. 5 Example of Dual Scale Dial



more capsules to provide appropriate displacement (see Fig. 3).

differential gauge: see *gauge, differential*.

differential pressure: see *pressure, differential*.

duplex gauge: see *gauge, duplex*.

elastic element: see *element, elastic*.

element, elastic: the elastic component of the pressure element assembly that moves in response to pressure changes. It may be a Bourdon tube, bellows, diaphragm, or other type of member (see Fig. 3).

element assembly, pressure: the assembly, including the elastic element, that converts a pressure change into motion. It may also include a stem, tip, restrictor, and other components (see Fig. 2).

environmental conditions: see *conditions, environmental*.

error: the difference between the indicated value and the true value of the variable being measured. A positive error denotes that the indicated value is greater than the true value (see also *correction*).

error, fatigue: the change of pressure indication that results from repeated applications of stress (pressure cycles). It is expressed as a percentage of span, number of cycles, and minimum and maximum values of pressure cycles.

error, friction: the difference between indicated readings before and after the gauge has been lightly tapped.

error, hysteresis: the difference between increasing pressure and decreasing pressure readings at any point on the scale obtained during a pressure cycle after friction errors have been eliminated by tapping (see para. 6.2.4.3 and Fig. 10).

error, offset: the error exhibited when the elastic element is unpressurized. It is expressed as a percentage of span (see Fig. 10).

error, position: the change of pressure indication that results when the gauge is placed in a position different from that in which it was calibrated.

error, span: the error exhibited when the input is at maximum scale pressure minus the error exhibited when the input is at minimum scale pressure. It is expressed as a percentage of span.

error, temperature: the change of pressure indication that results when the gauge components are at a temperature different from the temperature at which they were calibrated.

explosive failure: see *failure, explosive*.

extreme operating conditions: see *conditions, extreme operating*

failure, corrosion: elastic element failure resulting from corrosive chemical attack on the element walls (see para. 4.2.7.3).

failure, explosive: elastic element failure caused by the release of explosive energy generated by a chemical reaction inside the element (see para. 4.2.7.4).

failure, fatigue: elastic element failure resulting from repeated applications of stress (see para. 4.2.7.1).

failure, overpressure: elastic element failure caused by the application of internal pressure (positive or negative) in excess of the rated pressure of the element (see para. 4.2.7.2).

failure, overtemperature: failure as a result of continuous exposure to high ambient temperature.

failure, thermal shock: failure as a result of repeated, rapid exposure to ambient temperature extremes.

fatigue failure: see *failure, fatigue*.

fiber: any nonmetallic, flexible, threadlike contaminant with a length-to-diameter ratio of at least 10.

flush mounted: see *gauge, flush mounted*.

friction error: see *error, friction*.

friction ring: see *ring, friction*.

ft H₂O: see para. 3.3.2.1.

full scale pressure: see *pressure, full scale*.

gauge, piston: a device that indicates the presence of a predetermined pressure by means of weights loaded on an effective area such as a floating piston or a ball (see para. 6.1.1.2).

gauge, absolute pressure: a gauge that indicates absolute pressure (see para. 3.4.1.12).

gauge, acetylene: see para. 4.3.8.2.

gauge, ammonia: see para. 4.3.8.3.

gauge, chemical: see para. 4.3.8.4.

gauge, compound: a gauge that indicates both positive and negative gauge pressure (see para. 3.4.1.8).

gauge, differential: a gauge having two pressure connections and a pointer, which indicates the difference between two applied pressures.

gauge, duplex: a gauge having two pressure connections and two pointers, which indicate two applied pressures simultaneously.

gauge, flush mounted: a gauge provided with supporting means on the case so that it may be set through a hole in a panel. When installed, the dial is approximately flush with the panel (see Fig. 6).

gauge, hydraulic: a gauge designed to indicate the pressure developed in hydraulic systems. It may be equipped with a protective means to prevent damage to the internals in the event of a sudden pressure release.

gauge, liquid filled: a gauge in which the case is filled with a liquid (see *case, liquid filled*).

gauge, liquid level: a gauge with a dial graduated in units of head heights, such as feet (meters) of water.

gauge, oxygen: see para. 4.3.8.5.

gauge, pressure: a device that senses and indicates pressure using ambient pressure as datum.

gauge, receiver: a gauge designed to indicate the output signal from a pneumatic transmitter. It is calibrated in terms of the transmitter output. The dial may be graduated in units of pressure, temperature, flow, or other measurements corresponding to the transmitter input.

gauge, refrigerant: a gauge with a dial graduated in units of pressure and equivalent saturation temperature for refrigerant(s) other than ammonia.

gauge, retard: a gauge having a scale that is compressed at one or both ends (see para. 3.4.1.6). One example of the many different types in common use is shown in Fig. 7.

gauge, single: a gauge having one pressure connection and one pointer, which indicates one applied pressure.

gauge, specific service: a gauge designed for a specific service, such as indicating the pressure of explosive, corrosive, or viscous media (see para. 4.3.8).

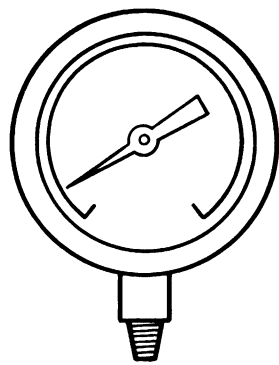
gauge, stem (socket) mounted: a gauge supported by attachment at the stem (socket) pressure connection (see Fig. 6).

gauge, suppressed scale: a gauge having a scale that starts at some value appreciably above zero (see para. 3.4.1.7). One example of the many different types in common use is shown in Fig. 8.

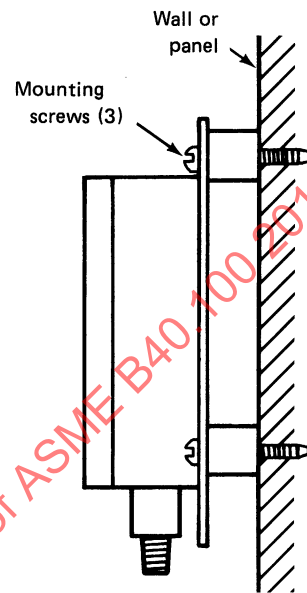
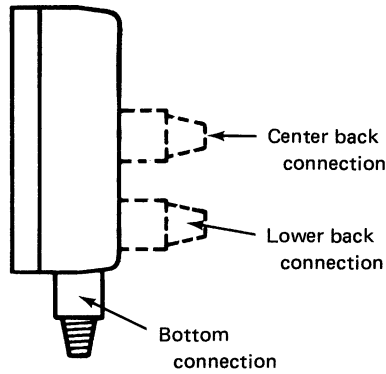
gauge, surface (wall) mounted: a gauge whose case can be mounted to a wall or flat surface (see Fig. 6).

gauge, temperature compensated: a gauge that is compensated to reduce errors caused by operation at ambient temperatures other than that at which it was calibrated.

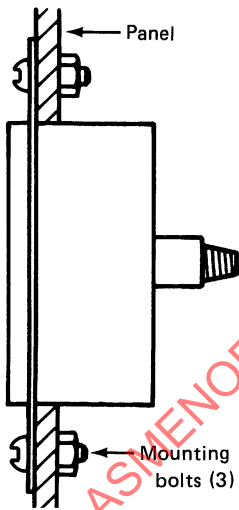
Fig. 6 Cases/Mounting



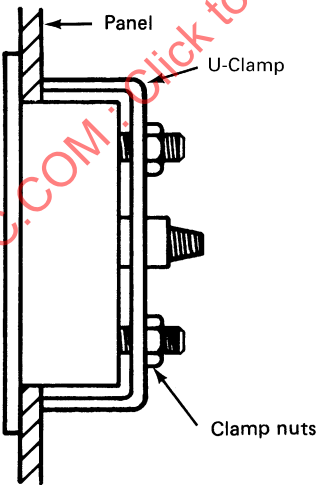
Stem Mounted
(Typical Connection Configuration)



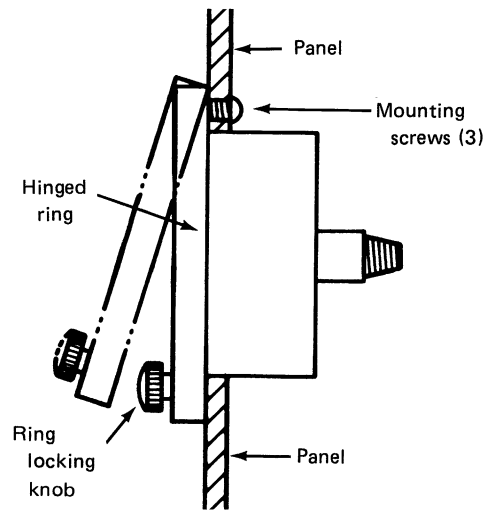
Surface Mounted
(Back Flange Type)



Flush Mounted
(Front Flange)



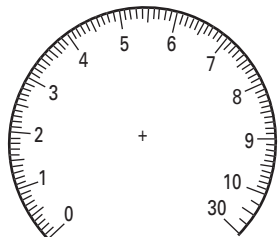
Flush Mounted
(U-Clamp)



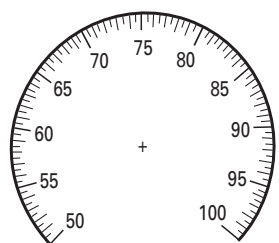
Panel Mounted
(Hinged Ring Type)

GENERAL NOTES:

- (a) These diagrams are schematic and not intended to show design details.
- (b) Surface- and flush-mounted cases may also be stem mounted.

Fig. 7 Example of Retard Gauge

GENERAL NOTE: Scale shown is retarded from 10 to 30.

Fig. 8 Example of Suppressed Scale Gauge

GENERAL NOTE: Scale shown is suppressed from 0 to 50.

gauge, test: a gauge used to check the accuracy of other gauges or pressure-actuated devices. The test gauge has an accuracy significantly better than the device being tested.

gauge, vacuum: a gauge that indicates negative gauge pressure (vacuum).

graduations, dial: see *dial, graduations*.

grommet: see *plug, pressure relief*.

H_2O : water.

Hg: mercury.

hydraulic gauge: see *gauge, hydraulic*.

hysteresis error: see *error, hysteresis*.

in. H₂O: see para. 3.3.2.1.

in. Hg: see para. 3.3.2.1.

internal stop: see *stop, internal*.

kg/cm^2 : see para. 3.3.2.1.

kPa: see para. 3.3.2.1.

lens: see *window*.

life, fatigue: the number of pressure cycles beyond which leakage of the pressure element assembly may occur. Accuracy may be degraded even if leakage has not occurred (see *error, fatigue*).

link: the component that connects the elastic element to the movement.

liquid column: a pressure measuring device employing a column and reservoir of liquid (oil, water, mercury, or other liquid). Pressure indicated by the height of the liquid column, measured at the meniscus.

liquid-filled case: see *case, liquid filled*.

liquid-filled gauge: see *gauge, liquid filled*.

liquid level gauge: see *gauge, liquid level*.

manometer: see ASME PTC 19.2, *Pressure Measurement*.

medium: the process fluid (gas or liquid).

mirror, dial: see *dial, mirror*.

mounting: the means by which the gauge is installed or supported.

mounting, flush: see *gauge, flush mounted*.

mounting, gauge: see *mounting*.

mounting, stem socket: see *gauge, stem (socket) mounted*.

mounting, surface (wall): see *gauge, surface (wall) mounted*.

movement: the gauge component that converts pressure element motion to rotary pointer motion.

NBS: National Bureau of Standards (see NIST).

negative pressure (vacuum): see *pressure, negative*.

NIST: National Institute of Standards and Technology (formerly NBS).

nomenclature, dial: may include, but is not restricted to, the following:

(a) materials of wetted parts

(b) restricted application notices such as USE NO OIL

(c) presence of special features such as an internal stop

normal operating conditions: see *conditions, normal operating*.

NPT: American Standard taper pipe threads. Defined by ASME B1.20.1, *Pipe Threads (Except Dryseal)*.

operating pressure: see *pressure, operating*.

overpressure: the application of a pressure beyond the full scale pressure.

overpressure failure: see *failure, overpressure*

Pa: see para. 3.3.2.1.

particle: any solid contaminant other than fiber.

pascal: see para. 3.3.2.1.

piston gage: see *gage, piston*.

plug, pressure relief: a plug inserted in the gauge case wall that, in the event of an element leak, vents, minimizing case pressure buildup.

pointer: the component that, in conjunction with the dial, indicates pressure.

pointer adjustment: see *adjustment, pointer*.

position error: see *error, position*.

positive pressure: see *pressure, positive*.

pressure, absolute: a pressure using zero absolute pressure as datum (see Fig. 1).

pressure, ambient: the pressure surrounding the gauge, usually atmospheric (barometric) pressure (see Fig. 1).

pressure, burst: see *pressure, rupture*.

pressure, differential: the difference between two pressures (see Fig. 1).

pressure element: see *element assembly, pressure*.

pressure, full scale: the highest numerically defined graduation on the unretarded portion of the scale.

pressure, gauge: a positive pressure (greater than ambient) or negative pressure (less than ambient) using ambient pressure as datum (see Fig. 1).

pressure gauge: see *gauge, pressure*.

pressure, negative (vacuum): gauge pressure less than ambient pressure using ambient pressure as datum (see Fig. 1).

pressure, operating: the pressure at which a gauge is normally operated.

pressure, positive: gauge pressure greater than ambient pressure (see Fig. 1).

pressure, process: the pressure of the process medium at the pressure connection of the sockets.

pressure, proof: the maximum pressure a gauge can withstand without plastic deformation of the pressure element. Proof pressure may be a semidestructive test and should not be conducted repeatedly on the same gauge. It may be expressed as a pressure or as a percentage of full scale.

pressure, rated: full scale pressure unless otherwise specified.

pressure relief plug: see *plug, pressure relief*.

pressure, rupture: the maximum pressure above which the pressure element assembly may no longer hold pressure.

pressure, variable: pressure that increases or decreases, or both, at a rate greater than that allowed for steady pressure; may include high pressure, short duration impulses (pressure spikes).

psi: see para. 3.3.2.1.

psia: see para. 3.3.2.1.

psid: see para. 3.3.2.1.

psig: psi (see para. 3.3.2.1).

pulsation: a periodic surge.

range: the high and low limits of the scale (including retarded portions) expressed in the sequences and units in which they occur. For example: 0/100 kPa, 200/500 psi, 30 in. Hg vac/30 psi.

readability: the uncertainty inherent in the observer's ability to determine the indicated pressure value. Factors

that may affect readability include length of scale, graduation configuration and spacing, pointer design and width, parallax, distance between observer and scale, illumination, stability of pointer, pointer and scale colors, and the liquid level line in liquid-filled gauges.

receiver gauge: see *gauge, receiver*.

refrigerant gauge: see *gauge, refrigerant*.

repeatability: the maximum difference between any two or more consecutive indications for the same applied pressure under the same operating conditions, approaching from the same direction, after lightly tapping the gauge. It is usually expressed as a percentage of span.

resonance: resonance of a system-forced oscillation exists when any change, however small, in the frequency of excitation causes a decrease in the response of the system. (A resonance may occur in an internal part of the gauge, with no outward manifestation.)

restrictor: the device that restricts fluid flow between the pressure source and the pressure element. It is used to reduce the effect of pressure fluctuations or to control flow from a pressure element that has failed in service, or both. It may be integrally mounted or separate from the gauge.

retard gauge: see *gauge, retard*.

ring: the component that secures the window to the case. Ring configurations will vary for design and aesthetic reasons.

ring, bayonet: see *ring, cam*.

ring, cam: a ring similar to the threaded ring except that the threads are replaced by a cam arrangement.

ring, friction: a ring retained by means of an interference or friction fit between it and the case.

ring, hinged: a ring retained by a hinge-type device and a single retaining screw.

ring, slip: a ring similar to the friction ring except that it has a clearance fit with the case and is secured by screws.

ring, snap: a ring that snaps into a groove on the case.

ring, threaded: a ring having threads that match threads on the case.

scale: markings on the dial, consisting of graduations, related numerals, and units of measure.

sealed case: see *case, sealed*.

shock (impact) resistance: the maximum deceleration a gauge can withstand without damage or evidence of a change in accuracy of more than a specified value. It is expressed in g's, time duration (10% to 90% of the leading edge of the shock pulse), and number of impacts.

significant surface: see *surface, wetted*.

silver brazing: brazing using a nonferrous filler metal containing silver.

single gauge: see *gauge, single*.

size, gauge: see Fig. 9.

slip ring: see *ring, slip*.

snap ring: see *ring, snap*.

snubber: a device that is used to reduce the effect of pressure fluctuations and surges, or to reduce flow from a pressure element that has failed in service, or both. See ASME B40.5.

socket: see *stem*.

soft soldering: see *soldering*.

soldering (soft soldering): a metal-joining process wherein coalescence is produced by heating to a suitable temperature and by using a nonferrous alloy fusible at temperatures below 425°C (800°F) and having a melting point below that of the base metals being joined.

span: the algebraic difference between the limits of the unretarded portion of the scale.

(a) The span of a 0/100 kPa gauge is 100 kPa.

(b) The span of a suppressed scale gauge is the difference between the maximum and minimum scale pressures. For example, the span of 200/500 psi gauge is 300 psi.

(c) The span of a *compound gauge* is the algebraic difference between the limits of the vacuum and pressure scales when both are expressed in the same units. For example, the span of 30 in. Hg vac (approximately -15 psi) to 30 psi pressure scale is 45 psi.

span adjustment: see *adjustment, span*.

span, compound gauge: see *span*.

span, suppressed scale: see *span*.

specific service gauge: see *gauge, specific service*.

spike: a short duration, high amplitude sudden rise or drop in system pressure.

spontaneous explosive failure: see *failure, explosive*.

standard: see *standard, calibration*.

standard, calibration: a pressure instrument used to determine the accuracy of a gauge (see ASME PTC 19.2).

standard, transfer: see ASME PTC 19.2.

standard, working: see ASME PTC 19.2.

steady pressure: see *pressure, steady*.

stem (socket): the main supporting component of the pressure element assembly to which the elastic element is attached. It may include the pressure connection and mounting for the movement and case.

stop: the component that limits the motion of the pointer (see *stop, internal*, and *stop pin*).

stop, internal: a stop designed to restrain the pressure element motion by acting directly on it or on the movement mechanism (see para. 3.3.7).

stop pin: the component on the dial that limits the angular rotation of the pointer.

suppressed scale gauge: see *gauge, suppressed scale*.

surface (wall) mounted: see *gauge, surface (wall) mounted*.

surface, wetted: any surface that directly contacts the pressure media.

surge: a sudden rise or drop in system pressure.

takeup: the portion of the scale between the position where the pointer is stopped and its true zero pressure position.

temperature, ambient: the temperature of the atmosphere surrounding the gauge.

temperature error: see *error, temperature*.

temperature, process: the temperature of the process medium at the pressure connection of the socket.

temperature, storage: the extremes of temperature (high and low) that the gauge may be exposed to when it is not pressurized.

test gauge: see *gauge, test*.

threaded ring: see *ring, threaded*.

threaded window: see *window, threaded*.

tip: the motion or force transmitting component at the free end of an elastic element.

torr: see para. 3.3.2.1.

traceability: documentation of the existence of a calibration chain between an instrument and a primary standard.

transfer standard: see *standard, transfer*.

vacuum: see *pressure, negative*.

vacuum gauge: see *gauge, vacuum*.

variable pressure: see *pressure, variable*.

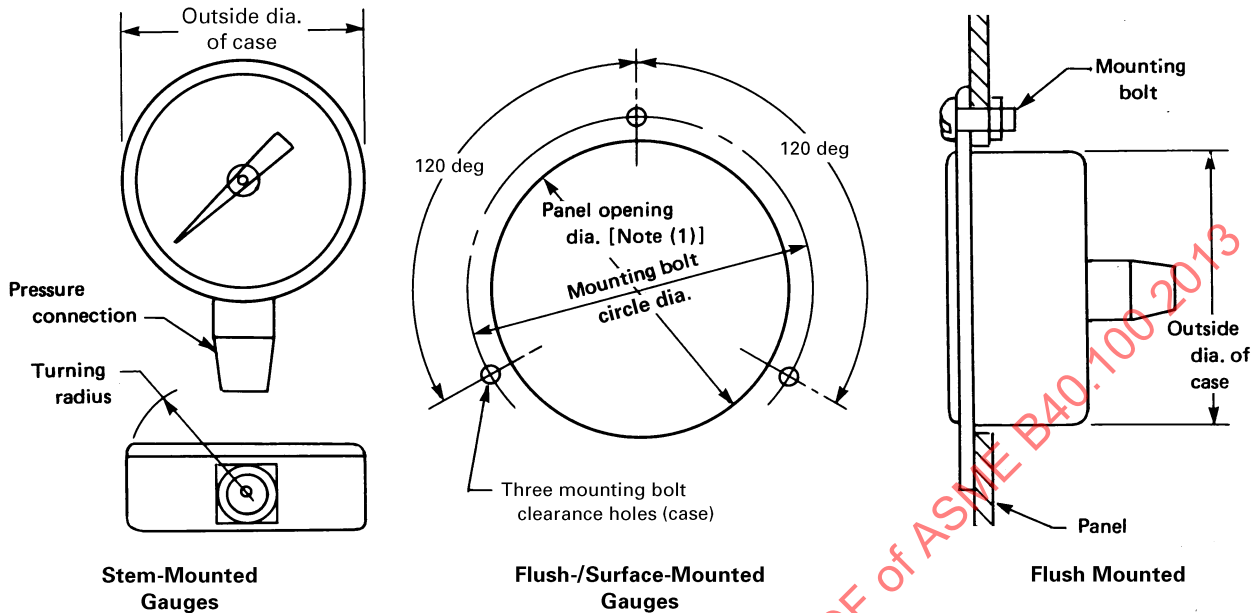
vibration resistance: the maximum sinusoidal acceleration a gauge can withstand without damage or evidence of a change in accuracy of more than a specified value. It is expressed in g's, or amplitude over a frequency range and time period.

welding: a metal-joining process wherein coalescence is produced by heating to suitable temperatures to melt the base metals together, with or without the addition of filler metal. If filler metal is used, it shall have a melting point and composition approximately the same as the base metal.

window: a transparent component that closes the front of the case (see Fig. 2).

window, heat-treated glass: a window of specially heat-treated (tempered) glass, which, when broken, will form

Fig. 9 Recommended Case and Mounting Dimensions



Gauge Size	Flush/Surface Mounting Dimensions							
	Mounting Bolt Circle Diameter		Mounting Bolt Hole Diameter		Panel Opening Diameter		Case Max. Outside Diameter [Note (1)]	
	in.	mm	in.	mm	in.	mm	in.	mm
1½	1.91	48.5	0.13	3.4	1.65	41.9	1.59	40.4
2	2.56	65.0	0.16	4.5	2.19	55.6	2.13	54.1
2½	3.13	79.5	0.16	4.5	2.81	71.4	2.75	69.9
3½	4.25	108	0.22	5.6	3.81	96.8	3.75	95.3
4½	5.38	137	0.22	5.6	4.94	125	4.88	124
6	7.00	178	0.28	7.1	6.50	165	6.44	164
8½	9.63	245	0.28	7.1	9.00	229	8.94	227
12	13.50	343	0.28	7.1	12.62	321	12.56	319
16	17.00	432	0.28	7.1	16.50	419	16.44	418

The sizes listed above are equal to the approximate inside diameter of the case, in inches, at the dial. The EN case sizes listed below define size as the outside diameter of the case. Because of this difference, gauges made to the inch-based sizes may not be interchangeable with those made to the EN sizes, even though the nominal sizes may be very close. For instance, the outside diameter of a size 2½ gauge may be as large as 70 mm, 7 mm larger than that of an EN 63-mm gauge.

Gauge Size	EN 837.1 Case Sizes			
	Mounting Bolt Circle Diameter		Case Outside Diameter [Note (2)]	
	mm	in.	mm	in.
40	51	2.01	40	1.57
50	60	2.36	50	1.97
63	75	2.95	63	2.48
80	95	3.74	80	3.15
100	118	4.65	100	3.94
150	168	6.61	150	5.91
160	178	7.01	160	6.30
250	276	10.87	250	9.84

GENERAL NOTE: Contact supplier for actual mounting dimensions (panel openings, bolt circle diameter, etc.).

NOTES:

(1) Flush-mounted cases only.

(2) The reader should reference ISO 3/ANSI Z17.1-1973 for additional details.

into small, granular pieces, usually with no jagged edges.

window, laminated glass: a window with two or more sheets of glass held together by an intervening layer(s) of clear plastic. When it is cracked or broken, the pieces of glass tend to adhere to the plastic.

window, plain glass: a window of commercial single or double strength plate or sheet glass.

window, plastic: a window of transparent plastic.

window, threaded: window, generally made of plastic, with integral threads that match threads on the case. No separate ring is required.

3 GENERAL RECOMMENDATIONS

3.1 Gauge Sizes

See Fig. 9.

3.2 Typical Ranges

Many ranges in addition to the ones listed in para. 3.2.1 are in common use.

3.2.1 Positive Gauge Pressure. The following is a list of positive gauge pressure:

in. H ₂ O	psi				
0/10	0/3	0/300	0/6,000		
0/15	0/5	0/600	0/10,000		
0/30	0/10	0/800	0/15,000		
0/60	0/15	0/1,000	0/20,000		
0/100	0/30	0/1,500	0/30,000		
0/200	0/60	0/2,000	0/40,000		
0/300	0/100	0/3,000	0/60,000		
	0/160	0/4,000	0/80,000		
	0/200	0/5,000	0/100,000		
kPa					
0/1	0/10	0/100	0/1 000	0/10 000	0/100 000
0/1.6	0/16	0/160	0/1 600	0/16 000	0/160 000
0/2.5	0/25	0/250	0/2 500	0/25 000	0/250 000
0/4	0/40	0/400	0/4 000	0/40 000	0/400 000
0/6	0/60	0/600	0/6 000	0/60 000	0/600 000
bar					
0/0.01	0/0.10	0/1.0	0/10	0/100	0/1,000
0/0.016	0/0.16	0/1.6	0/16	0/160	0/1,600
0/0.025	0/0.25	0/2.5	0/25	0/250	0/2,500
0/0.04	0/0.40	0/4.0	0/40	0/400	0/4,000
0/0.06	0/0.60	0/6.0	0/60	0/600	0/6,000

3.2.2 Negative Gauge Pressure. The following is a list of negative gauge pressure.

in. Hg Vacuum	kPa	bar
30/0	-100/0	-1/0

3.2.3 Compound Pressure. The following is a list of compound pressure:

in. Hg/psi	kPa	bar
30 in. Hg vac/15 psi	-100/150	-1/1.5
30 in. Hg vac/30 psi	-100/300	-1/3
30 in. Hg vac/60 psi	-100/500	-1/5
30 in. Hg vac/100 psi	-100/900	-1/9
30 in. Hg vac/150 psi	-100/1 500	-1/15
30 in. Hg vac/300 psi	-100/2 400	-1/24

3.2.4 Receiver

psi	kPa	bar
3/15	20/100	0.2/1.0

3.3 Construction

3.3.1 Cases. See Fig. 4.

3.3.1.1 General. Cases may be fabricated from various materials using various manufacturing processes. They may have solid fronts or open fronts, and may or may not employ various case pressure relief means. Specific applications may require design variations with respect to case construction. There should be mutual agreement between user, supplier, or manufacturer, or some combination, regarding the applications and the design variations.

3.3.1.2 Cases With Pressure Relief Means. For gauges used to measure gas pressures of 400 psi (2 800 kPa) and higher and liquid pressures of 1,000 psi (7 000 kPa) and higher, cases with pressure relief means are recommended.

3.3.1.3 Solid Front With Pressure Relief Back. In the event of failure of the elastic element within its rated pressure range, the solid front (partition between the pressure element and the window) and the pressure relief back shall be designed to reduce the possibility of window failure and projection of parts outward through the front of the gauge. The user should consult with the supplier regarding the degree of protection required (see section 4).

Normal mounting of the gauge shall not prevent proper functioning of the pressure relief means.

3.3.1.4 Open Front With Pressure Relief. In the event of a slow leak of media through the elastic element, the case pressure relief shall be sufficient to vent the case pressure increase before window failure occurs. If case pressure increases rapidly, however, the case pressure relief device may not prevent parts from being expelled.

Normal mounting of the gauge shall not prevent proper function of the case pressure relief means.

3.3.1.5 Mounting. Mounting holes or studs are used for flush and surface-mounted gauges. They shall be sized and located as shown in Fig. 9.

3.3.2 Dials

3.3.2.1 Common Units

(a) Over the years, different classifications of units of measure have been used. Many of the older units, although not presently officially recognized by standard setting bodies, are still in widespread use and are therefore included in this Standard for the purpose of definition. The three basic classifications are as follows:

(1) *SI (Le Système International d'Unités)*. These units are recognized by the CIPM (Comité International des Poids et Mesures).

(2) *MKSA (meter, kilogram-force, second, ampere)*. The former metric units, which are being replaced by the SI units.

(3) *Customary (inch, pound-force, second, ampere)*. Customary units are used primarily in English-speaking countries and are being replaced in most countries by SI units.

(b) For conversion factors, see para. 7.2.

(c) Definitions of the various units are as follows:

SI		
Abbreviation	Unit	Definition
bar	bar	1 bar = 100 kPa (The bar is a unit outside the SI, which is nevertheless recognized by CIPM.)
kPa	kilopascal	1 kPa = 1 000 Pa
mbar	millibar	1 mbar = bar/1 000 = 100 Pa
MPa	megapascal	1 MPa = 1 000 000 Pa
N/m ²	newton per square meter	1 N/m ² = 1 Pa
Pa	pascal	1 Pa = 1 N/m ²
MKSA		
Abbreviation	Unit	Definition
kg/cm ²	kilograms per square centimeter	1 kg/cm ² = 1 kilogram force per square centimeter
m H ₂ O	meters of water	1 m H ₂ O = 1 meter of water at 68°F (20°C)
mmHg	millimeters of mercury	1 mm Hg = 1 millimeter of mercury at 32°F (0°C)
torr	torr	1 torr = 1.0 mm Hg absolute pressure
Customary		
Abbreviation	Unit	Definition
ft H ₂ O	feet of fresh water	1 ft H ₂ O = 1 foot of water at 68°F (20°C) (0.4328 psi)
ft seawater	feet of seawater	1 ft seawater = 0.4453 psi (0.9877 ft H ₂ O)
in. Hg	inches of mercury	1 in. Hg = 1 inch of mercury at 32°F (0°C) (0.4911 psi)
in. H ₂ O (20°C)	inches of water (Ref. ISA RP2.1)	1 in. H ₂ O (20°C) = 1 inch of water at 20°C (68°F) and 980.665 cm/sec ² gravity (0.036063 psi)

in. H ₂ O (60°F)	inches of water (Ref. AGA Report #3)	1 in. H ₂ O (60°F) = 1 inch of water at 60°F (15.6°C) and 980.665 cm/sec ² gravity (0.036092 psi)
in. H ₂ O (4°C)	inches of water	1 in. H ₂ O (4°C) = 1 inch of water at 4°C and 980.665 cm/sec ² gravity (0.036127 psi)
oz/in. ²	ounces per square inch	1 oz/in. ² = 1 ounce force per square inch
psi	pounds per square inch	1 psi = 1 pound force per square inch gauge pressure
psia	pounds per square inch absolute	1 psia = 1 pound force per square inch absolute pressure
psid	pounds per square inch differential	1 psid = 1 pound force per square inch differential pressure

3.3.2.2 Dial Information. Dials shall indicate the units in which the scale is graduated.

Dual scale dials are useful where gauges are employed on equipment that may be used internationally, or where users plan to convert from one unit of measure to another over a period of time.

Each scale on a dial with multiple scale shall indicate the units in which it is graduated. One of the scales should be one of the typical ranges (see para. 3.2).

Receiver gauge dials shall indicate the input pressure range of the gauge.

Dials with a scale graduated in nonpressure units, or a scale range different from the range of the pressure element assembly, shall clearly indicate the maximum pressure that may be applied to the gauge without loss of calibration.

The use of multipliers, such as ×100, ×1 000, and ×100 kPa, is discouraged because of potential misapplication or misinterpretation.

All of the above scales indicate gauge pressure unless otherwise specified, except when psia, psid, or torr are displayed. For all other scales, absolute or differential pressures are indicated by adding the words ABSOLUTE or DIFFERENTIAL. Uppercase or lowercase letters are acceptable. When space does not permit, the abbreviation ABS, DIFF, or ΔP may be used.

Dial markings may include manufacturer's or customer's trademark, or both, and any other information deemed appropriate for safety of specific service requirements (see para. 4.3.8).

Numerals shall be sufficient in number to enable the operator to accurately and quickly identify any pressure on the scale. They shall not obscure or crowd graduations or important markings.

Numerals shall not extend beyond the calibrated portion of the scale.

Negative (vacuum) values shall be indicated by preceding the appropriate numerals with a minus (–) or clearly marking the dial with the words VAC or VACUUM. Uppercase or lowercase letters are acceptable.

Both signs and words should not appear on the same scale.

The absence of a sign before a numeral indicates a positive value except when accompanied by the words VAC or VACUUM.

3.3.2.3 Scale Arcs. The recommended graduated scale arc is 270 deg. Special applications and ranges may require scale arcs greater or less than 270 deg.

3.3.2.4 Graduation Lines. Graduation lines shall be radial to the center of rotation of the pointer and shall project beyond the arc described by the end of the pointer (mirror and multiple scale dials excepted). Major and intermediate graduation lines shall be emphasized. Graduations shall not extend beyond the calibrated portion of the scale.

Where possible, scale, numeral, and graduation increments should follow the format: 1×10^n , 2×10^n , or 5×10^n , where n is a whole positive or negative number or zero.

It is desirable that the smallest graduation increment should not exceed twice the error permitted (accuracy) in the middle half of the scale.

3.3.2.5 Graduation Near Zero. On dials for Grades 4A and 3A gauges, there shall be no takeup. The number and the spacing of the minor graduations near zero, shall be the same, commencing at the true zero, as in the rest of the scale. On dials for all other grades, take up may be incorporated. However, if it is incorporated, it shall be readily apparent at what pressure the graduations start. A zero graduation or numeral, or both, shall not be permitted at the stopped pointer position on gauges using a stop pin or internal stops that prevent free pointer motion to the actual zero pressure position.

3.3.3 Pointer

3.3.3.1 Length (All Grades). The tip of the pointer shall cover 10% to 90% of the minor graduation. The pointer may overlap the graduations.

3.3.3.2 Tip Width (Grades 4A and 3A). The width of the pointer tip shall not be greater than the width of the minor graduation lines.

3.3.3.3 Pointer Rotation. The pointer shall rotate clockwise for increasing positive pressure and counter-clockwise for increasing negative pressure.

3.3.4 Pointer Adjustment. Pointer adjustment can only be used to match the indication to a reference pressure at one point on the scale and should not be depended upon to recalibrate the gauge. Such an adjustment could cause a significant error at pressures above or below the setting point.

3.3.5 Pressure Connection

3.3.5.1 Location of Connection

(a) *Stem mounted* — bottom or back

(b) *Surface mounted* — bottom or back

(c) *Flush mounted* — back

3.3.5.2 Type of Connection. Taper pipe connections for pressures up through 20,000 psi or 160 000 kPa are usually $\frac{1}{8}$ in. 27 NPT, $\frac{1}{4}$ in. 18 NPT, or $\frac{1}{2}$ in. 14 NPT American Standard external or internal taper pipe threads per ASME B1.20.1 as required. Above this pressure, $\frac{1}{4}$ in. high pressure tubing connections, or equal, may be used. Other appropriately sized connections, employing sealing means other than tapered threads, are acceptable.

In applications of stem-mounted gauges, especially with liquid-filled cases and where vibration is severe, consideration should be given to the possibility of failure of the stem or associated piping caused by the vibrating mass of the gauge. A larger connection (e.g., $\frac{1}{2}$ NPT instead of $\frac{1}{4}$ NPT) or a stronger stem material (e.g., stainless steel instead of brass), or both, should be considered.

3.3.6 Rings. Removable rings, size $4\frac{1}{2}$ and larger, generally have window retaining devices.

3.3.7 Internal Stop. An internal stop is a device that restrains the motion of the pressure element or the mechanism to reduce the probability of damage to the pressure element or disengagement of the movement mechanism caused by application of pressure below the minimum scale value or above the maximum scale value. It will also reduce the possibility of disengagement of the movement mechanism caused by the inertial effect of sudden pressure changes.

3.3.7.1 Maximum Stop. A maximum stop shall prevent pointer motion beyond a point approximately midway between the last and the first dial graduation and shall prevent the pointer from striking an obstruction. Pointer motion shall not be restrained at less than 105% of full scale pressure.

3.3.7.2 Minimum Stop. A minimum stop shall prevent pointer motion below a point 5% lower than the first scale graduation and a point approximately midway between the last and the first dial graduation. When incorporated, requirements of para. 3.3.2.5 shall apply.

3.3.8 Windows

3.3.8.1 Laminated Glass. Laminated glass shall comply with ANSI Z26.1. Laminated glass offers some protection in all applications. It reduces the possibility of glass particles scattering if the pressure element ruptures and window failure results.

3.3.8.2 Tempered Glass. Tempered glass shall comply with ASTM C 1048 (heat treated) or ASTM C 1422 (chemically treated). Tempered glass is generally 2 to 5 times stronger than annealed (plain) glass.

3.3.8.3 Plastic. Impact and abrasive environmental conditions, especially temperature and corrosive atmosphere, must be carefully considered to determine the type of plastic best suited for the application.

3.3.8.4 Plain Glass. This window material is commonly used due to its abrasion, chemical, and wear resistance properties. Careful consideration of its use should be given for hazardous applications.

3.4 Accuracy

Pressure gauge accuracy is graded as shown in Table 1 (see section 6 for testing procedures).

3.4.1 General Discussion

3.4.1.1 Elastic elements are made of many materials to meet various requirements of corrosion resistance and performance. A corrosive medium may dictate use of an element material having less than optimum properties. The accuracy classification of such a gauge depends to a large extent on these properties.

3.4.1.2 Using a pressure gauge in an environment or with media that cause the temperature of the elastic element to be different from that at which it was calibrated will increase the indication error. This is caused by temperature effects on the elastic element, movement, and link.

3.4.1.3 Temperature change affects the stiffness of the elastic element. The change in stiffness of a material with change in temperature is the thermoelastic coefficient (TEC) of the material. Stiffness change is produced by a combination of changes in the elastic modulus (Young's Modulus) due to thermal effects and a change in linear dimensions due to linear expansion and contraction.

Using a pressure gauge in an environment or with media that cause the temperature of the elastic element to be different from that at which it was calibrated will increase the indication error.

For common materials of construction (e.g., stainless steel, bronze), the error caused by temperature will be approximately the percentage values given by the following formula:

$$\text{Error (change in span)} = \pm 0.04 \times (t_2 - t_1)$$

where

t_1 = the temperature at calibration in °C

t_2 = the temperature of the gauge in service in °C

For example, a change of 1% at full scale pressure occurs for each 25°C change in temperature. This error is approximately proportional to the applied pressure.

Special alloys such as NiSpan C (Alloy 902) are also used for elastic elements where heat treatment could control the TEC and reduce the temperature error.

This error is approximately proportional to the applied pressure and therefore cannot be corrected by resetting the pointer.

For a given temperature condition, correction can be made by calculating the approximate error at each applied pressure value and adding it to or subtracting it from the indicated value. If the temperature condition is stable and a more accurate indication is required, recalibration may be appropriate.

3.4.1.4 Gauges represented as being compensated for service at various temperatures generally have components of special materials and design to compensate not only for the temperature effects on the elastic element stiffness, but also to compensate for similar effects on the gauge mechanism. The accuracy classification of a temperature-compensated gauge is established by the magnitude of the largest error encountered when the gauge is tested over its entire rated service temperature range.

3.4.1.5 Gauges with sealed cases, liquid filled or not, will exhibit additional error as a result of exposure to ambient or media temperature different from that at which the case was sealed unless compensation is provided. This error is caused by internal case pressure changes and depends on fill media, extent of fill, and other factors.

The error is constant over the entire scale, and if the temperature is stable, within limits, it can be corrected by resetting the pointer.

An increase in temperature generally causes an increase in internal case pressure with a resulting decrease in indicated pressure. The opposite occurs for a decrease in temperature.

For a given temperature change, the percentage of error noted on the gauge is a function of the range (or span) of the gauge. If, for example, the temperature increases causing the internal case pressure to increase by 3 psi, then on a 0/30 psi gauge, this will cause a -10% error, whereas on a 0/100 psi gauge, the error will be -3%. For higher ranges, the percentage of error becomes proportionately less.

3.4.1.6 The accuracy of a retard gauge shall be expressed as a percentage of the expanded portion of the scale. The accuracy for the compressed portion of the scale may be substantially different.

3.4.1.7 The accuracy of a gauge with suppressed scale shall be expressed as a percentage of span.

3.4.1.8 The accuracy of a compound gauge shall be expressed as a percentage of span.

3.4.1.9 Accuracy is affected by readability. For this reason, more accurate gauges are generally made in larger sizes (see Table 1).

3.4.1.10 Mounting a pressure gauge in a position other than that at which it was calibrated can affect its

accuracy. Normal calibrating position is upright and vertical. For applications requiring mounting in other than this position, consult the supplier.

3.4.1.11 Some absolute pressure gauges are pressure gauges with the pointer set to indicate 14.7 psia with the elastic element unpressurized. These gauges indicate in terms of absolute pressure, but will be in error by the difference between the ambient pressure and 14.7 psia. Other absolute pressure gauges indicate the correct absolute pressure value, even though the ambient pressure may vary.

3.4.1.12 Pressure gauges can be rendered inaccurate during shipment despite care taken in packaging. To ensure conformance to the standard grade to which the pressure gauge was manufactured, it should be checked before use.

3.5 Installation

Before installing a pressure gauge, consideration should be given to environmental conditions such as temperature, humidity, vibration, pulsation, and shock and the possible need for protective attachments, maintenance, and/or special installation requirements. Refer to section 4, Safety.

The gauge connection must be compatible with the mating connection, and appropriate assembly techniques must be used.

Installation of the gauge should be accomplished by tightening the pressure connection using the wrench flats if provided. Failure to do so may result in loss of accuracy, excessive friction, or mechanical damage to the pressure element or case.

4 SAFETY

4.1 Scope

This section of the Standard presents certain information to guide users, suppliers, and manufacturers toward minimizing the hazards that could result from misuse or misapplication of pressure gauges with elastic elements. The user should become familiar with all sections of this Standard, as all aspects of safety cannot be covered in this section. Consult the manufacturer or supplier for advice whenever there is uncertainty about the safe application of a pressure gauge.

4.2 General Discussion

4.2.1 Adequate safety results from intelligent planning and careful selection and installation of gauges into a pressure system. The user should inform the supplier of all conditions pertinent to the application and environment so that the supplier can recommend the most suitable gauge for the application.

4.2.2 The history of safety with respect to the use of pressure gauges has been excellent. Injuries to

personnel and damages to property have been minimal. In most instances, the cause of failure has been misuse or misapplication.

4.2.3 The pressure-sensing element in most gauges is subjected to high internal stresses, and applications exist where the possibility of catastrophic failure is present. Pressure regulators, diaphragm (chemical) seals, pulsation dampers or snubbers, syphons, and other similar items, are available for use in these potentially hazardous systems. The hazard potential increases at higher operating pressure.

4.2.4 The following systems are considered potentially hazardous and must be carefully evaluated:

- (a) compressed gas systems
- (b) oxygen systems
- (c) systems containing hydrogen or free hydrogen atoms
- (d) corrosive fluid systems (gas and liquid)
- (e) pressure systems containing any explosive or flammable mixture or medium
- (f) steam systems
- (g) nonsteady pressure systems
- (h) systems where high overpressure could be accidentally applied
- (i) systems wherein interchangeability of gauges could result in hazardous internal contamination or where lower pressure gauges could be installed in higher pressure systems
- (j) systems containing radioactive or toxic fluids (liquids or gases)
- (k) systems installed in a hazardous environment

4.2.5 When gauges are to be used in contact with media having known or uncertain corrosive effects or known to be radioactive, random or unique destructive phenomena can occur. In such cases the user should always furnish the supplier or manufacturer with information relative to the application and solicit his advice prior to installation of the gauge.

4.2.6 Fire and explosions within a pressure system can cause pressure element failure with very violent effects, even to the point of completely disintegrating or melting the pressure gauge. Violent effects are also produced when failure occurs due to

- (a) hydrogen embrittlement
- (b) contamination of a compressed gas
- (c) formation of acetylides
- (d) weakening of soft solder joints by steam or other heat sources
- (e) weakening of soft soldered or silver brazed joints caused by heat sources such as fires
- (f) corrosion
- (g) fatigue
- (h) mechanical shock
- (i) excessive vibration

Failure in a compressed gas system can be expected to produce violent effects.

4.2.7 Modes of Pressure Gauge Failure

4.2.7.1 Fatigue Failure. Fatigue failure caused by pressure-induced stress generally occurs from the inside to the outside along a highly stressed edge radius of a Bourbon tube, appearing as a small crack that propagates along the edge radius. Such failures are usually more critical with compressed gas media than with liquid media.

Fatigue cracks usually release the medium slowly so case pressure buildup can be averted by providing pressure relief openings in the gauge case. However, in high pressure elastic elements where the yield strength approaches the ultimate strength of the element material, fatigue failure may resemble explosive failure.

A snubber (restrictor) placed in the gauge pressure inlet will reduce pressure surges and fluid flow from the partially open elastic element (see para. I-2.4).

4.2.7.2 Overpressure Failure. Overpressure failure is caused by the application of internal pressure greater than the rated limits of the elastic element and can occur when a low pressure gauge is installed in a high pressure port or system. The effects of overpressure failure, usually more critical in compressed gas systems than in liquid-filled systems, are unpredictable and may cause parts to be propelled in any direction. Cases with pressure relief openings will not always retain expelled parts.

Placing a snubber (restrictor) in the pressure gauge inlet will not reduce the immediate effect of failure, but will help control flow of escaping fluid following rupture and reduce the potential of secondary effects.

It is generally accepted that solid front cases with pressure relief back will reduce the possibility of parts being projected forward in the event of failure.

The window alone will not provide adequate protection against internal case pressure buildup, and can be the most hazardous component.

Short duration pressure impulses (pressure spikes) may occur in hydraulic or pneumatic systems, especially when valves open or close. The magnitude of the spikes may be many times the normal operating pressure, and may not be indicated by the gauge. The result could be immediate failure, or a large upscale error. A snubber (restrictor) may reduce the magnitude of the pressure transmitted to the elastic element.

Use of a pressure limiter valve can isolate the pressure gauge from pressures greater than the rated limits of the elastic element, protecting the gauge from overpressure failure. A pressure limiter valve is a device that is designed to close on rising pressure, limiting the pressure at the outlet of the device. The closing pressure is adjustable and should be set to close above the full scale range of the pressure gauge and below the rated limit of the elastic element. Complete information regarding pressure limiter valves is contained in ASME B40.6.

4.2.7.3 Corrosion Failure. Corrosion failure occurs when the elastic element has been weakened through attack by corrosive chemicals present in either the media inside or the environment outside it. Failure may occur as pinhole leakage through the element walls or early fatigue failure due to stress cracking brought about by chemical deterioration or embrittlement of the material.

A diaphragm (chemical) seal should be considered for use with pressure media that may have a corrosive effect on the elastic element.

The addition of a seal may reduce accuracy or sensitivity or both. For further detail see ASME B40.2.

4.2.7.4 Explosive Failure. Explosive failure is caused by the release of explosive energy generated by a chemical reaction such as can result when adiabatic compression of oxygen occurs in the presence of hydrocarbons. It is generally accepted that there is no known means of predicting the magnitude or effects of this type of failure. For this mode of failure, a solid wall or portion between the elastic element and the window will not necessarily prevent parts being projected forward.

4.2.7.5 Vibration Failure. The most common mode of vibration failure is wear of mechanical components because of high cyclic loading caused by vibration. This is characterized by gradual loss of accuracy, and, ultimately failure of the pointer to indicate any pressure change.

4.2.7.6 Vibration-Induced Fatigue Failure. In addition to its effect on the gauge movement and linkage, (see para. 4.2.7.5), vibration may in some instances result in high loading of various parts of the pressure element assembly. This loading could cause cracks in the element itself, or in joints. Case pressure buildup may be slow, but it is possible that a large hole may suddenly develop, with a high rate of case pressure rise, which could result in a failure similar to an explosive failure.

4.2.7.7 Plugging. Apparent failure may be encountered due to plugging (clogging) of internal pressure passages or throttling devices by the pressure media. A diaphragm seal should be considered for use with pressure media that may cause plugging or clogging.

4.2.8 Pressure Connection. See recommendations in para. 3.3.5.

4.3 Safety Recommendations

4.3.1 Operating Pressure. The pressure gauge selected should have a full-scale pressure such that the operating pressure occurs in the middle half (25% to 75%) of the scale. The full-scale pressure of the gauge selected should be approximately 2 times the intended operating pressure.

Should it be necessary for the operating pressure to exceed 75% of full scale, contact the supplier for recommendations.

This does not apply to test retarded or suppressed scale gauges.

NOTE: Gauges that are obviously not working or indicating erroneously should be immediately valved off or removed from service to prevent further damage.

4.3.2 Use of Gauges Near Zero Pressure. The use of gauges near zero pressure is not recommended because the accuracy tolerance of the gauge may be a large percentage of the applied pressure. If, for example, a 0/100 psi Grade A gauge is used to measure 4 psi, the accuracy of measurement will be ± 2 psi, or 50% of the applied pressure.

For this reason, gauges should not be used for the purpose of indicating the residual pressure in a tank, autoclave, or other similar device that has been seemingly exhausted. Depending on the accuracy and the range of the gauge, hazardous pressure may remain in the tank even though the gauge is indicating zero pressure.

The operator may develop a false sense of security when the gauge indicates zero or near-zero pressure even though there may be substantial pressure in the system. A venting device must be used to completely reduce the pressure to zero before unlocking covers, removing fittings, or performing other similar activities.

4.3.3 Compatibility With Medium

4.3.3.1 Wetted Parts. The elastic element is generally a thin-walled member, which of necessity operates under high stress conditions and must, therefore, be carefully selected for compatibility with the medium being measured. None of the common element materials is impervious to every type of chemical attack. The potential for corrosive attack is established by many factors, including the concentration, temperature, and contamination of the medium. The user should inform the gauge supplier of the installation conditions so that the appropriate element materials can be selected.

4.3.3.2 Calibration Test Fluid. The calibration fluid must be compatible with the medium. Test fluids containing hydrocarbons should not be used when the medium is oxygen or other oxidants.

4.3.4 Capability of a Pressure Element. In addition to the factors discussed above, the capability of a pressure element is influenced by the design, materials, and fabrication of the joints between its parts.

Common methods of joining are soft soldering, silver brazing, and welding. Joints can be affected by temperature, stress, and corrosive media. Where application questions arise, these factors should be considered and discussed by the user and supplier.

4.3.5 Special Applications. Some special applications require that the pressure element assembly have a high degree of leakage integrity. Users should contact the supplier to ensure that the allowable leakage rate is not exceeded.

4.3.6 Cases

4.3.6.1 Cases, Solid Front. It is generally accepted that a solid front case per para. 3.3.1 will reduce the possibility of parts being projected forward in the event of elastic element assembly failure. An exception is explosive failure of the elastic element assembly.

4.3.6.2 Cases, Liquid Filled. It has been general practice to use glycerin or silicone filling fluids. These fluids must be avoided where strong oxidizing agents including, but not limited to, oxygen, chlorine, nitric acid, and hydrogen peroxide are involved. In the presence of oxidizing agents, potential hazard can result from chemical reaction, ignition, or explosion. Completely fluorinated or chlorinated fluids, or both, may be more suitable for such applications.

The user shall furnish detailed information relative to the application of gauges having liquid-filled cases and solicit the advice of the gauge supplier prior to installation.

In a compressed gas application, consideration should also be given to the instantaneous hydraulic effect that may be created by one of the modes of failure outlined in para. 4.2.7. The hydraulic effect due to pressure element failure could cause the window to be projected forward even when a case having a solid front is employed.

4.3.7 Snubber. Placing a snubber or a restrictor between the pressure connection and the elastic element will not reduce the immediate effect of failure, but will help reduce flow of escaping fluid following rupture and reduce the potential of secondary effects. For further details, see ASME B40.5.

4.3.8 Specific Service Conditions. Specific applications for pressure gauges exist where hazards are known. In many instances, requirements for design, construction, and use of gauges for these applications are specified by state or federal agencies or Underwriters Laboratories, Inc. Some of these specific service gauges are listed in paras. 4.3.8.1 through 4.3.8.4. The list is not intended to include all types, and the user should always advise the supplier of all application details.

4.3.8.1 Acetylene Gauge. A gauge designed to indicate acetylene pressure (and other gases having similar properties). The gauge may bear the inscription ACETYLENE on the dial. For material recommendations see CGA E-4.

4.3.8.2 Ammonia Gauge. A gauge designed to indicate ammonia pressure and to withstand the corrosive effects of ammonia. The gauge may bear the inscription AMMONIA or NH₃ on the dial. It should also

include the equivalent saturation temperature scale markings on the dial. Materials such as copper, brass, and silver brazing alloys should not be used.

4.3.8.3 Chemical Gauge. A gauge designed to indicate the pressure of corrosive or high viscosity fluids, or both. The primary material(s) in contact with the medium may be identified on the dial. It may be equipped with a diaphragm (chemical) seal, pulsation damper, or pressure relief device, or a combination. These devices help to minimize potential damage to personnel and property in the event of gauge failure. They may, however, also reduce accuracy or sensitivity, or both.

4.3.8.4 Oxygen Gauge. A gauge designed to indicate oxygen pressure. Cleanliness shall comply with Level IV (see section 5). The dial shall be clearly marked with a universal symbol and/or USE NO OIL in red color (see para. 6.1.1.4).

4.4 Reuse of Pressure Gauges

It is not recommended that pressure gauges be moved from one application to another for the following reasons:

(a) *Chemical Compatibility.* The consequences of incompatibility can range from contamination to explosive failure. For example, moving an oil service gauge to oxygen services can result in explosive failure.

(b) *Partial Fatigue.* The first installation may involve pressure pulsation that has expended most of the gauge life, resulting in early fatigue in the second installation.

(c) *Corrosion.* Corrosion of the pressure element assembly in the first installation may be sufficient to cause early failure in the second installation.

5 CLEANLINESS

5.1 General

This section provides standardized reference for gauge users in specifying cleanliness requirements and guidance to manufacturers in meeting these requirements.

If gauge cleanliness is important for the application, such as for use on equipment involving food processing, life support, or oxidizing fluids, the user should specify the appropriate level of cleanliness listed in Table 2.

If the cleanliness requirements of the intended application are not covered in Table 2, the user should so advise the manufacturer.

5.2 Cleanliness Levels

Cleanliness is determined by the size and quantity of maximum permissible solid contaminants on wetted surfaces or by the quantity of contaminant (hydrocarbons) discernible in the fluids used to flush or clean such surfaces, or by both. Common cleanliness levels are defined in Table 2.

5.3 Inspection for Cleanliness

Hydrocarbon concentration may be determined by methods such as infrared spectrophotometry or black light (ultraviolet) radiation of the long wave type [approximately 3 600 angstrom units (360 nm)], where the solvent used to flush the pressure element assembly is evaluated.

When black light radiation methods are employed, the manufacturer should ascertain that the solvent used will dissolve all hydrocarbons that could be present and that all hydrocarbons are detectable and fluoresce under black light.

The dimensions of particles and fibers are usually determined by microscopic examination of filter paper through which the flushing solvent has been passed.

5.4 Packaging

Gauges shall be packaged in such a manner that specified cleanliness requirements are maintained.

The user shall take proper precautions so that cleanliness levels for socket and pressure element are maintained after the gauge is removed from its package for installation.

6 PRESSURE GAUGE TESTING

6.1 Calibration Standards

6.1.1 General Discussion

6.1.1.1 Standards shall have nominal errors not greater than $\frac{1}{4}$ of those permitted for the gauge being tested. For example, when testing a 200 psi Grade 1A (1%) gauge, the standard must have errors not more than $\frac{1}{4}$ of 1%, or 0.5 psi. The range of the standard must be not less than that of the gauge under test but may be higher, as long as the errors do not exceed 0.5 psi. A 200 psi Grade 3A gauge, with errors of 0.25% of 200 (0.5 psi), or a 500 psi Grade 4A gauge, with errors of 0.1% of 500 (0.5 psi) or a 1,000 psi digital gauge with errors of 0.05% of 1,000 (0.5 psi) may be used.

Standards for pressure, weight, density, and linear dimensions used in manufacturing and calibrating the test instruments shall conform to equivalent measuring standards that have been calibrated at NIST and shall have a documented path to NIST.

6.1.1.2 Complete information regarding manometers and piston gages is contained in ASME PTC 19.2. To compute their errors, geographical location and elevation must be determined and gravity corrections applied, as outlined in NIST manometry and piston gage monographs.

6.1.1.3 Gauges used as standards shall be tested for accuracy regularly. The frequency of such testing will depend on their demonstrated ability to retain accuracy after a period of time and after repeated use. The date of the last test may be noted on the front of the gauge.

Table 2 Cleanliness Levels

Cleanliness Level [Note (1)]	General Cleanliness Requirements Applicable to All Levels	Allowable Size and Quantity				Maximum Hydrocarbon, ppm [Note (3)]
		Particles		Fibers		
		Size (Micrometers)	Maximum Quantity [Note (2)]	Size (Micrometers)	Maximum Quantity [Note (2)]	
I	Normal cleanliness attained through high standard shop practices	No limit	No limit	No limit	No limit	No limit
IV	Gauge shall be free of visually [Note (4)] (unaided eye) detectable moisture and foreign matter (chips, slivers, weld slag or splatter, shop soil, greases, oils, or other contaminants) that could be mechanically detrimental to proper function of gauge	Less than 100 100/500 Over 500	No limit 25 0	Less than 700 700/1 000 Over 1 000	No limit 10 0	50

NOTES:

- (1) Levels II and III have been discontinued.
- (2) Quantity = number by count per solvent flush.
- (3) Ppm per solvent flush (approximately the volume contained by the wetted surface).
- (4) Excluding particle, fiber, and hydrocarbon detection procedures.

6.1.1.4 Piston gages or other standards that contain oil or other hydrocarbon fluids shall not be used to test oxygen gauges or other gauges cleaned to Level IV. See Table 2 and para. 4.3.3.2.

6.1.1.5 If a liquid medium is used, correction for the difference in liquid head between the standard and the gauge being tested may be necessary, especially in the case of low pressure gauges.

6.1.1.6 A liquid medium shall not be used to test gauges where the weight of liquid in the pressure element will introduce significant errors. This effect is greater on low pressure gauges.

6.1.1.7 If an air piston gage is used, no liquid is permitted in the gauge under test, or in the lines between the gauge and the piston gage.

6.1.2 Recommended Standards. A wide variety of mechanical and electronic standards may be used to test gauges. Some of these are

- (a) piston gage (hydraulic or air)
- (b) manometer
- (c) test gauge
- (d) pressure transducer or transmitter

Selection of a standard is determined by the accuracy and pressure range of the gauge being tested, suitability of the medium, convenience of use, and availability.

6.2 Verification Test Procedures

The following procedures are suggested when testing a pressure gauge to determine its compliance with the

accuracy grades defined in para. 3.4. Statistical methods or alternate test procedures, or both, may be used when agreed to by the supplier and the user.

6.2.1 Reference Temperature (All Grades). A temperature of $20^{\circ}\text{C} \pm 1^{\circ}\text{C}$ (approximately $68^{\circ}\text{F} \pm 2^{\circ}\text{F}$) shall be the reference standard. Temperature-compensated gauges shall be tested at several ambient temperatures within the compensated range.

6.2.2 Reference Barometric Pressure. A barometric pressure 101.32 kPa (29.92 in. Hg) shall be the reference standard. Only absolute pressure gauges with the pointer set to indicate 14.7 psia will be affected by changes in barometric pressure (see para. 3.4.1.11).

6.2.3 Calibration Standards. See para. 6.1.

6.2.4 Procedures

6.2.4.1 Accuracy

(a) *Grades 3A and 4A.* Before conducting the accuracy test, subject the gauge to a pressure equal to the maximum indicated pressure (or vacuum). Conduct the accuracy test within 10 minutes.

(b) *All Grades/Classes.* Known pressure shall be applied at each test point on increasing pressure (or vacuum). At each test point the gauge under test shall be read, lightly tapped, and then read again. The difference of the readings is friction error. The same sequence shall be repeated on decreasing pressure (or vacuum). The entire set of upscale and downscale readings shall then be repeated.

Accuracy Grade/ Classes	Minimum Recommended Number of Test Points [Note (1)]
4A	10
3A, 2A, 1A, A	5
B, C, D	3
0.6	5
1.6	3
2.4	3
4	4
	Minimum Number of Test Points for EN 837-1
0.1, 0.25, 0.6	10
1	5
1.6, 2.5, 4	3

NOTE:

(1) The test points shall be distributed over the dial range and shall include points within 10% of the ends of the dial range.

The error can be determined from the data obtained in the two pressure cycles and is equal to the maximum error at each test point, in either direction, after tapping. When expressed as a percentage of span, the error shall not exceed the limits in Table 1 for the applicable grade of accuracy.

6.2.4.2 Repeatability. Repeatability can be determined from the data obtained in para. 6.2.4.1. It is the difference between any two readings taken after tapping, at the same pressure, approached from the same direction, and in the two pressure cycles, expressed in percentage of span. More than two pressure cycles may be desirable.

Repeatability does not include hysteresis or friction error.

6.2.4.3 Hysteresis. Hysteresis can be determined from the data obtained in the two pressure cycles (see para. 6.2.4.1). It is the difference at each test point between increasing pressure and decreasing pressure readings taken after tapping, at the same test point, approached from both increasing and decreasing pressure directions; in a single pressure cycle, expressed in percentage of span (see Fig. 10).

The hysteresis value is lower if the pressure excursion is less than full scale. Hysteresis does not include friction error. Hysteresis error shall not exceed the absolute value of the limits of permissible error at a reference temperature of 20°C (68°F). The amount of hysteresis errors should not move the readings outside the permissible error limits for accuracy (see Table 1).

7 ORDERING PARAMETERS AND RELATED STANDARDS

7.1 Order Checklist

The following includes some factors to consider and questions to answer when ordering pressure gauges.

7.1.1 Assistance Not Required. If the user does not require assistance with selection and recommendation for service involved, specify

- (a) supplier's catalog number, size, range, and connection location and size
- (b) variations or accessories, or both, if required

7.1.2 Moderate Assistance Required. If the user requires moderate assistance, specify

- (a) range (specify units of measure) (see para. 3.2)
- (b) accuracy (see para. 3.4)
- (c) size (para. 3.1 and Fig. 6)
- (d) material
- (e) method of joining the pressure-containing components
- (f) connection type, location, and size
- (g) mounting (stem, surface, or flush) (see Figs. 5 and 6)
- (h) supplier's catalog number
- (i) variations or accessories, or both

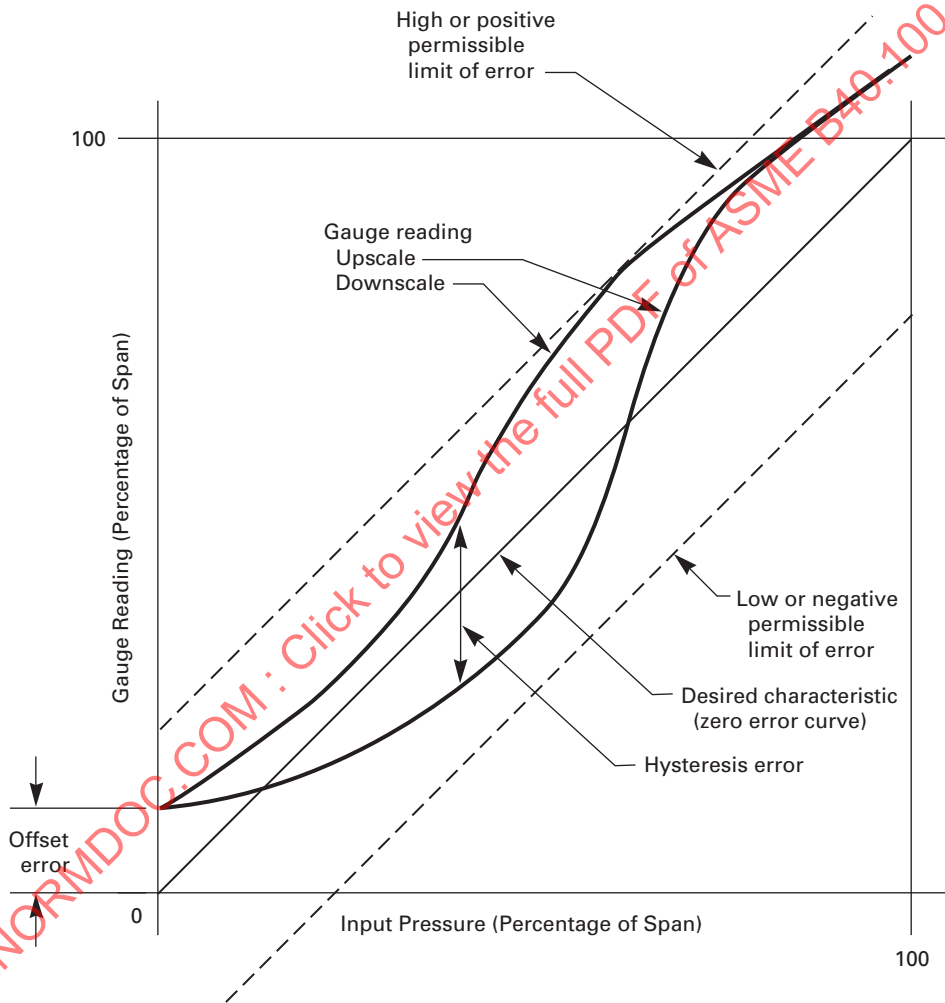
7.1.3 Detailed Assistance Required. If the user requires detailed assistance, specify items listed in para. 7.1.2 plus the applicable portions of the following:

- (a) medium, name and state (gas or liquid), concentration, temperature
- (b) material of process equipment
- (c) pressure pulsation range and frequency
- (d) sudden pressure increase or decrease (spike or surge)
- (e) case and ring materials
- (f) window material
- (g) environmental conditions such as
 - (1) vibration frequency and amplitude
 - (2) temperature
 - (3) indoor and outdoor use
 - (4) corrosive atmosphere
 - (5) dust
 - (6) weather resistance
 - (7) humidity
 - (8) mechanical shock

7.2 Conversion Factors (Customary Units to SI Units)

The Customary measuring units are listed below with their corresponding SI units and conversion factors. Multiplying the Customary units by the conversion factor will yield the correct value in SI units.

Fig. 10 Hysteresis and Offset Error



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Customary Unit X	Conversion Factor [Note (1)]	= SI Unit
atmosphere (standard)	1.01325 E+05	Pa (pascal)
bar [Note (2)]	1.00000 E+05	Pa
in. (inch)	2.54000 E-02	m (meter)
ft (foot)	3.04800 E-01	m
in. H ₂ O (4°C)	2.49081 E+02	Pa
in. H ₂ O (20°C)	2.48640 E+02	Pa
in. H ₂ O (60°F)	2.48850 E+02	Pa
ft H ₂ O (20°C)	2.98370 E+03	Pa
in. ² (square inches)	6.45160 E-04	m ² (square meters)
ft ² (square feet)	9.29030 E-02	m ²
psi (pound force per square inch)	6.89476 E+03	Pa
oz./in. ² (ounce per square inch)	6.89476 E-02	bar [Note (2)]
in. Hg (mercury) (0°C)	3.38638 E+03	Pa
micron	1.00000 E-06	m
°F (degree Fahrenheit)	(°F-32)/1.8	°C (degree Celsius)

NOTES:

- (1) Conversion factors are expressed as a number between 1.0 and 10.0 with five decimal places. This number is followed by the letter E (for exponent), a plus or minus symbol, and two digits indicating the power of 10 by which the number must be multiplied to correctly place the decimal point. The plus or minus indicates the direction the decimal must be moved: plus to the right, minus to the left.

EXAMPLES:

- (a) 2.54000 E-02 means 2.54000×10^{-2} and equals 0.025400
 (b) 1.01325 E+05 means 1.01325×10^5 and equals 101,325
- (2) The bar is a unit outside the SI system that is nevertheless recognized by the Comité International des Poids et Mesures (CIPM).

7.3 Related Standards

Other standards and specifications relating to pressure gauges and their performance requirements follow. The edition bearing the latest date of issuance shall be used.

ANSI Z26.1, Safety Code for Glazing Materials for Glazing Motor Vehicles Operating on Land Highways

Publisher: American National Standards Institute (ANSI), 25 West 43rd Street, New York, NY 10036 (www.ansi.org)

ASME B1.20.1, Pipe Threads, General Purpose (Inch) (Except Dryseal)

ASME B1.20.3, Dryseal Pipe Threads

ASME PTC 19.2, Performance Test Code, Pressure Measurement

Publisher: The American Society of Mechanical Engineers (ASME), Two Park Avenue, New York, NY 10016; Order Department: 22 Law Drive, P.O. Box 2900, Fairfield, NJ 07007-2900 (www.asme.org)

CGA E-4, Standard for Gas Pressure Regulators

Publisher: Compressed Gas Association (CGA), 14501 George Carter Way, Suite 103, Chantilly, VA 20151 (www.cganet.com)

EN 837.1, Pressure Gauges Part 1: Bourbon Tube Pressure Gauge — Dimensions, Metrology, Requirements, and Testing

Publisher: European Committee for Standardization (CEN), Avenue Marnix 17, B-1000 Brussels, Belgium (www.cen.eu). The English language version is published by British Standards Institute (BSI), 389 Chiswick High Road, London W4 4AL United Kingdom (www.bsigroup.com).

ISA RP2.1, Manometer Tables

Publisher: Instrument Society of America (ISA), 67 Alexander Drive, Research Triangle Park, NC 27709

ISO 5171, Pressure Gauges Used In Welding, Cutting and Related Processes

Publisher: International Organization for Standardization (ISO), Central Secretariat, 1, ch. de la Voie-Creuse, Case postale 56, CH-1121 Genève 20, Switzerland/Suisse (www.iso.org)

FED-STD-H28, Screw-Thread Standards for Federal Services

MIL-G-6019, Gage, Pressure, Dial Indicating, Oxygen, Low Pressure

MIL-G-6035, Gage, Pressure, Dial Indicating, Oxygen, High Pressure

MIL-G-17489, Gage, (Pressure) (Air) Boiler

MIL-G-18997, Gage, Pressure, Dial Indicating

Publisher: Federal specifications available from: Superintendent of Documents, U.S. Government Printing Office (GPO), 732 N. Capitol Street, NW, Washington, DC 20401 (www.gpoaccess.gov/index.html)

NBS Monograph No. 8, Mercury Manometers

NBS Monograph No. 65, Reduction of Data for Piston Gauge Pressure Measurement (NBS Technical Note on Error Assessment)

SAE J906, Automotive Safety Glazing Manual

Publisher: Society of Automotive Engineers (SAE International), 400 Commonwealth Drive, Warrendale, PA 15096 (www.sae.org)

UL 299, Fire Extinguishers, Dry Chemical

UL 393 (ANSI B156.1), Indicating Pressure Gauges for Fire Protection Service

UL 404, Gauges, Indicating Pressure, for Compressed Gas Service

UL 626, Fire Extinguishers, Halogenated Agent

Publisher: Underwriters Laboratories, Inc. (UL), 333 Pfingsten Road, Northbrook, IL 60062-2096 (www.ul.com)

MANDATORY APPENDIX I

TEST PROCEDURES USED TO MEASURE NEW GAUGE PERFORMANCE

I-1 SCOPE

This Mandatory Appendix relates to performance and test requirements for pressure gauges utilizing C, spiral, and helical-shaped Bourdon tubes. It covers pressure, compound, and vacuum gauges for industrial use up to 1 600 bar (23,200 psi). It applies to liquid-filled and high-pressure gauges used for gases, including oxygen and acetylene. It does not cover pressure gauges with electrical contacts. Consult the manufacturer when it is known that the pressure gauges will encounter conditions more severe than those specified in this Mandatory Appendix.

I-2 EVALUATION PROCEDURES

CAUTION: Failures during pressure testing are unpredictable and may cause parts to be propelled in any direction. All pressure testing should be conducted by qualified personnel using appropriate safety equipment, such as safety glasses, shields, enclosures, or a combination to prevent personal injury and property damage. Read section 4 before conducting any testing.

I-2.1 Accuracy

See para. 6..1 for a description of the test procedures.

I-2.2 Temperature-Related Error

I-2.2.1 High Temperature Error. The gauge shall be tested for accuracy in accordance with para. 6.2.4.1. The gauge shall then be placed in a temperature test chamber at an elevated temperature [e.g., 60°C (140°F)] and allowed to stabilize for a period of not less than 4 h. The gauge shall then be checked for accuracy at this temperature, in accordance with para. 6.2.4.1. The difference in readings at each test point between room temperature and the maximum operating temperature is the high temperature error.

I-2.2.2 Low Temperature Error. The gauge shall be tested for accuracy in accordance with para. 6.2.4.1. The gauge shall then be placed in a temperature test chamber at a lower temperature [e.g., -20°C (-4°F)] and allowed to stabilize for a period of not less than 4 h. The gauge shall then be checked for accuracy at this temperature, in accordance with para. 6.2.4.1. The difference in readings at each test point between room temperature and the minimum operating temperature is the low temperature error.

Table I-1 Proof Pressure Testing Specifications

Overpressure Requirements	
Pressure Range of Gauge	Pressure in Percent of Span
0–100 bar (0–1,500 psi)	125%
100–400 bar (1,500–6,000 psi)	115%
400–1 400 bar (6,000–20,000 psi)	110%

I-2.2.3 Storage Temperature Test. The gauge shall be tested for accuracy in accordance with para. 6.2.4.1. The gauge shall then be placed in a temperature test chamber at an elevated temperature [e.g., 70°C (158°F)] for a period of 24 h. The gauge shall then be placed in a temperature test chamber at a lower temperature [e.g., -40°C (-40°F)] for a period of 24 h. This 48-h cycle shall be repeated four times for a total of five complete cycles. The gauge shall then be allowed to stabilize at room temperature and then be checked for accuracy, in accordance with para. 6.2.4.1. The difference between the two accuracy tests is the effect of storage temperature expressed as a percentage of span. The gauge shall not change its appearance. The dial and pointer shall not crack, blister, or change color. If gauge cases are liquid filled, there shall be no evidence of the fill liquid leakage.

I-2.3 Pressure Testing

I-2.3.1 Rated Pressure Testing. The gauge shall be pressurized to its full scale pressure for a minimum of 12 h and maintain accuracy with no evidence of leakage.

I-2.3.2 Proof Pressure Testing. The gauge shall be overpressurized for 15 min to the values shown in Table I-1.

After applying overpressure, the gauge shall be tested for accuracy in accordance with para. 6.2.4.1. The readings shall be within the permissible error limits for the accuracy grade/class of the gauge under test.

I-2.4 Fatigue Testing

The gauge shall be tested for accuracy in accordance with para. 6.2.4.1. The gauge shall then be subjected to repeated applications of a pressure (hydraulic preferred) that produces an indication from 20% to 80% of the range of the gauge at a rate of 0.3 Hz to 0.6 Hz. The application and release of the pressure shall be as smooth

Table I-2 Fatigue Testing Cycle Requirements

Fatigue Testing Cycle Specification	
Pressure Range Gauge	Number of Cycles Required
0–25 bar (0–350 psi)	300,000
25–600 bar (350–9,000 psi)	100,000
600–1 600 bar (9,000–23,000 psi)	20,000

as practicable, so as not to subject the gauge mechanism to excessive upscale or downscale accelerations or high amplitude impulses (pressure spikes). The gauge shall be tested periodically for accuracy in accordance with the test specified in para. 6.2.4.1, not less than 1 h after stopping the pressure cycling. The difference between the first set of readings at each test point and the latest set of readings at each test point is fatigue error at this point. The gauge shall also be tested periodically for leakage of the pressure element assembly at full scale pressure. The fatigue life is the number of cycles to leakage (see Table I-2).

NOTE: Pressure limits different from 20% to 80% of the range of the gauge can have a significant effect on the fatigue error and life.

I-2.4.1 Accuracy After Fatigue Test. After completion of the fatigue test, the gauge should be left undisturbed for 1 h. Accuracy should then be tested in accordance with para. 6.2.4.1, and the errors should not exceed 1.2 times the original values.

I-2.5 Effect of Mechanical Shock

After being exposed to shocks of 15 g, the gauge should not change its reading by more than 25% of its accuracy grade rating. The test should be administered in accordance with IEC 60068-2-27: 1987, Basic Environmental Testing Procedures Part 2: Tests — Test Ea and Guidance: Shock.

I-2.6 Effect of Mechanical Vibration

The vibration test is required for gauges of accuracy grades 2A, 1A, A, and B.

The gauge shall be tested for accuracy in accordance with para. 6.2.4.1 before starting the vibration tests. Each of the tests specified below shall be conducted separately in each of three mutually perpendicular axes. All tests in one axis shall be completed before proceeding to tests in another axis. The gauge under test shall be secured to the vibration table in the same manner that it will be secured in service. In the case of surface or flush mounting, the panel shall be sufficiently rigid to ensure that its motion will be essentially the same as the motion of the platform of the vibration machine. Input condition should be monitored adjacent to the gauge mounting. A pressure of $50\% \pm 5\%$ of full scale shall be applied to the gauge under test during vibration. This pressure may be applied by pressurizing the gauge and sealing the pressure port.

Table I-3 Vibration Test Amplitudes

Frequency, Hz	Amplitude, mm	Amplitude, in.
5 to 15	1.5 \pm 0.3	0.060 \pm 0.012
15 to 25	1.0 \pm 0.2	0.040 \pm 0.008
26 to 33	0.5 \pm 0.1	0.020 \pm 0.004
34 to 40	0.25 \pm 0.05	0.010 \pm 0.002
41 to 60	0.13 \pm 0.025	0.005 \pm 0.001

I-2.6.1 Exploratory Vibration Tests. To determine the presence of resonances, the gauge under test shall be vibrated at frequencies from 5 Hz to 60 Hz at a peak-to-peak amplitude not to exceed that shown in Table I-3. The change in frequency shall be made in discrete frequency intervals of approximately 1 Hz and maintained at each frequency for about 15 s. The frequencies and locations at which resonances occur shall be noted.

I-2.6.2 Endurance Test. The gauge shall be tested for a period of 2 h in each of three mutually perpendicular axes (6-h total) at the resonant frequency. If more than one resonant frequency exists, the test shall be conducted at the highest resonant frequency. If no resonance is observed, the test shall be in accordance with Table I-3.

Test for accuracy in accordance with para. 6.2.4.1 before and after the endurance test. The change in errors should not exceed 1.5 times the permissible errors for the accuracy grade.

I-2.7 Solid Front Gauges

I-2.7.1 Slow Leak Bourdon Tube. Solid front gauges should protect the user from failure of the pressure system and the resulting release of pressurized media by deflecting the pressure release away from the front of the gauge.

The baffle wall between the Bourdon tube and dial should have a minimal amount of openings. These holes should be reserved for fixing screws, pointer shafts, and dial pillars only. These openings should be less than 5% of the area of the baffle wall.

The existence of blowout devices should be verified by inspection of the gauge.

The functionality of the pressure relief devices should be tested by

- slowly pressurizing the case with air of the gauge, with the Bourdon tube removed
- sealing all areas of the case with low strength sealant, with the exception of the pressure relief areas
- slowly increasing a measured pressure until the pressure relief portion activates
- recording pressure at which the back blows out

The window of the gauge should not fail during these tests, nor should any internal components of the gauge be expelled from the front of the gauge.

Table I-4 Receiver Pressure

Maximum Gauge Range	Test Pressure
Up to and including 100 bar (1,500 psi)	1.5 times maximum scale value
Above 100 bar (1,500 psi) up to and including 350 bar (5,000 psi)	1.15 times maximum scale value
Above 350 bar (5,000 psi)	Maximum scale value

I-2.7.2 Sudden Bourdon Tube Rupture. All sizes of solid front gauges should be subjected to a high-pressure gas release test with the Bourdon tube removed, as follows:

This test shall be conducted on a gauge from which the pressure element has been removed. The pressure gauge shall be connected to a pressure receiver having at least ten times the volume of the gauge case. Connection shall be made using a short length of pipe or tubing of suitable wall thickness to withstand the required pressure. The pipe or tubing between the gauge and receiver shall include a union fitted with a frangible blowout disc. Sudden rupture of the elastic element in the pressure case shall be simulated by gradually raising the pressure in the receiver with nitrogen or air until the frangible disc ruptures. A quick opening valve may be substituted for the frangible blowout disc if the valve can be fully opened from the closed position in less than 25 ms. Pressure in the receiver shall be monitored by another pressure gauge or pressure transducer. Gauges shall be tested to the pressures specified in Table I-4. The pressure relief device (pressure relief plug, blowout disc, or pressure relief back) shall be blown from the case (pressure relief plug or blowout disc), successfully open (pressure relief back), or relieve pressure from the case without causing a failure in either the case or the window.

I-2.8 Nonsolid Front Case — Slow Leak Bourdon Tube

The functionality of pressure relief devices should be tested by removing the Bourdon tube and slowly pressurizing the case with air until the pressure relief device activates. The pressure shall be recorded. The pressure relief device (pressure relief plug, blowout disc, or pressure relief back) shall activate, successfully relieving pressure without causing a failure in the case or ejecting the window.

I-2.9 Leak Integrity at Rated Temperatures in Service

The pressure gauge shall show no signs of leakage ($<5 \times 10^{-3}$ mbar \times l/s, 5×10^{-3} atm cc/s) within the manufacturer's specified range of ambient temperatures and media temperatures. Test samples shall be placed at the maximum temperature recommended by the manufacturer. For brass gauges, the test samples should be subject to 2.5 times the full scale pressure of the gauge up to 1 000 bar (14,500 psi) for 240 h. Steel or stainless steel gauges should be subject to 2.5 times the full scale pressure of the gauge up to 1 000 bar (14,500 psi) for 24 h. After testing, gauges should show no sign of leakage ($<5 \times 10^{-3}$ mbar \times l/s, 5×10^{-3} atm cc/s). No accuracy testing is required.

For ranges above 1 000 bar (14,500 psi), 1.5 times the full scale pressure of the gauge should be applied.

I-2.10 Rupture Pressure Test (Burst Test)

Apply pressure (hydraulic preferred) to the gauge under a test increasing at the maximum rate of 20% of the full scale per second until the Bourdon tube ruptures. The minimum rupture pressure shall be 2.5 times the ranges up to and including 300 bar (5,000 psi). For pressure ranges above 300 bar (5,000 psi), consult the manufacturer.

I-2.11 Liquid-Filled Gauges — Seal Integrity and Stability

NOTE: This test must be conducted on each fill fluid.

(a) Mount gauge normally in accordance with the supplier's instruction.

(b) Heat filled gauge to the supplier's recommended maximum temperature, and hold for a minimum of 2 hr.

(c) Reduce temperature to the supplier's recommended minimum temperature, and hold for a minimum of 2 h.

(d) Repeat the above cycle 20 times.

(e) No leakage of the fill fluid is permitted.

(f) The dial must remain readable. No discoloration of the fill fluid, which degrades readability of the dial, is permitted.

NOTE: If some slight discoloration is observed, additional exposure to the maximum temperature may be desirable, to determine whether further darkening of the fluid, to the point where readability is affected, will occur.

MANDATORY APPENDIX II

GAUGES USED ON REGULATORS

This Mandatory Appendix is intended to emphasize and supplement the recommendations contained in this Standard and to guide personnel specifying and installing gauges used on regulators for oxy-fuel gas welding, cutting, and allied processes. It should not be assumed that every test or safety procedure or method, precaution, equipment, or device is contained in this Mandatory Appendix, or that abnormal or unusual circumstances may not warrant suggesting further requirements or additional procedures.

II-1 SCOPE

This Mandatory Appendix is intended to emphasize those parts of this Standard that are applicable to gauges commonly used on regulators for oxy-fuel gas welding, cutting, and allied processes and to provide specific considerations for gauge dial printing (marking) and gauge installation.

II-2 RECOMMENDATIONS

II-2.1 General References

Gauges used on regulators for oxy-fuel gas welding, cutting, and allied processes are to be governed by the recommendations of this Standard.

To facilitate the use of this Standard, references have been made to specific sections and paragraphs.

II-2.2 General Contents

II-2.2.1 Basic Terms. Basic terms and definitions are outlined in section 2.

II-2.2.2 General Requirements. General requirements are provided in section 3. Gauges used on regulators are usually size $1\frac{1}{2}$ in., 2 in., and $2\frac{1}{2}$ in., mounted by the stem (socket), and have open front cases with pressure relief. They shall be grade B accuracy or better.

II-2.2.3 Safety Considerations. Safety considerations are discussed in section 4.

II-2.2.4 Cleanliness Levels. Cleanliness levels are detailed in section 5. Gauges used on oxygen regulators shall have cleanliness equivalent to Level IV.

II-2.2.5 Testing Standards and Procedures. Pressure gauge testing standards and procedures are discussed in section 6. Additional information is outlined in Mandatory Appendix I.

II-2.2.6 Helpful Information. Section 7 contains helpful information relative to ordering gauges, related standards, and conversion factors.

II-2.3 Gauges Used on Regulators

The following references to specific paragraphs of this Standard apply to gauges used on regulators. Appropriate additional considerations are discussed.

II-2.3.1 Sizes. See para. 3.1. The nominal gauge sizes are $1\frac{1}{2}$ in., 2 in., and $2\frac{1}{2}$ in. for regulator applications.

II-2.3.2 Ranges. See para. 3.2. Common ranges for gauges used on regulators are listed in Table II-1 by customary units and the corresponding SI units (rounded to a maximum of two significant figures).

It is recommended that no larger graduations than those shown in Table II-1 be printed (marked) on the gauge dial. The spacing and displaying of the numerals marked on the gauge dial may vary for aesthetic reasons, provided that at least three numerals are displayed.

II-2.3.3 Cases. See paras. 3.3.1 and 4.3.8. The cases commonly used for regulator gauge applications are open front with pressure relief. Figure 6 and paras. 3.3.1.1 and 3.3.1.4 outline case construction.

II-2.3.4 Dials. See para. 3.3.2.

II-2.3.4.1 Recommended units of measure for gauges used on regulators are kPa and psi (psig) presented together (dual scale).

II-2.3.4.2 Paragraphs 3.3.2.3 through 3.3.2.5 are applicable. Scale graduations on gauges installed on the output side of acetylene regulators are usually restricted to 15 psi, with the scale red-lined above 15 psi.

II-2.3.4.3 Dials used on regulator gauges having ranges greater than 1,000 psi usually contain a UL listing mark. The UL listing mark indicates that the gauge design complies with Underwriters Laboratories Safety Standard UL 404 and gauges bearing the listing mark are subject to UL follow-up procedures.

II-2.3.5 Pointer Length. See para. 3.3.3.

II-2.3.6 Pressure Connection. See para. 3.3.5. Gauges used on regulators are stem mounted and have $\frac{1}{8}$ in. 27 NPT or $\frac{1}{4}$ in. 18 NPT taper pipe threads, per ANSI B1.20.1.

Table II-1 Ranges

Customary Units, psi			SI Units, kPa		
Range	Smallest Graduation	Numerals	Range	Smallest Graduation	Numerals
0/15	0.5	3.0	0/100	2.0	20
0/30	1.0	5.0	0/200	5.0	50
0/50	1.0	10	0/350	10	50
0/60	2.0	10	0/400	10	100
0/100	2.0	20	0/700	20	100
0/150	5.0	30	0/1 000	20	200
0/160	5.0	20	0/1 100	20	200
0/200	5.0	40	0/1 400	50	200
0/300	10	50	0/2 000	50	500
0/400	10	50	0/2 800	100	400
0/500	10	100	0/3 500	100	500
0/600	20	100	0/4 000	100	1 000
0/1,000	20	200	0/7 000	200	1 000
0/1,500	50	300	0/10 000	200	2 000
0/2,000	50	400	0/14 000	500	2 000
0/3,000	100	500	0/20 000	500	5 000
0/4,000	100	500	0/28 000	1 000	4 000
0/5,000	100	1,000	0/35 000	1 000	5 000
0/6,000	200	1,000	0/40 000	1 000	10 000
0/7,500	200	1,000	0/50 000	1 000	10 000
0/10,000	200	2,000	0/70 000	2 000	10 000

II-2.3.7 Windows. See para. 3.3.8. Plastic windows are most commonly used on regulator gauges.

II-2.3.8 Accuracy. See para. 3.4. Gauges shall have an accuracy of Grade B or better (see Table 1). Applicable paragraphs in this section include: 3.4.1, 3.4.1.1, 3.4.1.2, 3.4.1.6, 3.4.1.9, 3.4.1.10, and 3.4.1.12.

II-2.3.9 Safety. See section 4. Personnel specifying and installing pressure gauges used on oxy-fuel gas regulators should become familiar with the material presented in this section.

II-2.3.10 Cleanliness. See section 5. Gauges used on oxygen regulators shall comply with cleanliness Level IV or better.

II-2.3.11 Acetylene. See para. 4.3.8.2.

II-2.3.12 Pressure Gauge Testing. See section 6. The pressure medium used for testing shall maintain the required cleanliness level of the gauge under calibration or calibration verification. The dead-ended pressure element assembly of regulator gauges cannot be reliably cleaned once contaminated. Gauges contaminated with hydrocarbon pressure media shall not be used on oxygen regulators.

II-3 INSTALLATION

II-3.1 References

This section is limited to the installation of gauges on regulators, as used for oxy-fuel gas welding, cutting, and allied processes. The installation and operation of regulators may be found in manufacturer's instruction manuals or handbooks, in the Occupational Safety and Health Standards for Industry (29 CFR, Part 1910), Subpart Q, and in the National Institute for Occupational Safety and Health (NIOSH), Safety and Health in Arc Welding and Gas Welding and Cutting.

II-3.2 General Precautions

Oxygen and hydrocarbons (oil and grease are common hydrocarbons) under certain conditions can react violently, resulting in explosions, fire, and damage and injury to personnel and property. Never allow oil or grease to come into contact with any external or internal part of the threaded fitting or internal portion of the pressure element assembly of oxygen gauges. Even a minute amount of hydrocarbon can be hazardous in the presence of oxygen.

Regulator gauges should be installed or replaced only by skilled personnel who have been properly instructed.

II-3.3 Installation Precautions

DO maintain the pressure element assembly and connection cleanliness level required for the intended application.

DO refer to the manufacturer's instruction manual for the correct pressure ranges to be used.

DO use the wrench flats provided on the gauge connection and the proper size wrench to secure the gauge to the regulator.

DO use only the thread sealant recommended by the regulator manufacturer for the specific application.

DO NOT install a low pressure gauge into the high pressure port on a regulator.

DO NOT use the gauge case for wrenching.

DO NOT interchange gauges from one gas application to another.

DO NOT exchange gauges from one regulator to another.

DO NOT conduct calibration verification using air from shop air lines, oil, or a contaminated pressure source.

DO NOT remove the restrictor installed in the gauge connection. The restrictor limits gas flow and aids in limiting temperature rise due to adiabatic compression.

II-3.4 Operation Precautions

Gauges can fail during operation and the energy contained in compressed gases can produce violent effects should the pressure element assembly rupture.

DO always apply cylinder pressure slowly. Heat due to adiabatic compression can cause ignition.

DO use safety glasses or provide eye protection.

DO stand with the cylinder between yourself and the regulator (cylinder valve outlet facing away) when opening the cylinder valve.

DO read CGA Safety Bulletin SB-8, Use of Oxy-Fuel Gas Welding and Cutting Apparatus.

DO NOT stand in front of or behind the pressure gauges when applying cylinder pressure to the regulator. This will reduce the possibility of injury from flying parts should the pressure element assembly rupture.

DO NOT operate regulators without eye protection.

II-4 Referenced Documents

The edition bearing the latest date of issuance shall be used.

ASME B1.20.1, Pipe Threads, General Purpose, (Inch) (Except Dryseal)

Publisher: The American Society of Mechanical Engineers (ASME), Two Park Avenue, New York, NY 10016-5990; Order Department: 22 Law Drive, P.O. Box 2900, Fairfield, NJ 07007-2900 (www.asme.org)

CGA E-4 Regulator Pressure Gauges

CGA TB8 Use of Oxy-Fuel Gas Welding and Cutting Apparatus, Technical Bulletin

Publisher: Compressed Gas Association, Inc. (CGA), 14501 George Carter Way, Suite 103, Chantilly, VA 20151 (www.cganet.com)

NIOSH Publication No. 78-138, Safety and Health in Arc Welding and Gas Welding and Cutting

29 CFR, Part 1910, Subpart Q, National Institute for Occupational Safety and Health. (NIOSH), Safety and Health in Arc Welding and Gas Welding and Cutting

Publisher: Department of Health, Education and Welfare, Public Health Service, National Institute of Occupational Safety and Health, Robert A. Taft Laboratories, 4676 Columbia Parkway, Cincinnati, OH 45226 (www.cdc.gov/niosh)

UL 404, Gauges, Indicating Pressure, for Compressed Gas Service

Publisher: Underwriters Laboratories, Inc. (UL), 333 Pfingsten Road, Northbrook, IL 60062-2096 (www.ul.com)

MANDATORY APPENDIX III SUPPLEMENTAL REQUIREMENTS

The following supplementary requirements established for naval shipboard application shall apply when specified in the contract or purchase order. When there is conflict between the Standard (ASME B40.1) and this supplement, the requirements of this supplement shall take precedence for equipment acquired by this supplement. This document supercedes MIL-G-18997, Gauges, Pressure, Dial Indicating, for new ship construction.

III-1 SCOPE

This addendum describes requirements for Naval hardened pressure gauges for use in the demanding environment of marine applications. Many of the basic requirements of ASME B40.1 apply, however some modified and/or additional requirements, which include withstanding shock and salt-water spray, are included.

III-2 GENERAL REQUIREMENTS

III-2.1 Gauge Sizes

Naval hardened gauges are limited to these five nominal sizes: 2 in., 2½ in., 3½ in., 4½ in., and 8½ in.

III-2.2 Ranges

The following gauge types are shown with their ranges and respective range designators.

III-2.2.1 Positive Pressure. Table III-1 shows the ranges and range designators for general purpose positive pressure gauges.

III-2.2.2 Negative Pressure. Table III-2 shows the ranges and range designators for negative (vacuum) pressure gauges.

III-2.2.3 Compound Pressure. Table III-3 shows the ranges and range designators for general purpose compound pressure gauges.

III-2.2.4 Refrigerant Pressure. Table III-4 shows the ranges and range designators for refrigerant pressure gauges.

III-2.2.4.1 Gauge Scale. A separate temperature degrees Fahrenheit (°F) equivalent scale in red printing, in addition to the pressure scale in lb/in.², shall be included. The type of refrigerant used with the pressure gauge shall be marked on the dial (see para. III-2.3.3.2).

III-2.2.5 Suppressed. Table III-5 shows the range and range designator for suppressed pressure gauges.

III-2.2.6 Retard. Table III-6 shows the ranges and range designators for retard pressure gauges.

Table III-1 Positive Pressure Range Designators

Positive Pressure, lb/in. ²	Range Designator
0/15	15P
0/30	30P
0/60	60P
0/100	1hP
0/160	160P
0/200	2hP
0/300	3hP
0/400	4hP
0/600	6hP
0/800	8hP
0/1,000	1kP
0/1,500	15hP
0/2,000	2kP
0/3,000	3kP
0/5,000	5kP
0/8,000	8kP
0/10,000	10kP

GENERAL NOTES:

- Gauge pressure ranges from 0/15 to 0/1,000 are applicable to both simplex and duplex indicators.
- Gauge pressure ranges from 0/1,500 to 0/10,000 are applicable to simplex only.

Table III-2 Negative Pressure Range Designators

Negative Pressure, in. Hg Vacuum	Range Designator
0/30	V

III-2.2.7 Caisson Pressure. Caisson gauges are intended for use in submarine escape trunks and decompression chambers. They shall have a dual scale with the inner scale graduated in meters or feet of seawater and the outer scale in lb/in.² The gauge case shall be open to the ambient pressure through a vent in the bottom of the case. The vent shall be threaded to accept a ¼ in. NPT male fitting. Table III-7 shows the ranges and range designators for caisson pressure gauges. Feet shall indicate feet (depth) of seawater. One foot of seawater shall equal 0.4453 psi.

Table III-3 Compound Pressure Range Designators

Compound Pressure		
Vacuum, in. Hg	Gauge Pressure, lb/in. ²	Range Designator
30	0/15	15C
30	0/30	30C
30	0/60	60C
30	0/100	1hC
30	0/150	150C
30	0/200	2hC
30	0/300	3hC
30	0/400	4hC
30	0/600	6hC
30	0/800	8hC

Table III-4 Refrigerant Pressure Range Designators

Ranges			
Vacuum, in. Hg	Gauge Pressure, lb/in. ²	Refrigerant Type	Range Designator
30	0/30	R-11	A11
30	0/100	R-11	B11
30	0/150	R-11	C11
30	0/300	R-11	D11
30	0/100	R-12	E12
30	0/150	R-12	F12
30	0/300	R-12	G12
30	0/150	R-22	H22
30	0/300	R-22	J22
30	0/30	R-114	K14
30	0/100	R-114	L14
30	0/150	R-134A	M34
30	0/300	R-134A	N34

Table III-5 Suppressed Pressure Range Designators

Suppressed Pressure Range, lb/in. ²	Range Designator
1,000/1,500	S

Table III-6 Retard Pressure Range Designators

Retard			
Vacuum, in. Hg	Gauge Pressure, lb/in. ²	Expanded Portion	Range Designator
...	0/30	0/10	R1
30	0/30	30 in. 0/5 lb/in. ²	R2
30	0/150	30 in. 0/75 lb/in. ²	R3

Table III-7 Caisson Pressure Range Designators

Caisson	Range Designator
0/100 lb/in. ² – 0/230 ft depth	1hK
0/200 lb/in. ² – 0/450 ft depth	2hK
0/300 lb/in. ² – 0/675 ft depth	3hK
0/380 lb/in. ² – 0/850 ft depth	380K
0/380 lb/in. ² – 0/900 ft depth	4hK

III-2.3 Construction

III-2.3.1 Case

III-2.3.1.1 Design. Pressure gauge cases shall be safety solid front. However, a nonsolid front is permitted for gauges with elastic element Style D (helical and helical-spiral Bourdon tube). Cases for hardened gauges must withstand the demands of a saltwater environment and meet shock requirements. Cast iron, mild steel or plastic (with the exception of the window) shall not be used. When used, aluminum per ASTM B26, ASTM B85, and ASTM B209 shall be protected against corrosion. Case finish shall then include air dry primer and a gray enamel finish coat in accordance with FED-STD-595, color 26307. Corrosion resisting steel (CRES) shall be per ASTM A167 Series 300 and ASTM A473 Series 300 when used. Cases shall be interchangeable for mounting purposes with the case shown in Fig. III-1. Dimensions A3, A4, A8, A10, A15, and A17 shall be critical dimensions and shall be in accordance with Fig. III-1.

III-2.3.1.2 Mounting. Flush mounting kits shall be provided with all pressure gauges. Material shall be CRES except steel may be used for the ring and clamping ring. The maximum outside diameter of the flush mounting rings shall overlap the panel hole by no more than 0.25 in.

III-2.3.2 Internal and Other Parts

III-2.3.2.1 Welding or Microbrazing. Internal pressure containing parts shall be joined by welding or microbrazing.

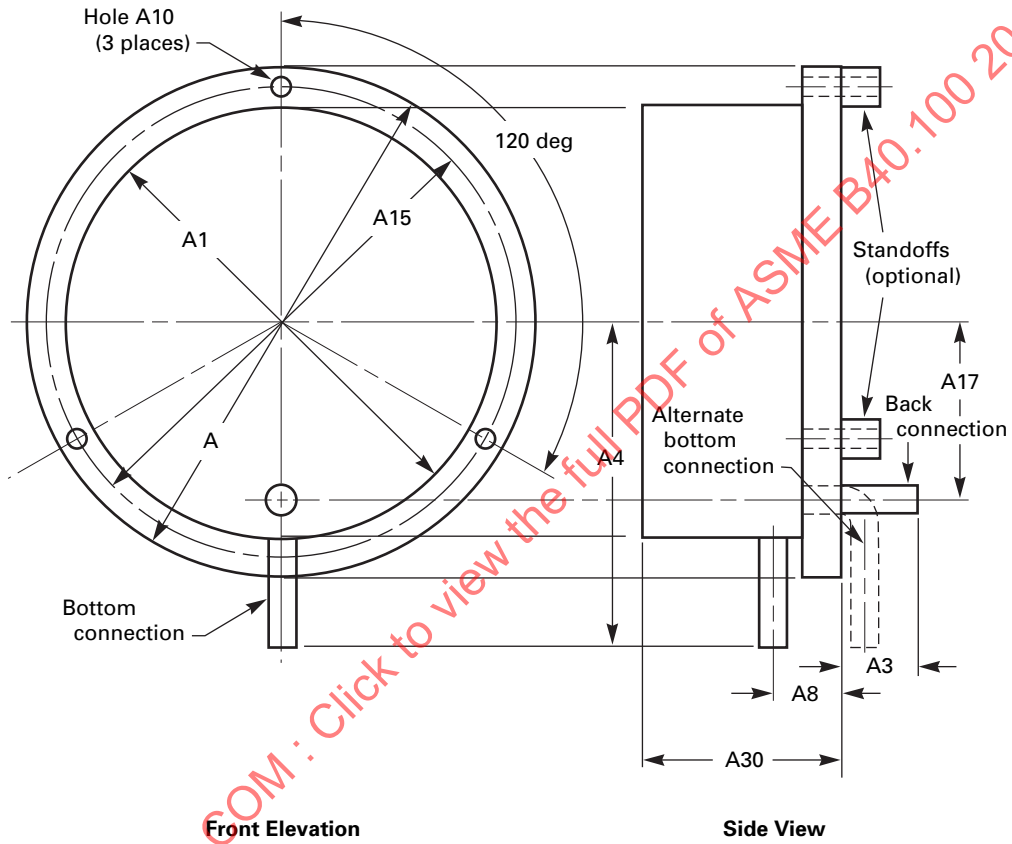
III-2.3.2.2 Materials. Wetted parts shall be nickel-copper alloys. Wetted parts include any part that comes in contact with the measured fluid, e.g., Bourdon tube, stem, tail piece (see Fig. III-2), etc. Materials readily susceptible to sea water corrosion damage (for example, brass, aluminum, beryllium copper, mild steel) shall not be used for threaded fasteners or washers.

III-2.3.2.3 O-Ring. O-rings shall be fluorocarbon rubber in accordance with SAE-AMS 7259, hardness of 85 to 95 Durameter.

III-2.3.3 Dials. Dials shall be designed to resist damage from corrosion.

III-2.3.3.1 Units. The standard units for gauges shall be Customary (English). Dual scale (Customary and SI) may be used on all gauges except for Caisson (see para. III-2.2.7) and Refrigeration (see para. III-2.2.4),

Fig. III-1 Case Design



Size/DIM	A ± 0.1	A1 + 0.000 - 0.1	A3 ± 0.3	A4 ± 0.3	A8 ± 0.1	A10 ± 0.01	A15 ± 0.015	A17 ± 0.050	A30
3½	4.75	3.97	1.2	3.2	1.0	0.22	4.25	1.063	2.54 - 4.0
4½	5.80	5.00	1.2	3.8	1.0	0.22	5.375	1.625	2.54 - 4.0
8½	10.25	8.97	1.2	5.8	1.0	0.28	9.625	3.625	2.54 - 4.0

GENERAL NOTES:

(a) For flush mounting, standard panel hole diameters are:

- 3½ → 4¹⁵/₃₂
- 4½ → 5¹⁹/₃₂
- 8½ → 9²⁹/₃₂

(b) Dimensions are in inches.

Table III-8 Pressure Connection Requirements and Applications

Pressure Connection	Threads	Reference	Intended Use
O-ring union	$\frac{9}{16}$ in. UNF-3A	Figs. III-2 and III-3	For all applications, except nuclear
Taper pipe thread (male)	$\frac{1}{4}$ in. 18 NPT	ASME B1.20.1	For use in stem-mounted pressure gauges with ranges 0/100 lb/in. ² or below
Flareless (bite type) $\frac{1}{4}$ in., tubing, 6,000 psi	$\frac{7}{16}$ in. 20 UNF-2A	SAE J 1926	For nuclear applications

in order to permit transition to SI units. Refrigeration gauges that show both temperature and pressure readings shall use Customary units for readability.

III-2.3.3.2 Markings. Dial markings shall include

- (a) the manufacturer's name or trademark (or both)
- (b) CAGE (Commercial and Government Entity) code
- (c) Part Identifying Number (PIN) (see para. III-6.2.1)
- (d) NSN (National Stock Number), if assigned
- (e) scale graduations, numerals, and units of graduations
- (f) refrigerant gauges shall include the type refrigerant and applicable temperature equivalent scale

III-2.3.4 Pointer. Indicating pointers shall be a non-reflective black with white background dials or white when dials have black backgrounds. The index pointer shall be a nonreflective red and shall be set off-scale prior to delivery. Duplex indicator pointers shall be orange (left) and green (right).

III-2.3.5 Pressure Connection. The pressure connection shall be in accordance with Table III-8. The O-ring union connection (see Figs. III-2 and III-3) shall be supplied unless otherwise specified and shall include the threaded end, union nut, tail piece, and O-ring.

III-2.3.5.1 Location. Table III-9 lists the four possible connection locations.

III-2.3.5.2 Type of Connection. Threads shall be in accordance with Table III-8. Tapered threads shall not be used except on 2 in. and 2½ in., dial sizes for ranges 0/100 lb/in.² or below.

III-2.3.6 Windows. Windows shall be fabricated from scratch-resistant thermoplastic in accordance with ASTM D788.

III-2.3.7 Maximum Stop. Gauges shall incorporate a maximum stop (see para. 3.3.7.1).

III-3 CLEANLINESS AND PACKAGING

III-3.1 Wetted Parts Cleanliness

Naval hardened gauges shall meet Cleanliness Level IV (see Table 2) for all applications except for

oxygen service (see para. III-7.8). Naval pressure gauges (especially the wetted parts) shall be free of loose scale, rust, grit, filings, mercury, calibration liquids, oil, grease, solvents, and other organic materials.

III-3.2 Packaging

Unless special packaging is specified, gauges shall be bagged and boxed in accordance with ASTM D3951.

III-4 VERIFICATION

III-4.1 Responsibility for Inspection

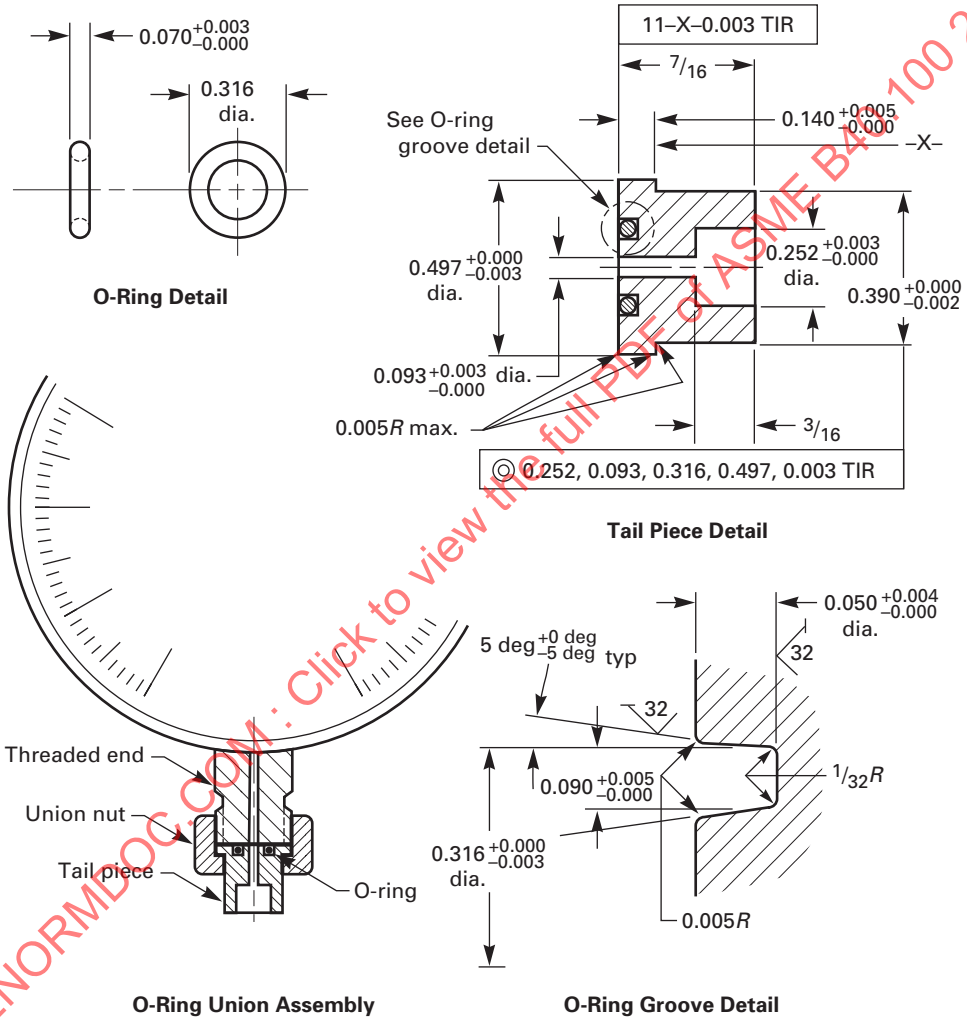
Unless otherwise specified in the contract or purchase order, the manufacturer is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or purchase order, the manufacturer may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the purchaser. The purchaser reserves the right to perform any of the inspections set forth in the standard where such inspections are deemed necessary to ensure supplies and services conform to prescribed requirements.

III-4.1.1 Responsibility for Compliance. All items shall meet all requirements of section III-5. The inspection set forth in this specification shall become a part of the manufacturer's overall inspection system or quality program. The absence of any inspection requirements in this specification shall not relieve the manufacturer of the responsibility of assuring that all products or supplies submitted to the purchaser for acceptance comply with all requirements of the contract. Sampling inspection, as part of the manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however this does not authorize submission of known defective material, either indicated or actual, nor does it commit the purchaser to accept defective material.

III-4.2 Classification of Inspections

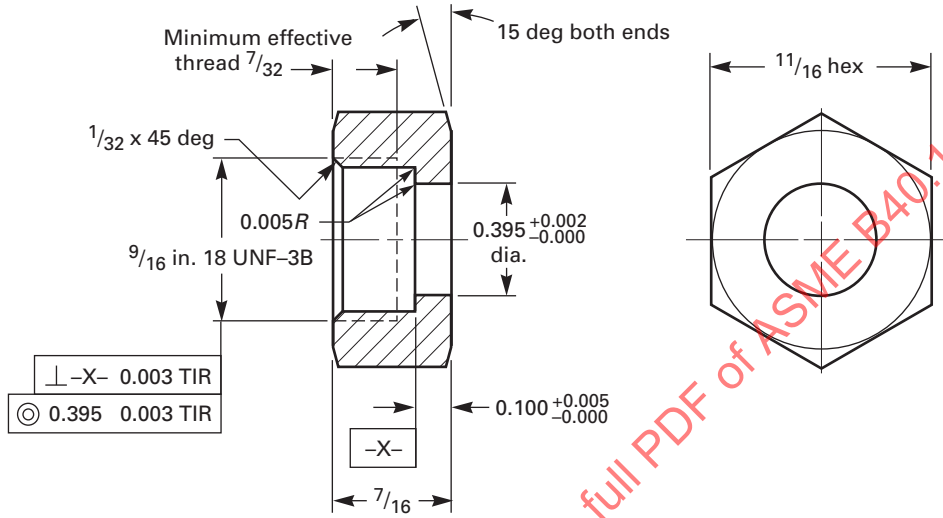
III-4.2.1 Qualification Inspection. Qualification inspection shall be performed and passed prior to production. Qualification inspection shall be performed on

Fig. III-2 O-Ring Union Assembly

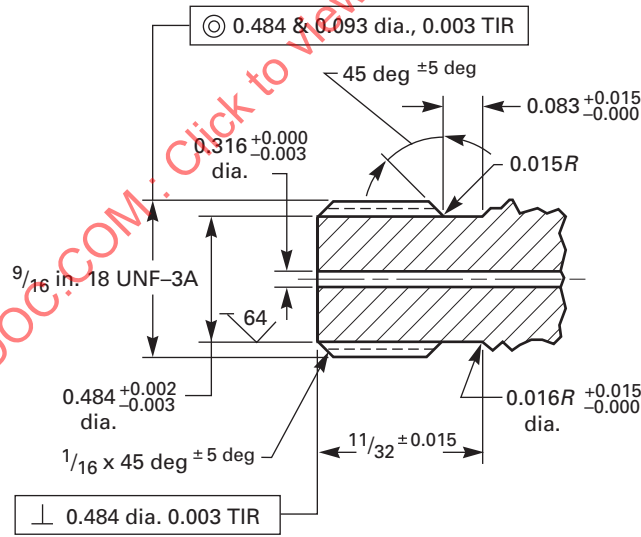


GENERAL NOTE: Dimensions are in inches.

Fig. III-3 O-Ring Union Nut/Threaded End Detail



Union Nut Detail



Threaded End Detail

GENERAL NOTE: Dimensions are in inches.

Table III-9 Gauge Connection Positions

Case	Bottom	Lower Back	Center Back	5 O'clock Position
Flush/surface-mounted	X	X	...	X
Caisson	X
Stem-mounted	X	...	X	...

Table III-10 Inspection Requirements

Inspection	Qualification	Conformance
Examination	X	X
Accuracy	X	X
Friction error	X	X
Repeatability	X	X
Inclination	X	...
Pressure integrity	X	...
Temperature	X	...
Salt spray	X	...
Load test	X	...
Pressure cycling	X	...
Elastic element or joining means failure	X	...
Vibration	X	...
Shock	X	...
Case pressure relief	X	...

samples which have been produced with equipment and procedures normally used in production and shall consist of the examination and tests specified in Table III-10.

III-4.2.1.1 Sample Size. Two gauges of each design, size, range, and elastic element style shall be subjected to the qualification inspection.

III-4.2.2 Conformance Inspection. Conformance inspection shall be performed at the place of manufacture. Each gauge shall be subjected to conformance inspection which consists of the examination and tests specified in Table III-10.

III-4.2.3 Acceptance Criteria. If any gauge sample fails to meet the conformance inspection requirements of Table III-10, no gauges shall be accepted until the manufacturer has determined the cause of the defect and has taken the necessary action to correct or eliminate the defect from each gauge in the lot. The failed test shall be repeated to demonstrate that the corrective action will enable the gauges to conform to the requirements of this specification. In addition, the results of previous tests may be deemed invalid, unless the manufacturer can prove to the satisfaction of the purchaser that such test would not be adversely impacted by the corrective action.

III-4.2.3.1 Lot. A lot consists of all gauges of the same part identification number that are manufactured at one time.

III-5 TEST PROCEDURES AND REQUIREMENTS

III-5.1 Examination

Gauges shall be examined to determine that the material, finish, workmanship, construction, assembly, dimensions, and markings conform to this Standard.

III-5.2 Accuracy

Accuracy shall be tested in accordance with para. 6.2.4.1. Accuracy for 3½, 4½, and 8½ shall be in accordance with the requirements of Table 1, accuracy Grade 1A. Accuracy for 2 and 2½ shall be in accordance with the requirements of Table 1, accuracy Grade B.

III-5.3 Friction Error

Friction error shall be tested in accordance with para. 6.2.4.1. The friction error shall not exceed ½% of span for ranges above 0/60 lb/in.²; for ranges 0/60 lb/in.² and below, the friction error shall not exceed 1% of span.

III-5.4 Repeatability

Repeatability shall be tested in accordance with para. 6.2.4.2. Repeatability requirements shall be within ±½% of span.

III-5.5 Inclination

Pressure gauges shall be pressurized so that the pointer is in a vertical position. The sample shall be positioned so that the dial faces the operator. The sample shall then be inclined 60 deg to the right, left, front, and back. The sample shall remain at each of these inclined positions for at least 1 min. Maximum deviation of the indication shall be within half of the specified accuracy except for ranges 0/100 psi and below, which shall be within twice the specified accuracy.

III-5.6 Temperature

III-5.6.1 High Temperature Error. High temperature error shall be tested in accordance with para. I-2.2 except for the manufacturers recommended high temperature; high temperature shall be 145°F for all testing. At the conclusion of the test, accuracy shall be in accordance with Table 1, accuracy Grade 1A.

III-5.6.2 Low Temperature Error. Low temperature error shall be tested in accordance with para. I-2.3 except for the manufacturer's recommended low temperature. Low temperature shall be 40°F for all testing. At the

conclusion of the test, accuracy shall be in accordance with para. III-5.2.

III-5.7 Shock

Pressure gauges shall be subjected to a shock test in accordance with MIL-S-901, Grade A, Class I, except for duplex pressure gauges, which shall be Grade B. All pressure gauges shall be subjected to nine blows. Flush- and surface-mounted pressure gauges shall be mounted on a 6D-1 adapter plate except the plate shall be $\frac{1}{4}$ in., in thickness to simulate the more rigid instrument boards installed in submarines. Stem-mounted pressure gauges (i.e., 2 in. and $2\frac{1}{2}$ in., dial size) shall be mounted on a 4C-2 adapter plate. The pressure gauge shall be mounted not less than 3 in. from the sides or rear of the adapter plate. For each classification of flush-/surface-mounted pressure gauge samples submitted, one pressure gauge sample shall be secured to the adapter plate in a flush-mounted configuration and the other pressure gauge sample in a surface-mounted configuration. Throughout this test, the pressure gauge(s) shall be pressurized to mid-span.

III-5.7.1 Requirements for Ranges 0/60 lb/in.² and Above. The pressure gauge shall show no evidence of improper operation, failure, or damage. A shift in the pointer indication shall not exceed 5 times the specified accuracy. The red index shall not shift during the shock test. The accuracy, after a zero adjustment is made, shall meet the requirements of para. III-5.2.

III-5.7.2 Requirements for Ranges 0/30 lb/in.² and Below. The pressure gauge shall show no evidence of improper operation, failure, or damage. A shift in the pointer indication shall not exceed $\pm 25\%$ of span. The red index shall not shift during the shock test. The accuracy after a zero adjustment is made shall meet the requirements of para. III-5.2.

III-5.8 Salt Spray

Pressure gauges shall be subjected to salt spray tests in accordance with ASTM B117. The test(s) shall have a duration of 96 hr. The pressure connection shall be sealed to prevent penetration into the elastic element. The pressure gauge shall show no evidence of visible corrosion or other damage, or exhibit improper operation. Accuracy shall be in accordance with para. III-5.2.

III-5.9 Load

The load test shall only be performed on stem-mounted pressure gauges. The pressure gauge shall be threaded into a plate and securely held in place. A constant load of 150 lb shall be applied to the pressure gauge case as shown on Fig. III-4 for 5 min. At the conclusion of the test, accuracy shall be in accordance with para. III-5.2.

III-5.10 Vibration

Flush- and surface-mounted gauges shall be vibration tested in accordance with para. I-2.5. Stem-mounted gauges shall be tested in accordance with Table III-11. The red index pointer shall not shift during the test. Total pointer oscillation shall not exceed $\pm 5\%$ of span ($\pm 10\%$ of span for ranges 0/100 lb/in.² and below), peak-to-peak, at any test frequency. At the conclusion of the test, accuracy shall be in accordance with para. III-5.2.

III-5.11 Pressure Cycling

Testing shall be in accordance with para. I-2.4. Fatigue error shall not exceed 3 times the specified accuracy. No leakage is permitted.

The pressure cycling test shall be performed using a pressure cyler that shall subject the pressure gauge to the following criteria:

(a) A cycle from $20\% \pm 4\%$ to $80\% \pm 4\%$ of span for pressure ranges 0/3,000 lb/in.² and below. A cycle from $40\% \pm 4\%$ to $60\% \pm 4\%$ of span for pressure ranges 0/5,000 lb/in.² and above.

(b) Unless otherwise specified, within a frequency of 0.5 Hz through 1.5 Hz when cycling only gauge pressure (no vacuum portion).

(c) A total of 260,000 cycles for pressure ranges 0/3,000 lb/in.² and below and a total of 50,000 cycles for pressure ranges 0/5,000 lb/in.² and above.

(d) The application and release of pressure shall be as smooth as practicable, so as not to subject the pressure gauge pressure element assembly and movement to excessive upscale or downscale accelerations or high amplitude impulse (pressure spikes).

(e) Suitable fluid shall be used to cycle pressure gauges with ranges greater than 0/200 lb/in.²

A reference measurement shall be performed after the conclusion of the test. The pressure gauge shall show no evidence of improper operation, failure, or damage. A reference measurement shall be within ± 3 times the specified accuracy but not more than 6% of span.

III-5.12 Elastic Element or Joining Means Failure

Nonsolid front gauges with ranges 0/60 lb/in.² and above shall be subjected to the internal explosion test as specified in UL 404 for each unique case design. The pressure relief device shall successfully relieve the pressure from the case without causing a failure in either the case or the window.

III-5.13 Case Pressure Relief

The case pressure relief test shall be performed in accordance with para. I-2.7.2.

III-5.14 Pressure Integrity¹

The pressure gauge shall be pressurized to the maximum scale value and sealed for 5 min and a reference

¹ Some of the text was taken from MIL-G-18997E, paras. 4.4.4 and 3.4.4 and Table XVIII.

Fig. III-4 Load Test

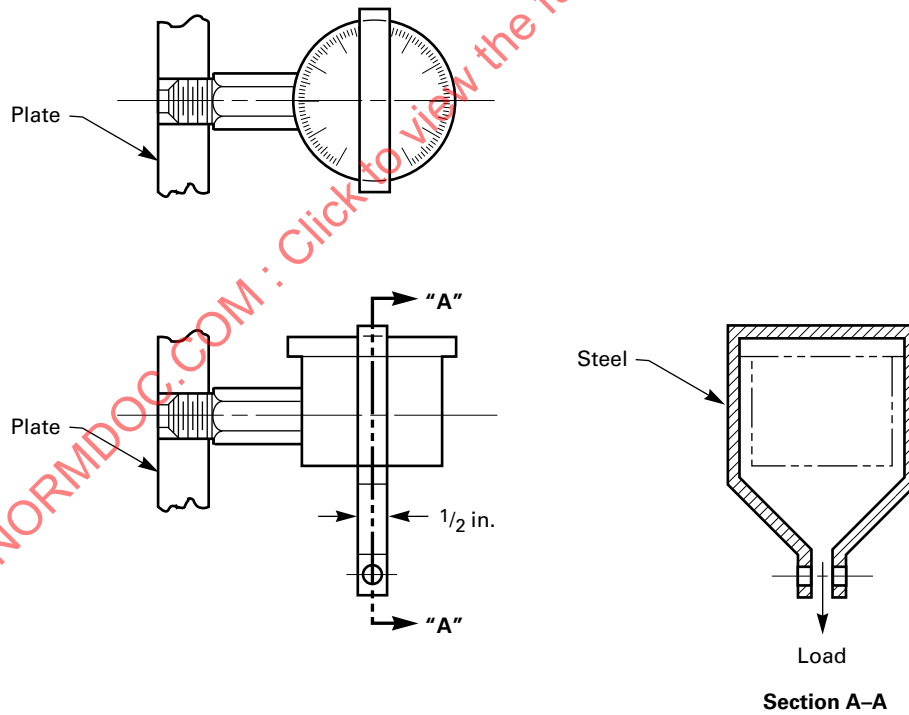
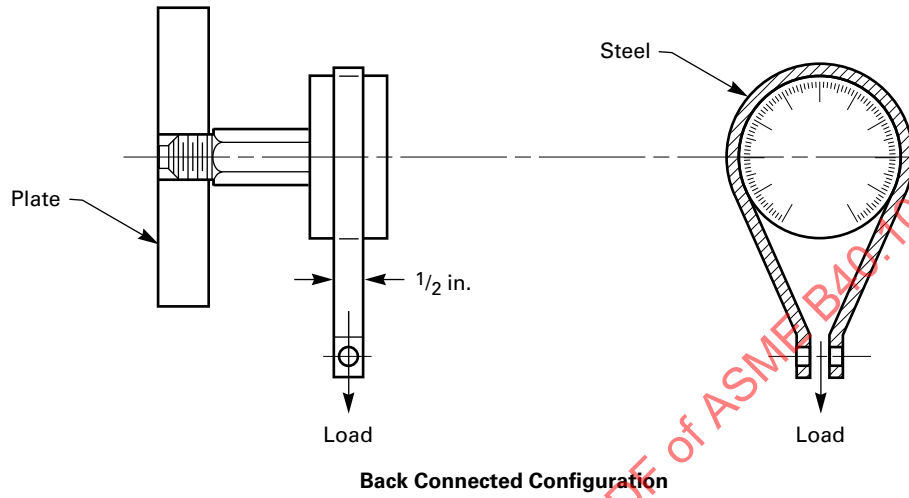


Table III-11 Stem-Mounted Gauge Vibration

Frequency Range, Hz (Inclusive)	Table Displacement, in. (Peak-to-Peak)	
	Exploratory Test	Variable Frequency Test
5 to 20	0.0200 ± 0.0040	0.060 ± 0.012
21 to 50	0.0100 ± 0.0020	0.040 ± 0.008
51 to 100	0.0050 ± 0.0010	0.020 ± 0.004
101 to 200	0.0010 ± 0.0002	0.004 ± 0.001

Table III-12 Conditions for Pressure Integrity Testing

Range	Test Pressure
All ranges	Under pressure to equivalent of 1 bar (29 in. Hg) vacuum
Up to and including 1,500 psi (103.41 bar)	1.50 times maximum scale value
Above 1,500 psi (103.41 bar) up to and including 5,000 psi (344.74 bar)	1.15 times maximum scale value
Above 5,000 psi (344.74 bar)	Maximum scale value

measurement shall then be performed. The pressure gauge pressure element assembly shall show no evidence of leakage, and there shall be no downscale shift in the pointer position.

Accuracy and friction error shall meet the requirements of para. III-5.2. If the pressure gauge meets the requirements specified, the gauge shall then be subjected to each of the applicable test conditions specified in Table III-12² for 1 hr. A reference measurement shall be performed after each applicable test condition, specified in Table III-12. The pressure gauge shall be exposed to the pressure conditions without damage or a change in accuracy exceeding that specified in para. III-5.2.

III-6 ORDERING PARAMETERS

III-6.1 Acquisition Requirements

When specifying a gauge for acquisition, the following shall be provided:

- title, number, and date of this supplement
- Part Identifying Number (PIN)
- when qualification is required
- special dial marking, when required
- National Stock Number (NSN), if available
- special dial color, when required

III-6.2 Part Identifying Number (PIN) Parameters

Hardened pressure gauges are classified according to the following variables:

- design

- dial size and case design
- elastic element style
- dial color
- pressure connection and connection location
- liquid fill case fluid and cleanliness
- dial range

III-6.2.1 Part Identifying Number (PIN) Format. The PIN to be used for items acquired to this supplement are created as shown in Table III-13.

III-6.2.2 Design. Pressure gauge design is designated by one of the following symbols:

Pressure Gauge Design	Symbol
Simplex	S
Caisson	K
Oxygen	X
Duplex	D

III-6.2.3 Dial Size and Case Design. The dial size and case design is designated by one of the following symbols:

Size	Case Design	Symbol
2	Stem mounted	1
2½	Stem mounted	2
3½	Flush/surface mounted	3
4½	Flush/surface mounted	4
8½	Flush/surface mounted	8

III-6.2.4 Elastic Element. The elastic element is designated as shown below.

Elastic Element Style	Symbol
C-type Bourdon tube	C
Helical (also helical-spiral) Bourdon tube	D
C-type, or helical — manufacturer option	N

III-6.2.5 Dial Color. The color of the dial is designated by one of the following symbols:

Dial Color	Symbol
Black background dial with white graduations and markings	B
White background dial with black graduations and markings	W
Special	S

² Table III-12 was taken from MIL-G-18997E, Table XVIII.

Table III-13 Part Identifying Number (PIN)

B40.1 C1	C	1	C	W	RA	NG	3P
Precedes classification (Appendix C to B40.1)	Design	Dial Size and Case Design	Elastic element style	Dial color	Pressure connection and Connection location	Liquid fill case fluid and Cleanliness	Dial range

GENERAL NOTE: Example B40.1 C1-C1CWRANG3P.

III-6.2.6 Pressure Connection and Connection Location. The type of pressure connection and its location for connection is designated by two symbols as provided below. The first symbol designates the type of connection fitting. The second symbol designates the location of the pressure connection.

Pressure Connection	Symbol
O-ring union	R
¼ NPT (male)	P
Welded nipple	W
Threaded vent (caisson only)	K
Flareless (bite type) 7/16 in. 20 UNF-2A	C

Connection Location	Symbol
Back	A
Bottom	O
5 o'clock	C

III-6.2.7 Liquid Fill Case Fluid and Cleanliness. Liquid fill applies to stem-mounted gauges only. The option for the pressure gauge case containing a liquid fill and the cleanliness is designated by the two symbols as provided below. The first symbol designates whether a fill fluid is required. The second symbol designates the cleanliness.

Liquid Fill (stem mount only)	Symbol
None	N
Glycerine	G

Cleanliness	Symbol
General	G
Oxygen	X

III-6.2.8 Ranges. The range is designated by a sequence of symbols (see para. III-2.2). Special ranges are permissible. The range designator shall be constructed in accordance with the formats as shown in Tables III-1 through III-4.

III-7 OXYGEN PRESSURE GAUGES

III-7.1 Case

Stem-mounted cases are not permitted. Joints shall be welded for all ranges.

Table III-14 Oxygen Service Ranges

Ranges, lb/in. ²	Range Designator
0/100	1hX
0/3,000	3kX
0/5,000	5kX

III-7.2 Dial

Dial markings shall include the words "OXYGEN CLEAN — USE NO OIL" in red printing, when oxygen application designated.

III-7.3 Pressure Connection

Pressure connection shall be a Monel (per ASTM B 127, B 164, and B 564) pipe nipple, ¼ in., nominal pipe size (NPS) with 0.109 in., minimum wall thickness, 6 in., long, welded to the socket. Connection location shall be at the lower back or bottom of the case.

III-7.4 Ranges

Table III-14 shows the ranges and range designators for oxygen gauges.

III-7.5 Internal Dimensions

Pressure gauges designated for oxygen service shall have a minimum internal dimensions throughout the pressure element assembly of not less than 0.025 in. to promote cleaning.

III-7.6 Liquid-Filled Gauges

Liquid-filled gauges shall not be used on oxygen systems, and shall have a warning label on the rear of the case that states:

WARNING: DO NOT USE ON OXYGEN SYSTEMS — LIQUID FILLED.

III-7.7 Quality Control

Oxygen service gauges shall not be examined on a sampling basis. One-hundred percent (100%) of all oxygen service gauges shall be examined for cleanliness, marking, and packaging.

III-7.8 Cleaning

Cleaning for oxygen service gauges shall be per MIL-STD-1330.

III-7.9 Qualification and Conformance Inspection

Qualification and conformance inspections shall be performed in accordance with para. III-4.2.

III-8 REFERENCED DOCUMENTS

The following is a list of publications referenced in this Mandatory Appendix.

ASME B1.20.1, Pipe Threads, General Purpose (Inch)

Publisher: The American Society of Mechanical Engineers (ASME), Two Park Avenue, New York, NY 10016; Order Department: 22 Law Drive, P.O. Box 2900, Fairfield, NJ 07007-2900 (www.asme.org)

ASTM A167, Specification for Stainless and Heat-Resisting Chromium-Nickel Steel Plate Sheet, and Strip

ASTM A473, Specification for Stainless and Heat-Resisting Steel Forgings

ASTM B26, Specification for Aluminum-Alloy Sand Castings

ASTM B85, Specification for Aluminum-Alloy Die Castings

ASTM B117, Practice for Operating Salt Spray (Fog) Apparatus

ASTM B127, Specification for Nickel-Copper Alloy (UNS N04400) Plate, Sheet, and Strip

ASTM B164, Specification for Nickel-Copper Alloy Rod, Bar, and Wire

ASTM B209, Specification for Aluminum and Aluminum-Alloy Sheet and Plate

ASTM B564, Specification for Nickel Alloy Forgings

ASTM D788, Classification System for Poly (Methyl Methacrylate) (PMMA) Molding and Extrusion Compounds

ASTM D3951, Practice for Commercial Packaging

Publisher: American Society for Testing and Materials (ASTM International), 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959 (www.astm.org)

FED-STD-595, Standard Practice for Precision Cleaning and Testing of Shipboard Oxygen, Helium, Helium-Oxygen, Nitrogen, and Hydrogen System

MIL-S-901, Shock Tests, High Impact, Shipboard Machinery, Equipment and Systems Requirements

MIL-STD-1330, Standard Practice for Precision Cleaning and Testing of Shipboard Oxygen, Helium, Helium-Oxygen, Nitrogen and Hydrogen Systems

Publisher: Federal specifications available from: Superintendent of Documents, U.S. Government Printing Office (GPO), 732 N. Capitol Street, NW, Washington, DC 20401 (www.gpoaccess.gov/index.html)

SAE AMS 7259, Rings, Sealings, Fluorocarbon (FKM) Rubber High-Temperature-Fluid Resistant Very-Low Compression Set 85 to 95

SAE J 1926, Connections for General Use and Fluid Power — Ports and Stud Ends with ISO 725 Threads and O-Ring Sealing — Part 1: Threaded Port with O-Ring Seal in Truncated Housing

Publisher: Society of Automotive Engineers (SAE International), 400 Commonwealth Drive, Warrendale, PA 15096 (www.sae.org)

UL 404, Underwriters Laboratory Standard for Safety Gauges, Indicating Pressure, for Compressed Gas Service

Publisher: Underwriters Laboratories, Inc. (UL), 333 Pfingsten Road, Northbrook, IL 60062-2096 (www.ul.com)

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DIAPHRAGM SEALS

1 SCOPE

This Standard (B40.2) is confined to mechanical separators utilizing diaphragms or bladders together with a fill fluid to transmit pressure from the medium to the pressure element assembly of pressure gauges or other pressure measuring instruments such as transducers, transmitters, and switches.

It does not include diaphragm actuated pressure instruments that employ mechanical linkages to transmit the applied pressure or other separation devices designed to protect the pressure element assembly.

2 DIAPHRAGM SEAL

2.1 Terminology and Definitions

accuracy: the conformity of an instrument's performance to an accepted standard or true value [see para. 2.10.4.2(a)].

capsule: an all-welded diaphragm assembly that threads into the upper housing (see Fig. 3).

chemical seal: see *diaphragm seal*.

coefficient of thermal expansion: volumetric change per unit of volume per unit of temperature change [see paras. 2.5.2.5 and 2.5.1.1(a)].

cold flow: a physical change in the shape of a part at room temperature due to applied forces (see para. 2.4.3).

compressibility: the property of a substance capable of being reduced in volume by application of pressure [see paras. 2.5.2.10 and 2.5.1.1(f)].

connection: see *mounting*.

connection, butt welded: the lower housing is butt welded directly to the process line [see para. 2.3.10.3(c)].

connection, fill/bleed: a connection in the upper housing used for filling the seal or bleeding excess fill fluid (see para. 2.3.8).

connection, flanged: a process connection using a flange (see para. 2.3.10.2).

connection, flanged pressure class: common pipe flange pressure classes that conform to pressure/temperature ratings per ASME B16.5 (see para. 2.3.14).

connection, flushing: a connection that permits the user to purge the volume below the diaphragm without removing the entire seal from the process line (see para. 2.3.11).

connection, instrument: a pressure connection in the upper housing to which the pressure instrument is attached (see para. 2.3.9).

connection, saddle: the lower housing is fillet welded within a hole cut in the process line or may be secured by a saddle adapter welded onto the process line [see paras. 2.3.10.3(e) and (f)].

connection sleeve: a type of in-line (flow through) connection [see para. 2.3.10.3(f)].

connection, socket welded: a lower housing socket welded directly to the process line [see para. 2.3.10.3(d)].

connection, threaded: the lower housing is connected to the process line using a threaded connection (see para. 2.3.10.1).

continuous duty: see *upper housing, continuous duty*.

continuous seal: see *upper housing, continuous seal*.

diaphragm: the flexible component that separates the medium from the fill fluid (see para. 2.3.1).

diaphragm seal: a diaphragm seal is a mechanical separator using a diaphragm or bladder together with a fill fluid to transmit pressure from the medium to the pressure element assembly. Other term used are chemical seal and gage isolator. This device is intended to keep the medium out of the pressure element assembly. The purpose of this device is to prevent damage from corrosion or clogging, to maintain sanitary requirements of the medium or to reduce the process temperature to which the pressure element assembly is exposed.

fill fluid: the liquid used to fill that portion of the pressure-sensing system between the diaphragm and the pressure-sensing element (see para. 2.5.1).

freeze point: the temperature at which a liquid and a solid may be in equilibrium [see para. 2.5.1.1(g)].

flow through: see *in-line*.

gage isolator: a seal consisting of an elastomeric bladder installed within the connection of a pressure instrument or in an adapter fitting (see para. 2.3.13).

gasket: a means used to seal joints exposed to the medium or fill fluid (see para. 2.3.5).

head effect: a change of an instrument's indication or output when the elevation of the instrument is above or below the seal (see para. 2.5.2.7).

in-line: a diaphragm seal installed directly in the process flow line (see para. 2.3.10.3).

long term stability (closed system): the resistance to decomposition, physical disintegration, or other chemical change over a long period of time [see paras. 2.5.2.4 and 2.5.1.1(j)].

lower housing: the component connected to the process line and wetted by the process fluid (see para. 2.3.3).

medium: the process fluid (gas or liquid).

mid-housing (cleanout ring): the component located between the upper and lower housing (see para. 2.3.4).

pressure rating: the maximum operating pressure (see para. 2.3.14).

process connection: a method for attaching or installing a diaphragm seal to a process line, tank, vessel, etc. (see para. 2.3.10).

reinforcing rings: rings that support clamping forces on nonmetallic lower housings (see para. 2.3.6).

sanitary seal: a quick disconnect type, where the upper and lower housings are held together by a unique clamp, permitting ease of dismantling and cleaning (see para. 2.3.12).

service temperature range: the high and low temperatures between which the fill fluid will remain serviceable [see para. 2.5.1.1(b)].

specific gravity: the ratio of a fluid's density to the density of water at 4°C (39.2°F) [see paras. 2.5.2.7 and 2.5.1.1(c)].

spontaneous ignition temperature: the temperature at which ignition can occur resulting from the generation of heat that cannot be readily dissipated [see para. 2.5.1.1(i)].

temperature, ambient: the temperature of the atmosphere surrounding the instrument/seal assembly (see para. 2.5.2.5).

temperature, process: the temperature of the medium at the pressure connection of the lower housing (see para. 2.5.2.5).

temperature, storage: the extremes of temperature (high and low) that the instrument/seal will be exposed to when not pressurized (see para. 2.5.2.6).

thermal decomposition point: the temperature at which changes in the chemical or physical characteristics of a material are initiated [see para. 2.5.1.1(h)].

upper housing: the component that includes a connection for the pressure instrument (see para. 2.3.2).

upper housing, continuous duty: an upper housing that prevents damage to the diaphragm or leaking of the process fluid should the pressure instrument leak or be removed (see para. 2.3.2.1).

upper housing, continuous seal: an upper housing that prevents leaking of the process medium should the pressure instrument leak or be removed, however, the diaphragm may be damaged (see para. 2.3.2.2).

upper housing, noncontinuous duty: an upper housing that does not prevent damage to the diaphragm or leaking of the process fluid should the pressure instrument leak or be removed (see para. 2.3.2.3).

upper housing, nonremovable: an upper housing that if removed from the bottom housing with the instrument installed, will result in the loss of fill fluid (see para. 2.3.2.5).

upper housing, removable: an upper housing that may be removed from the bottom housing with the instrument installed without loss of fill fluid (see para. 2.3.2.4).

vapor pressure: the pressure of the vapor in equilibrium with the liquid [see paras. 2.5.1.1(e) and 2.5.2.9].

viscosity: the resistance that a gaseous or liquid system offers to flow when it is subjected to a shear stress. Also, known as flow resistance [see paras. 2.5.2.8 and 2.5.1.1(d)].

volumetric displacement: the volume of fill fluid displaced by the movement of the diaphragm (see para. 2.6.1).

volumetric spring rate: the flexibility of the diaphragm (see para. 2.6.1).

wetted surface: the portions of the diaphragm seal that are exposed to the medium.

2.2 Mounting of Diaphragm Seals

The physical or "flow properties" of the medium such as listed below may determine the method of attaching or installing the diaphragm seal:

- (a) the physical characteristics, i.e., a gas or liquid
- (b) the percentage of solids
- (c) the melting and freezing point
- (d) the effect of changes in process or ambient temperatures on the viscosity
- (e) the maximum and minimum temperatures
- (f) the maximum and minimum process pressure
- (g) the need to provide the capability to clean the process piping

2.2.1 Threaded Connection. The most common method for attaching or installing a diaphragm seal to a process line, tank, or vessel is with a threaded connection. Common connections are from $\frac{1}{4}$ in. 18 NPT to $1\frac{1}{2}$ in. 11.5 NPT per ASME B1.20.1. With this method of connection, process media should be either liquid, vapor, or gas, or a combination of these, but free from solids. A small percentage of solids could plug or clog the process takeoff pipe or build up in the isolator cavity on the process side of the diaphragm.

Process media should not be sufficiently viscous, or of the type that will solidify in the takeoff pipe or the lower housing of the diaphragm seal within the limits of the ambient and process temperatures.

2.2.2 Flanged Connection. A second method of attaching diaphragm seals is by a flanged connection.

The integral flange of the isolator is bolted to a companion flange in the process piping or to flange openings, as hand holes, on tanks and vessels. Common pipe sizes are from $\frac{1}{2}$ in. to 6 in. with ASME B16.5 flanges in pressure classes of 150, 300, 600, 1500, and 2500. Flanged seals may also be manufactured to other standards such as DIN.

2.2.3 In-Line Connection. A third method is to install the diaphragm seal directly in the process flow line. These are referred to as “in-line” or “flow-through” types. This diaphragm seal is so designed that the diaphragm is essentially flush with the flow stream and thus continually washed by the process media. This “in-line” type should be used when the process media is a slurry or a liquid that contains a solid component, is viscous, or has a melting or freezing point at normal ambient temperatures. This method is frequently used where process lines are externally heated. The process connections are as follows:

(a) *Threaded.* Pressure lines are connected using a threaded connection; generally NPT.

(b) *Flanged.* Process connections are connected to pressure flanges.

(c) *Butt Welded.* The diaphragm seal is butt welded directly to the process line.

(d) *Socket Welded.* The diaphragm seal is socket welded directly to the process line.

(e) *Saddle.* The diaphragm seal is fillet welded within a hole cut into the process pipe or may be secured by a saddle adapter welded onto the process pipe.

(f) *Clamped (Sanitary).* Sanitary application, such as food processing require diaphragm seals to be easily cleaned after use. Quick removable clamps may be used to connect the diaphragm seal to the process connection (lower housing). Industry standards cover specific details of these applications.

2.3 Construction

A diaphragm seal consists of several components, as described in paras. 2.3.1 through 2.3.15.

2.3.1 Diaphragm. The diaphragm is the most critical component in the assembly. It separates the medium from the fill fluid. It is designed to flex in a direction essentially perpendicular to its surface. Diaphragms are generally convoluted, because sensitivity over a wide range of pressure is greater than that of a flat diaphragm of the same diameter.

2.3.2 Upper Housing. The upper housing includes a connection for the pressure instrument. Since this component is not in contact with the process fluid, it is commonly made of steel. However, if the external atmosphere contains corrosive elements, other materials may be required. Standard instrument connections are $\frac{1}{4}$ in. 18 NPT and $\frac{1}{2}$ in. 14 NPT female.

2.3.2.1 Upper Housing, Continuous Duty. Should the pressure instrument leak or be removed, the diaphragm will seat against a matching or other support surface in the upper housing, preventing damage to the diaphragm or leaking of the medium [see Fig. 1 and para. 2.10.4.2(h)].

2.3.2.2 Upper Housing, Continuous Seal. Should the pressure instrument leak, or be removed accidentally, the diaphragm will seat against a support surface in the upper housing to prevent leakage of the medium. The diaphragm may be damaged [see para. 2.10.4.2(i)].

2.3.2.3 Upper Housing, Noncontinuous Duty. The upper housing does not contain a matching or other support surface to support the diaphragm. Leakage of the pressure instrument or removal may result in damage to the diaphragm and loss of the medium (see Fig. 2).

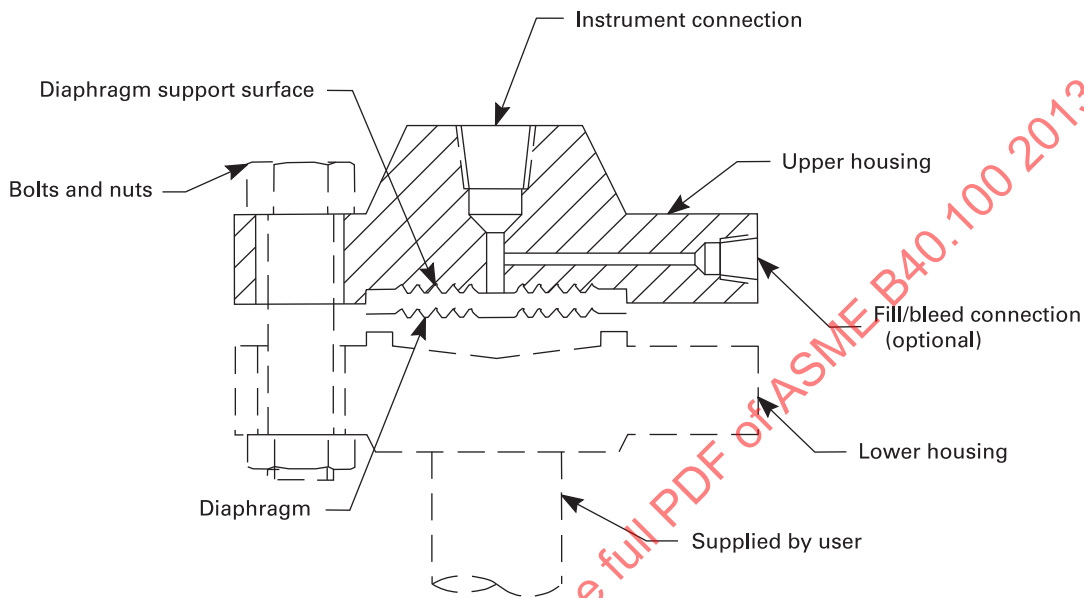
2.3.2.4 Upper Housing, Removable. The pressure instrument and top housing assembly may be removed from the bottom housing as a unit, without loss of fill fluid (this should be done only when there is no pressure in the process line). The diaphragm may be clamped to the upper housing with a middle housing, welded, bonded, or otherwise attached to the upper housing. The diaphragm may be made in the form of a capsule threaded into the upper housing (see Figs. 3 and 4).

2.3.2.5 Upper Housing, Nonremovable. When the diaphragm is clamped to the upper housing by the lower housing, removal of the pressure instrument and upper housing assembly from the lower housing will result in loss of the fill fluid (see Fig. 5).

2.3.2.6 Upper Housing, Flush Flanged. Flanged seals include a mounting flange that assists when aligning the diaphragm with the process connection. The 2 in. to 5 in. versions of this seal may be used with the diaphragm surface flush with the process or with a flushing ring. The diaphragm is an integral part of a standard flange and installed to be flush with the flange sealing face [see Fig. 6, illustration (a)].

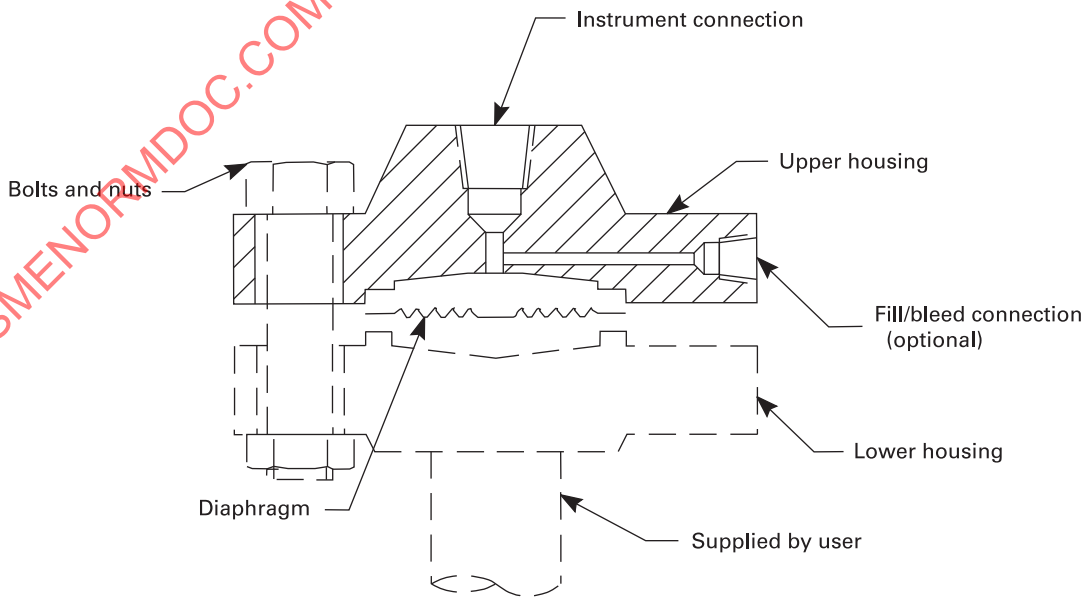
2.3.2.7 Upper Housing, Flush Flanged Seal (Sandwiched) With Backup Flange. These seals provide a basic 2 in. to 5 in. process connection. Available with or without a flushing ring, this seal has a flush or recessed diaphragm surface. The capillary connection is on the side of the seal, enabling use in areas where space is limited or restricted on the outside of the vessel. Because the flange is not a permanent part of this seal, it provides more user flexibility where flanges with different pressure ratings are required. The diaphragm housing corresponds to the size of the sealing face of a standard flange. Upon installation, the diaphragm seal is sandwiched between the process flange and a standard blind flange [see Fig. 6, illustration (b)].

Fig. 1 Upper Housing, Continuous Duty



GENERAL NOTE: Not intended to show design detail.

Fig. 2 Upper Housing, Noncontinuous Duty



GENERAL NOTE: Not intended to show design detail.

Fig. 3 Upper Housing, Removable

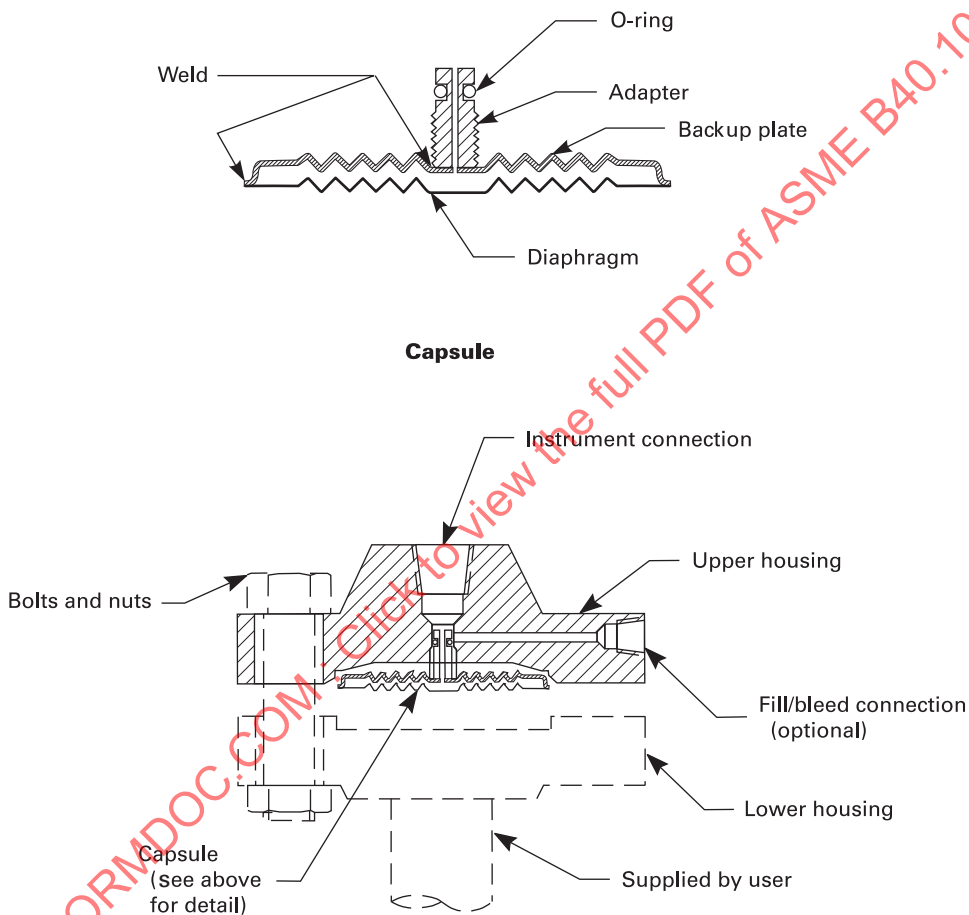
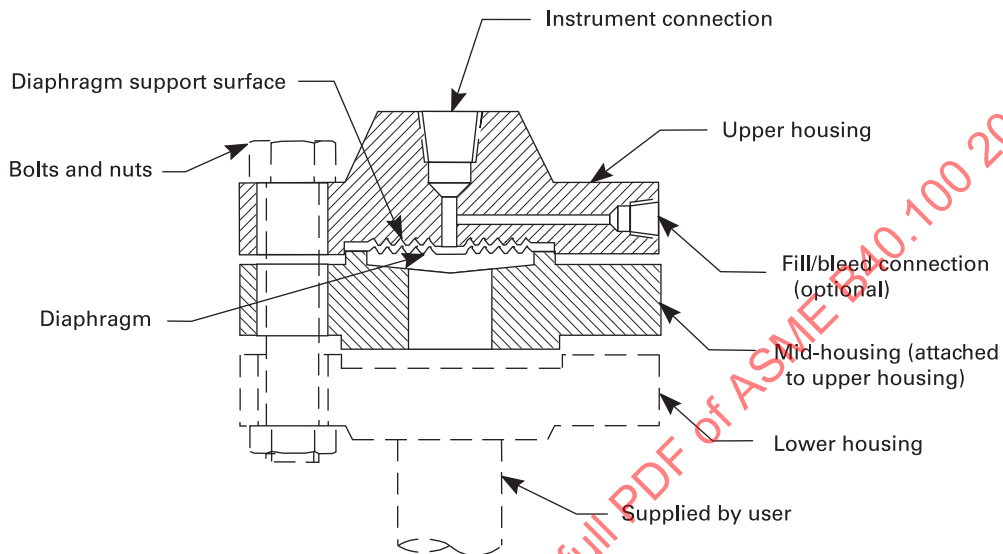
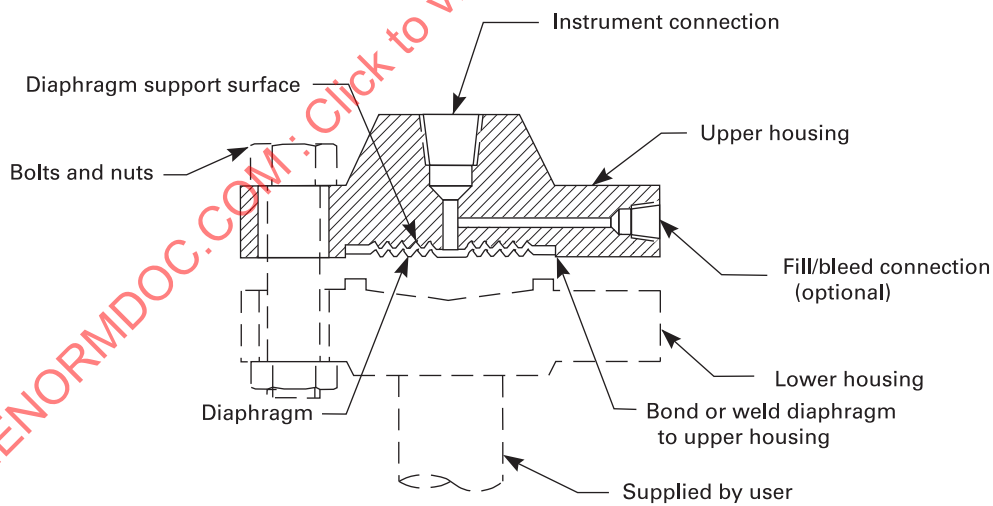


Fig. 4 Upper Housing, Removable



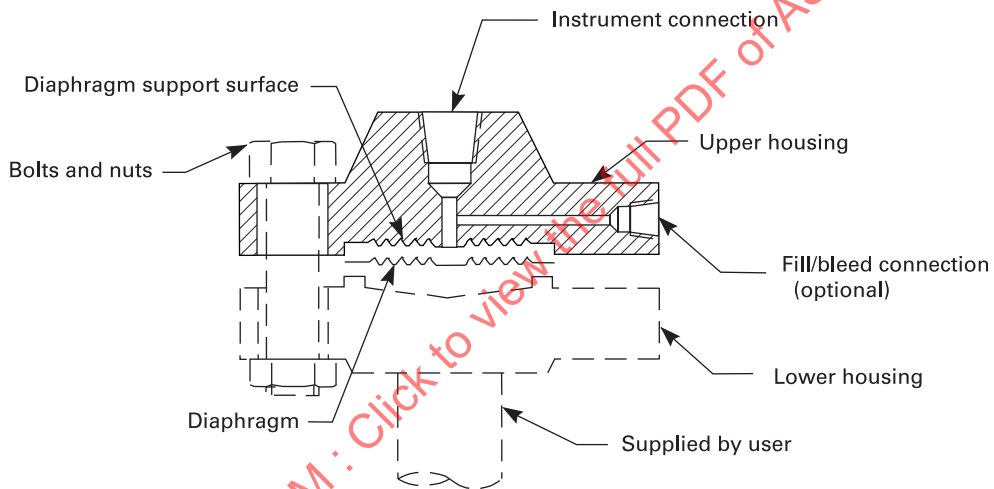
(a)



(b)

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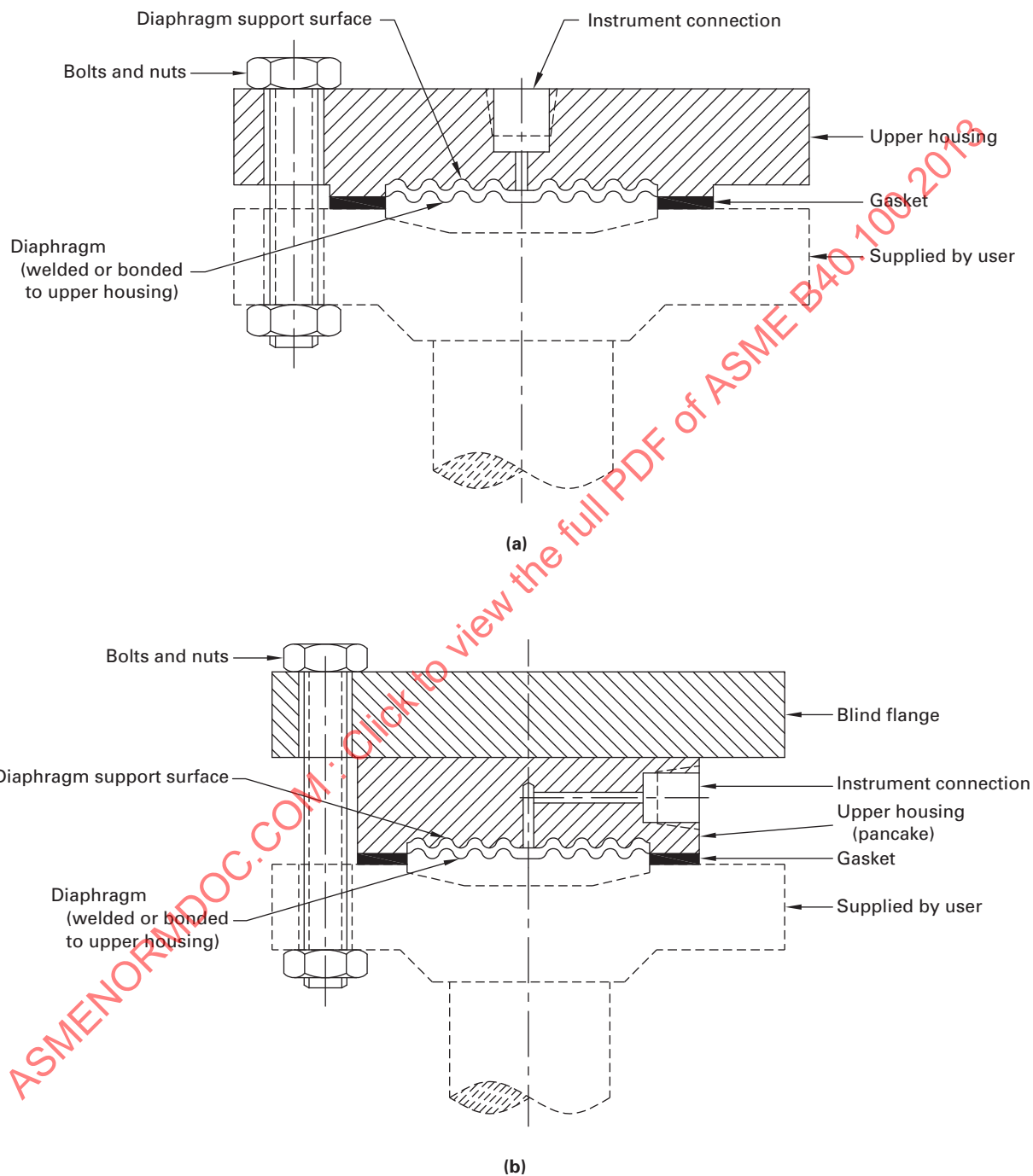
Fig. 5 Upper Housing, Nonremovable



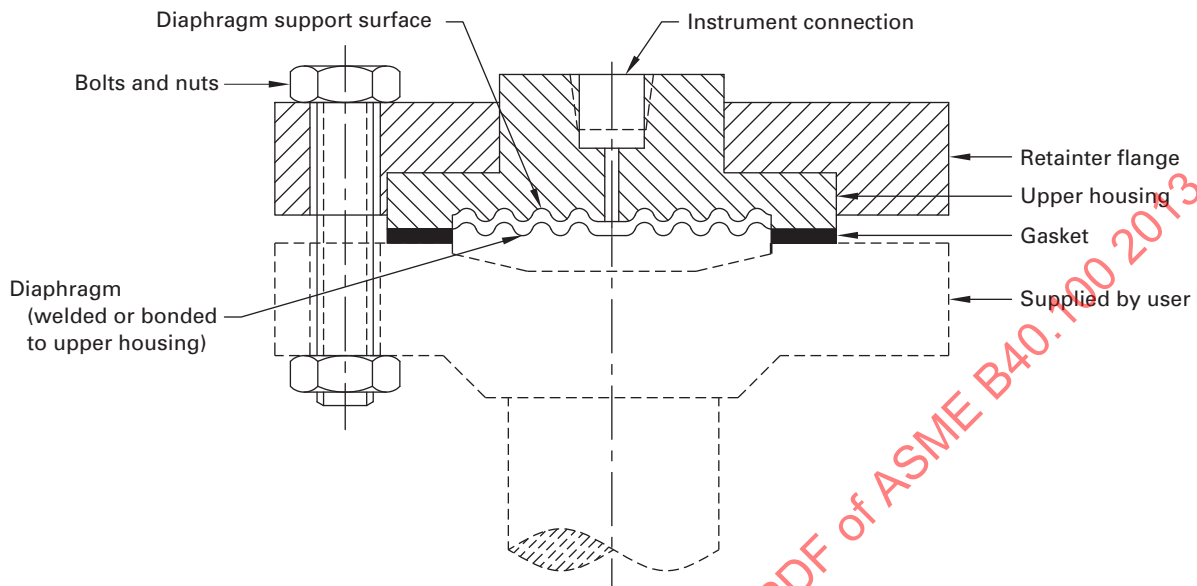
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Fig. 6 Upper Housing, Flush Flanged



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Fig. 7 Upper Housing, Inserted Flange

GENERAL NOTE: This drawing is not intended to show design detail.

2.3.2.8 Upper Housing, Inserted Flange. The upper housing with its welded diaphragm is separated from the retainer flange (see Fig. 7).

2.3.2.9 Upper Housing, Flanged Seal With Extended Diaphragm. Extended flanged seals in 2 in. to 5 in. versions are common and provide a choice of extension length. Typical extension lengths are 2 in., 4 in., 6 in., and 8 in. These seals mount on pipe flanges and extend through insulation to the tank wall (see Fig. 8).

2.3.3 Lower Housing. The lower housing connects to the process line, and is wetted by the medium. For this reason the material must be compatible with the medium. See para. 2.3.10 for process connections.

2.3.4 Mid-Housing (Cleanout Ring). The mid-housing (cleanout ring) is located between the upper and lower housing. This housing is used on diaphragm seals with replaceable diaphragms. Removal of the connection between the mid-housing and the lower housing permits access to the process side of the diaphragm without loss of the seal between the upper housing and the diaphragm. This housing is exposed to the medium and the material must be compatible with the medium. If a diaphragm capsule is used, a mid-housing may not be required [see Figs. 3 and 4, illustration (a)].

2.3.5 Gasket. A gasket or O-ring may be used to seal joints exposed to the medium. The material must be compatible with the medium. A coating on the diaphragm or housing may function as the gasket.

2.3.6 Reinforcing Rings. Some diaphragm seal designs use reinforcing rings to support clamping forces on nonmetallic lower housings. These rings are generally not in contact with the medium and are commonly made of steel. If the external atmosphere contains corrosive elements, other materials may be required [see Fig. 9, illustration (b)].

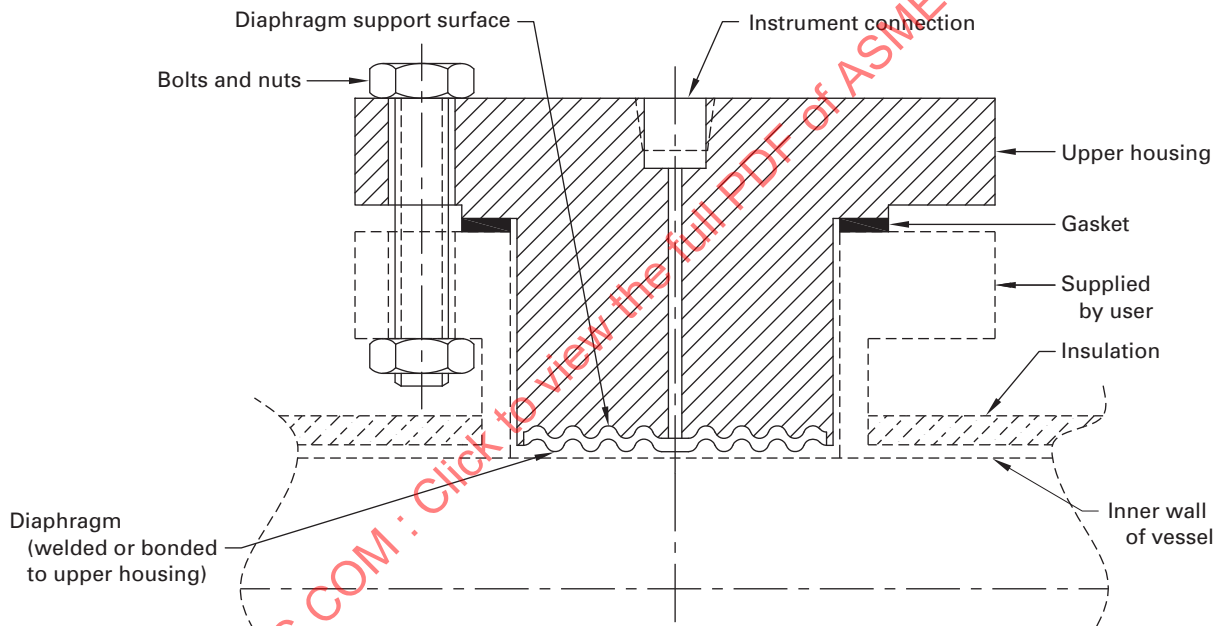
2.3.7 Fastening Methods. Several methods may be employed to fasten the upper, mid, and lower housing together.

(a) *Bolts and Nuts.* A series of bolts and nuts are used to fasten the upper housing to either the mid or lower housing. The housing may be tapped to replace the nut.

(b) *Clamp.* A clamp assembly may fasten the upper housing to the lower housing [see Fig. 10, illustration (a)].

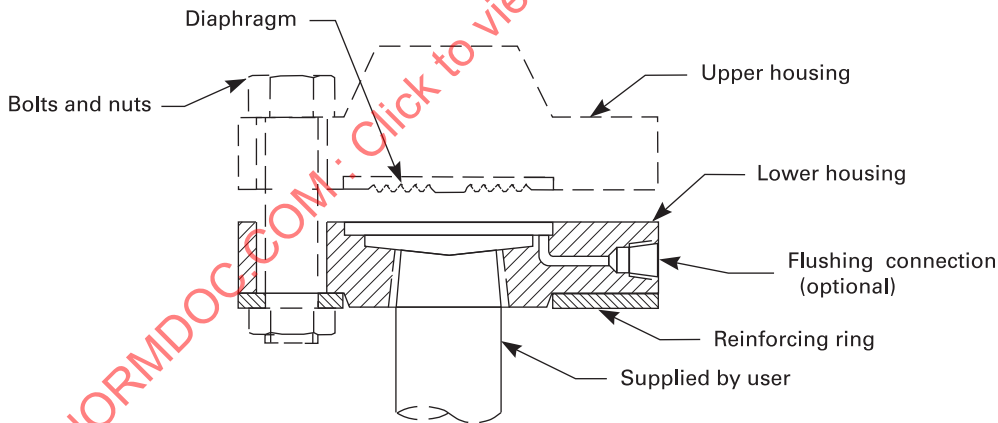
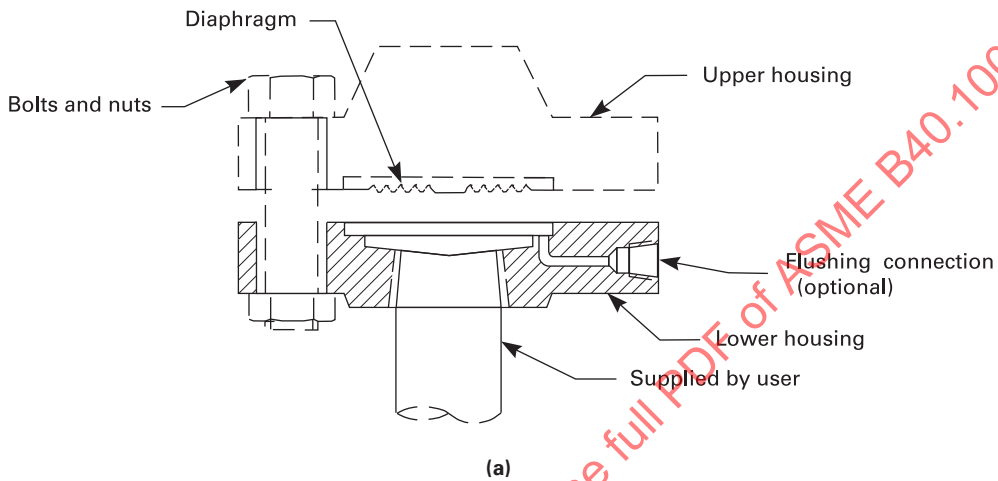
(c) *Welded.* The upper and lower housings may be joined by a weld. Weld filler material is generally identical to the material of the lower housing [see Fig. 10, illustration (b)].

Fig. 8 Upper Housing, Flanged Seal



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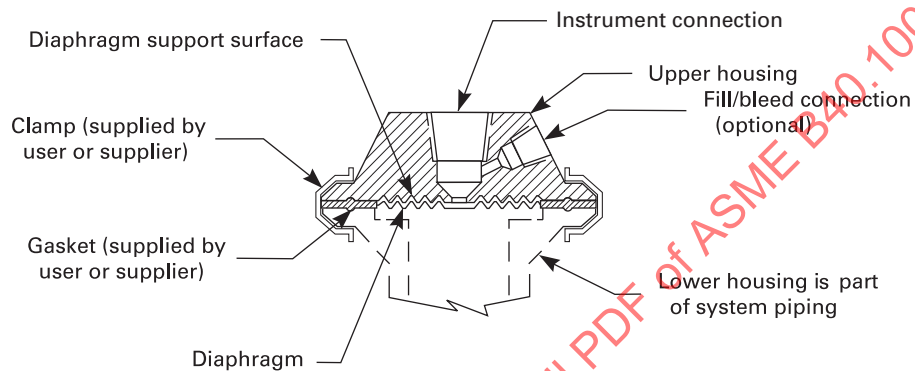
Fig. 9 Lower Housing



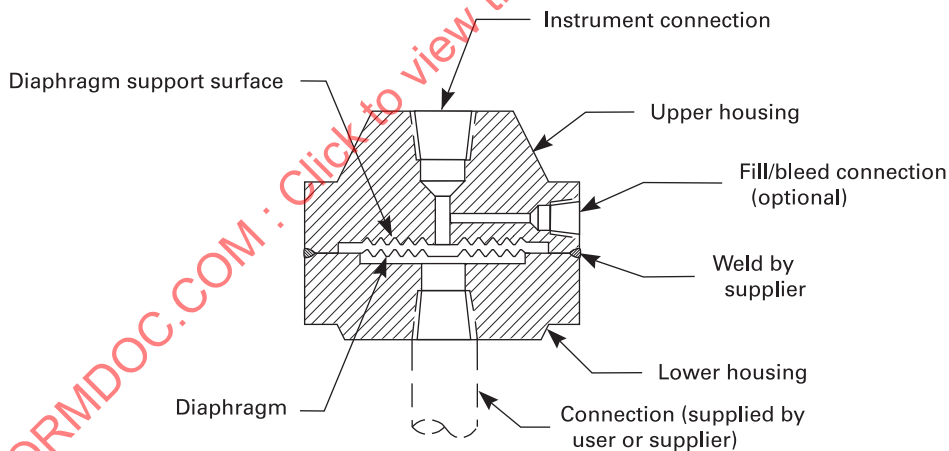
(b) With Reinforcing Ring

GENERAL NOTE: These drawings are not intended to show design detail.

Fig. 10 Fastening Methods



(a) Clamped Assembly



(b) Welded Assembly

GENERAL NOTE: These drawings are not intended to show design detail.

The fastening method is generally not in contact with the medium.

2.3.8 Fill/Bleed Connection (Optional Feature). A fill/bleed port is a connection machined integral with the upper housing, accessing the filled volume. A fill adapter may be inserted into the fill/bleed port allowing filling of the diaphragm seal/instrument assembly after assembly. After filling, the bleed screw is inserted into the fill/bleed port for sealing purposes and may be used to permit bleeding excess fill fluid (see Fig. 1).

2.3.9 Instrument Connection. The pressure instrument is attached directly to the diaphragm seal. Standard instrument connection ports are $\frac{1}{4}$ in. 18 NPT and $\frac{1}{2}$ NPT female, although other connections may be used as required.

It may be desirable, however, to install the instrument remote from the seal, for one or more of the following reasons:

- (a) to remove the instrument from an adverse environment (temperature, corrosive atmosphere, vibration, etc.)
- (b) to locate the instrument in a more convenient location for readability or serviceability (see Fig. 1)

2.3.9.1 Remote Instrument Attachment. If remote attachment is necessary, a length of capillary with suitable end fittings may be installed between the instrument and the seal. This capillary may be enclosed in a protective armor.

The following factors must be considered when remote mounting is required:

(a) The bore of the capillary must be kept to a minimum in order to reduce the effect of ambient temperature changes upon the accuracy of the instrument. If the bore is too small, however, the response time of the assembly may become unacceptably long and filling will be more difficult. A bore of approximately $\frac{1}{16}$ in. (2 mm) is suggested for most applications.

(b) The capillary material and size must be suitable for the maximum and minimum pressure and temperature of the medium and the maximum and minimum ambient temperatures.

(c) The elevation of the instrument above or below the seal will introduce a head effect on its reading or output, and will be more significant at low operating pressures.

(d) As capillary length increases, time response and temperature errors will increase.

(e) Length, size, material, and stiffness of the capillary must be such that it can be suitably installed.

(f) Capillary material, and joints between capillary and end fittings, must be compatible with expected ambient conditions, especially ambient temperatures and corrosiveness.

(g) All joints between the seal and the instrument must be leak-tight.

2.3.10 Process Connections (Lower Housing). Common process connections are described in paras. 2.3.10.1 through 2.3.10.4.

2.3.10.1 Threaded. The lower housing includes a threaded connection for attachment to the process line (see Fig. 9). A threaded lower housing may be provided with wrench flats or spanner wrench holes to facilitate assembly.

2.3.10.2 Flanged. The lower housing is designed to mate and seal with a companion ASME B16.5 flange in various sizes and pressure ratings. Flanged diaphragm seal parts may be manufactured of bar stock, castings, or forgings [see Fig. 11, illustration (a)]. In the smaller sizes, the use of studs assembled to the lower housing may be necessary because of diaphragm design considerations [see Fig. 11, illustration (b)].

2.3.10.3 In-Line (Flow-Through). In this type, the diaphragm surface is paralleled to the process flow, resulting in minimum restriction of the flow, and less tendency to build up deposits in the seal because the flow tends to wash the diaphragm continually. Connections are as follow:

- (a) threaded (see Fig. 12)
- (b) flanged [see Fig. 13]
- (c) butt weld (see Fig. 14)
- (d) socket weld (see Fig. 15)
- (e) *Saddle*
 - (1) fillet welded within a hole cut in the process line [see Fig. 16, illustration (a)]
 - (2) fillet welded onto the process line [see Fig. 16, illustration (b)]
- (f) sleeve [see Fig. 13, illustration (b)].

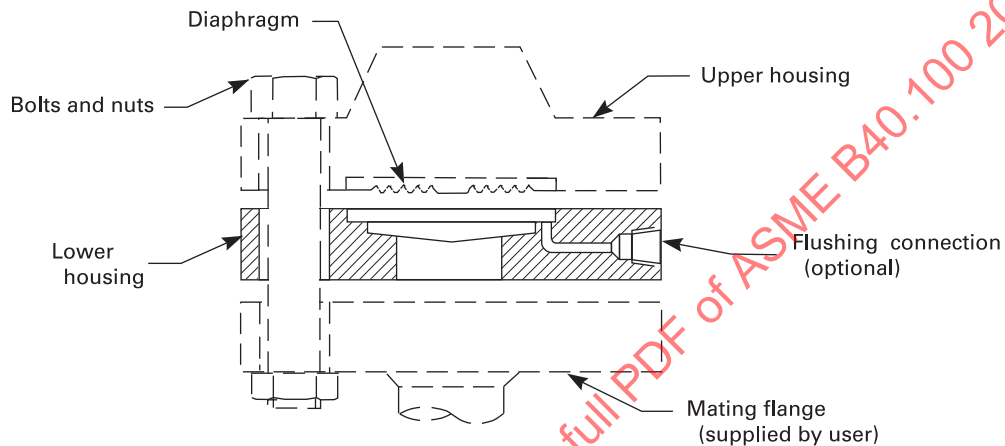
2.3.10.4 In-Line Seal (Crevice Free). This seal is suitable for rapidly flowing process fluids. The seal forms an integral part of the pipe to allow undisturbed flow of the process. The housing diameter corresponds to the size of the sealing face of a standard flange or standard clamp connection. The seal is comprised of a cylindrical jacket section (tube) in which the round diaphragm is welded (see Fig. 17).

2.3.11 Flushing Connection (Optional Feature). Threaded and flanged lower housings may be provided with a flushing connection, permitting the user to purge the area below the diaphragm without removing the seal from the process line. This connection may be located in the mid-housing, if supplied [see Fig. 9, illustration (a)].

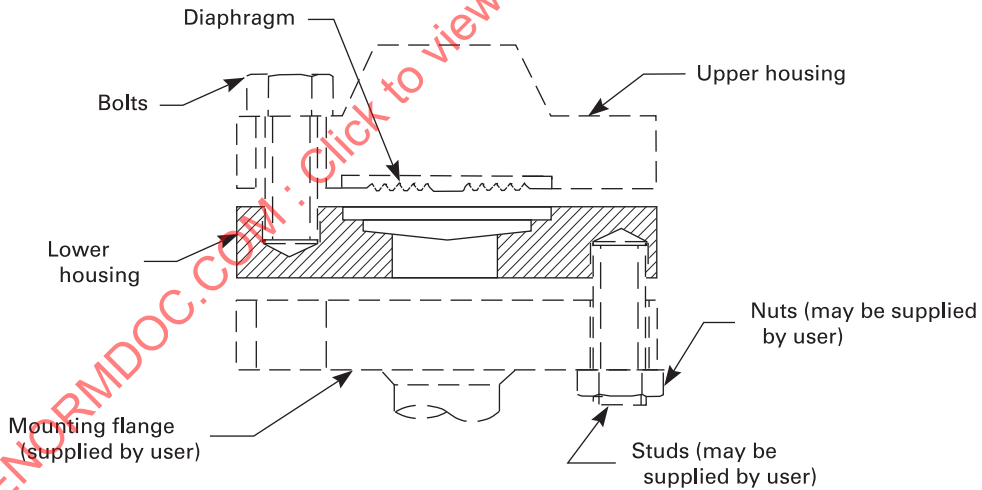
2.3.11.1 Flushing Ring. Flushing rings are commonly provided with one or two $\frac{1}{4}$ NPT or $\frac{1}{2}$ NPT connection(s). The ring facilitates purging of the process cavity. The ring is mounted between the diaphragm seal and the process flange (see Fig. 18).

2.3.12 Sanitary Seals. Sanitary seals are quick disconnect types, where the upper and lower housings are

Fig. 11 Flanged Seal



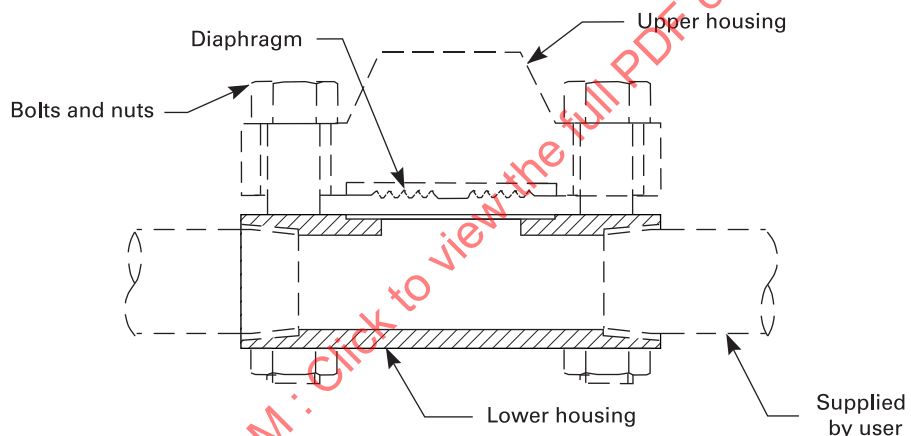
(a)



(b)

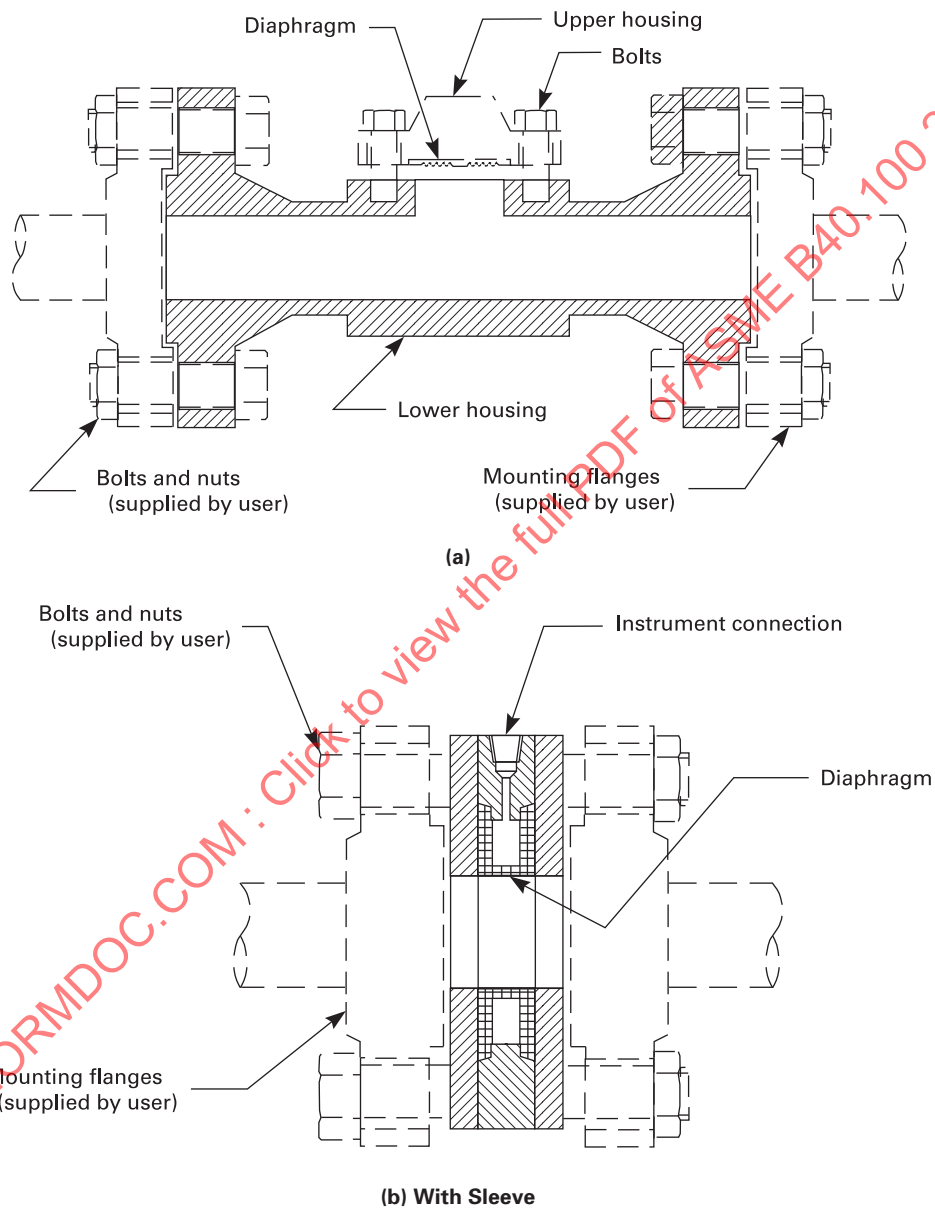
GENERAL NOTE: These drawings are not intended to show design detail.

Fig. 12 Threaded Seal



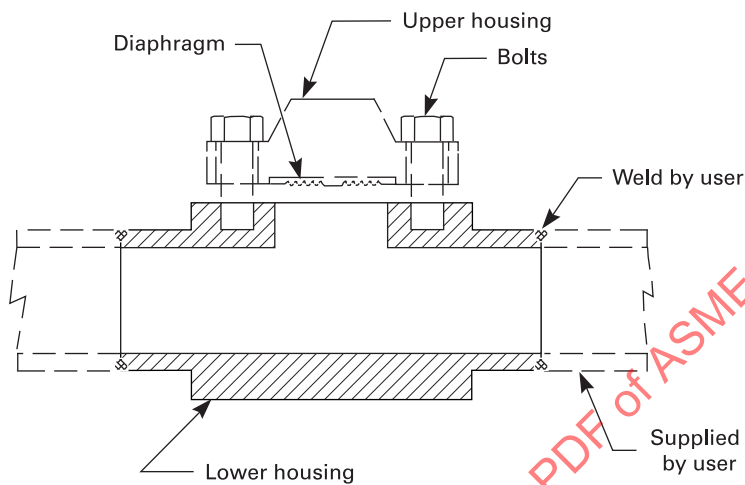
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Fig. 13 Flanged Seal With Sleeve



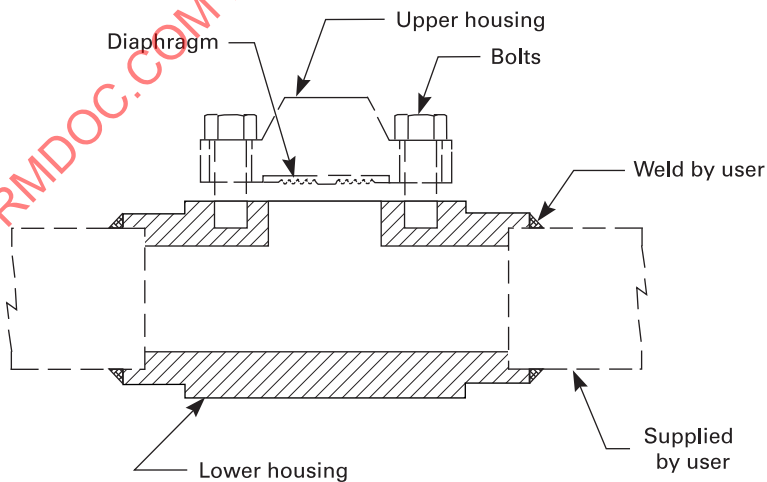
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Fig. 14 Butt Weld Seal



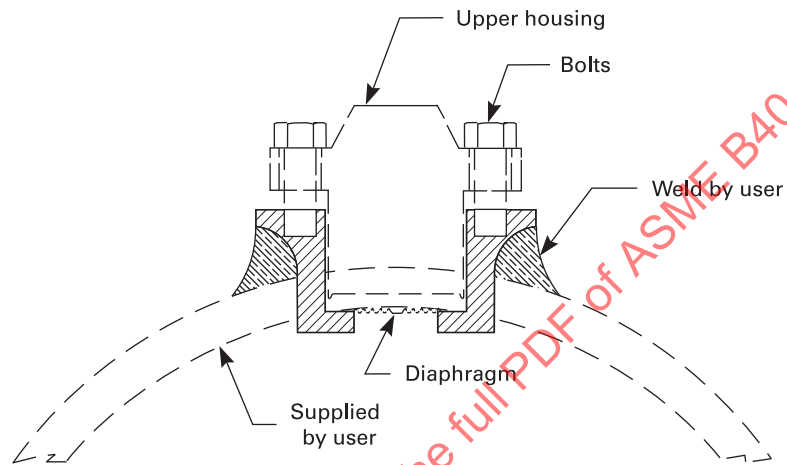
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Fig. 15 Socket Weld Seal

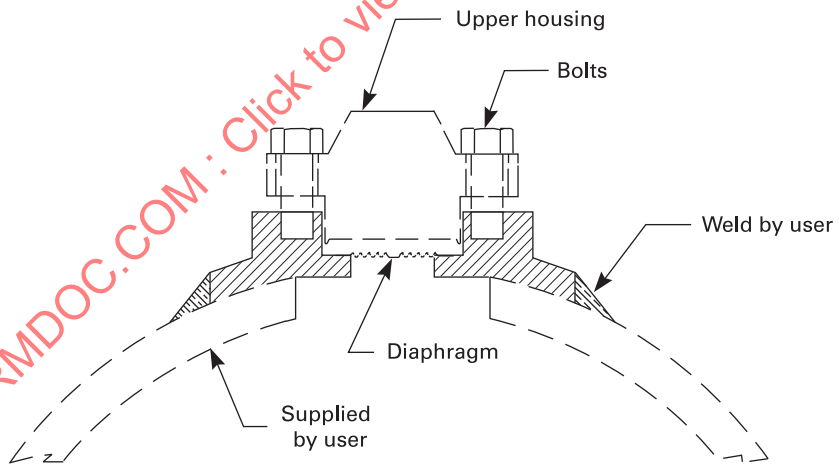


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Fig. 16 Welded Seal Saddle



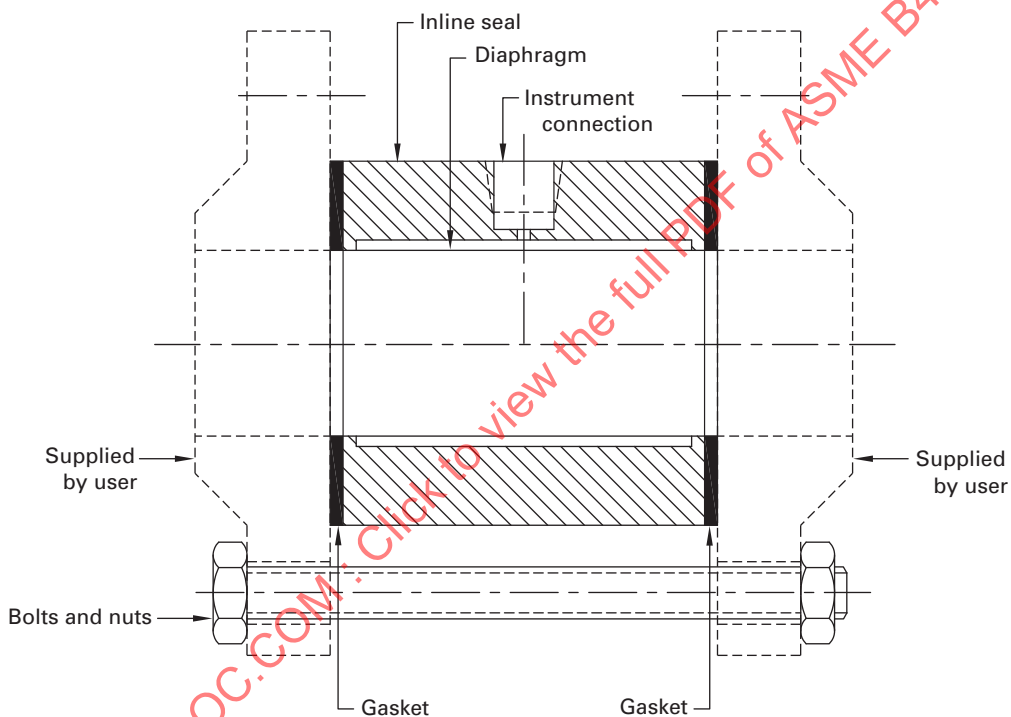
(a)



(b)

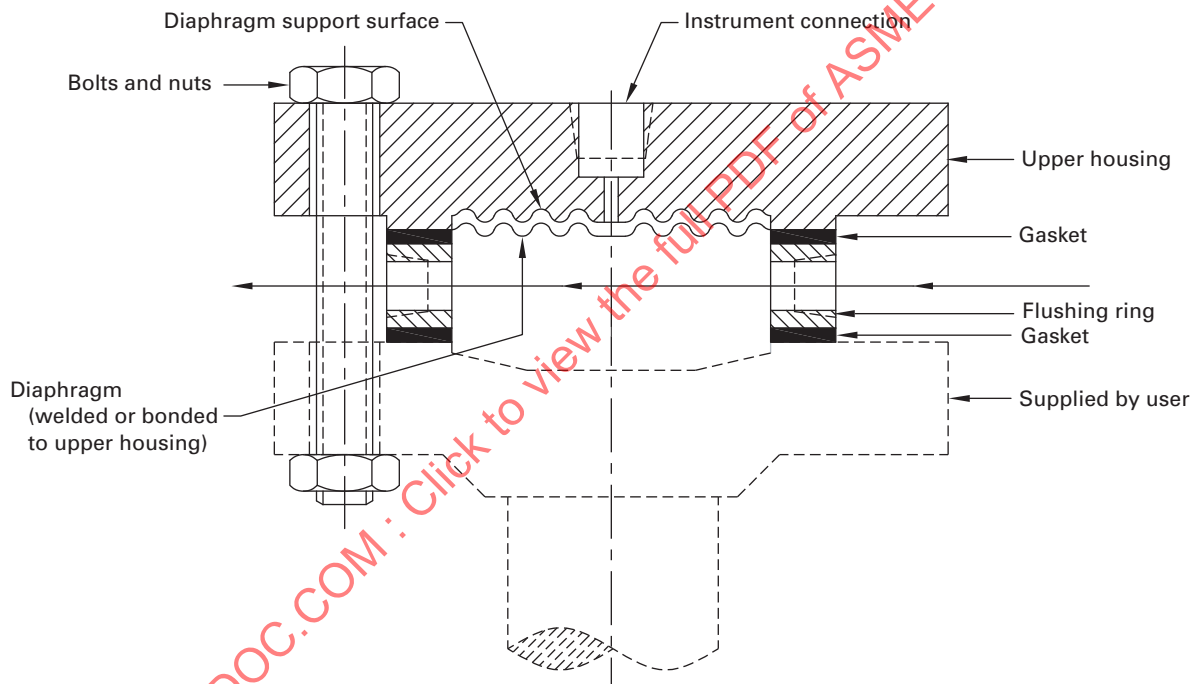
GENERAL NOTE: These drawings are not intended to show design detail.

Fig. 17 In-Line Seal (Crevice Free)



GENERAL NOTE: This drawing is not intended to show design detail.

Fig. 18 Flushing Ring



GENERAL NOTE: This drawing is not intended to show design detail.

held together by a unique clamp, permitting ease of dismantling and cleaning [see Fig. 10, illustration (b)].

2.3.13 Gauge Isolators. This type of seal consists of an elastomeric bladder installed within the connection of a pressure instrument or within an adapter fitting (see Fig. 19).

2.3.14 Pressure Ratings. Pressure ratings decrease (possibly significantly) as process or ambient temperatures increase. Suppliers provide pressure/temperature ratings for various materials and configurations of diaphragm seals.

Most metal threaded lower housing connections have a rating of 2,500 psi at 100°F (37.8°C). Ratings of flanged seals are usually determined by the ASME B16.5 flange pressure and temperature ratings. Pressure/temperature ratings of plastic components are generally lower than metal components.

2.3.15 Locking Device (Optional Feature). A device that minimizes the possibility of an instrument turning after installation on the diaphragm seal. The locking device bolts to the top housing and holds the instrument's wrench flat in a stationary position.

2.4 Material Selection

2.4.1 The materials used in fabrication of the diaphragm seal will depend upon the chemical and physical properties of the medium.

2.4.2 The majority of failures of diaphragm seals are due to the improper selection of materials for diaphragms and other surfaces exposed to the medium. In the selection of materials of construction for any medium resistance to corrosion is usually the determining factor. As a general rule, the same material used in process construction, pipe lines, tanks, etc., should be used for the surfaces exposed to the medium. Because of the thin cross section, special attention must be given to the selection of material for the diaphragm. Sometimes a material more corrosion resistant than the heavier bottom housing or associated piping should be considered. The physical characteristics of the medium, such as temperature and pressure, should also be considered. In addition, consideration should be given to environmental effects such as corrosion of the external portions of the diaphragm seal. Laboratory corrosion tests duplicating process and/or ambient conditions may be required. The user should obtain expert advice from a qualified source for selection of materials. The materials of construction in contact with the medium should be identified on the diaphragm seal.

2.4.3 Plastics such as PVC, Teflon®, etc., are used for lower and middle housings in diaphragm seals. However, there are temperature and pressure limitations to all plastics which must be strictly adhered to, or the application will fail. Because of their low tensile strength

and cold flow characteristics, plastics are usually not recommended for threaded process connections. If threaded plastic bottom housings are required, care must be taken to avoid over-tightening the process connection, which could cause failure of the housing after a period of time.

2.4.4 When using a flange-connected type, caution must be used in attaching to the companion flange. As all these materials are slightly compressible, bolts must be tightened evenly. Over-tightening may result in distortion of the plastic parts and possible failure.

2.4.5 Diaphragm materials such as Teflon®, other plastics or elastomers are sometimes used. Because of the thin sections, these materials may be porous. Consideration must be given to potentially hazardous interaction between the medium and the fluid used to fill the diaphragm seal and pressure instrument (see para. 2.5.2.2).

2.4.6 If the medium contains a hard solid, and the diaphragm seal is the flanged or flow-through type, the possibility of erosion of the thin diaphragm should be considered. Caution must be taken to select the proper diaphragm material.

2.4.7 A coating on a diaphragm should not be relied on for corrosion resistance unless specifically recommended by the supplier. Coatings may have been applied for other purposes and may have voids that allow corrosion. The permeability of the coating to the chemicals in the media must also be considered.

2.4.8 Lower or middle housings may be coated or plated to improve corrosion resistance. Caution must be taken on threaded housings as the coating or plating on the housings may be damaged during installation.

2.4.9 Fasteners that are usually highly stressed must be selected with consideration to strength, ambient temperature, and environmental effects. Stainless steel fasteners have improved corrosion resistance over carbon steel but may have lower strength. Some fastener materials may begin to lose strength at temperatures as low as 100°F (37.8°C). Combined effect of stress and corrosive ambient environments should be considered.

2.4.10 Gaskets used to seal the joints between the diaphragm, middle, and bottom housing must be resistant to the medium.

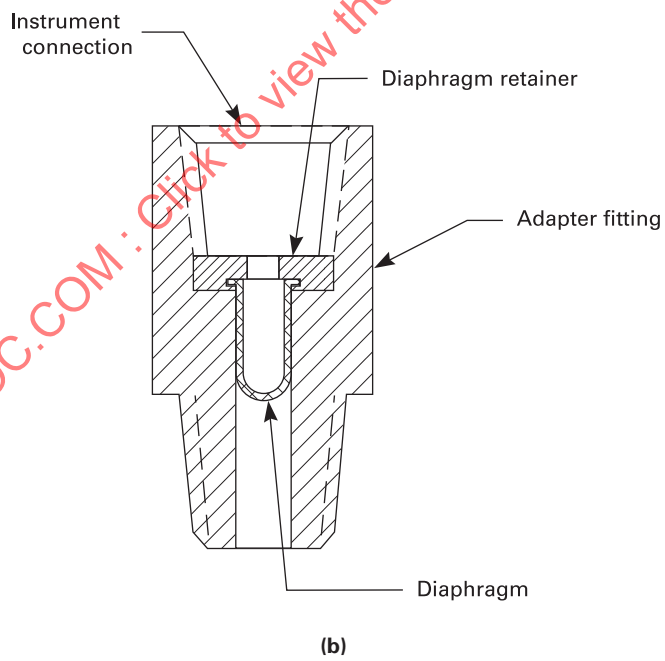
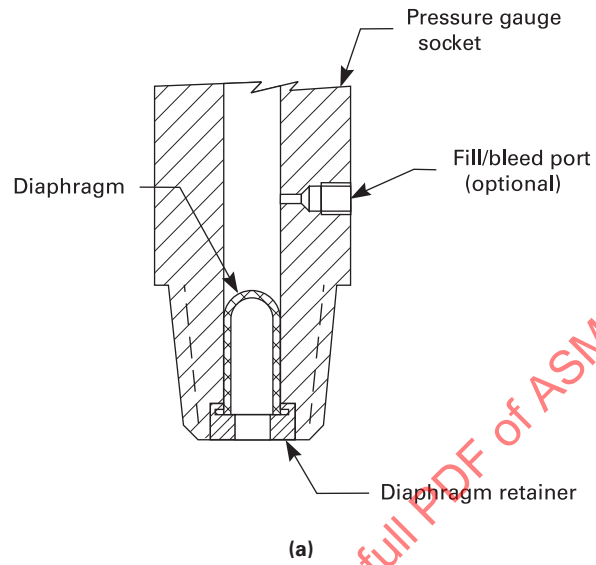
2.5 Fill Fluids and Selection

2.5.1 Fill Fluid. Fill fluid is the liquid used to fill that portion of the pressure-sensing system between the diaphragm and the pressure-sensing element, acting as the hydraulic medium for transmission of pressure.

2.5.1.1 Physical Properties. The following are physical properties of fill fluid:

- (a) coefficient of thermal expansion

Fig. 19 Gauge Isolator



GENERAL NOTE: These drawings are not intended to show design detail.

- (b) service temperature range
- (c) specific gravity
- (d) viscosity
- (e) vapor pressure
- (f) compressibility
- (g) freeze point
- (h) thermal decomposition point
- (i) spontaneous ignition temperature
- (j) long term stability (closed system)

2.5.2 Fluid Selection. The attributes of a fluid, specified in paras. 2.5.2.1 through 2.5.2.11, shall be considered.

2.5.2.1 Toxicity. Consideration must be made of the possibility of health hazards associated with the handling of fill fluids. If the fill fluid is to be used in an application to measure pressure in a food, beverage, or pharmaceutical process, the user should determine the nature of the risk involved, if small quantities of the fill fluid enter the process stream, by means of a leak.

2.5.2.2 Medium and External Environmental Compatibility. A fill fluid should not react adversely with the medium or environment if a leak should occur. Reaction with the environment could include toxic or corrosive contaminating and/or corrosive contamination and/or ignition. Reaction with the medium could include toxic contamination or loss of purity, which may damage the process or render the medium unusable (see para. 2.8).

2.5.2.3 Instrument Compatibility. The fill fluid must be compatible with all materials it contacts such as O-rings, gaskets, diaphragms, pressure elements, and housings.

2.5.2.4 Long Term Stability. Fill fluid shall be suitable for continuous operation at specified application service temperatures, pressures, and other service conditions. Incorrect selection with respect to service temperature range could result in fill fluid freezing, gel formation, polymerization, solidification, etc.

2.5.2.5 Effect of Temperature. The addition of a liquid-filled diaphragm seal to an instrument may create a detectable error in the pressure reading. Sealed systems contain fixed volumes of liquid. Temperature induced expansion and/or contraction of the fill fluid may increase or decrease the pressure reading. These effects will be greater for lower pressure instruments.

(a) Consideration should be given to the consequences of difference between assembly point (shop) ambient temperature and process service and ambient temperatures. When optimum accuracy is required, the filled seal and instrument system should be calibrated at the process service and ambient temperature.

(b) Consideration should also be given to the consequences of potential high or low ambient temperatures to which all or a portion of the seal/instrument assembly

may be exposed, for example, sun shining on exposed capillary line, temperature changes from noon to mid-night or mid-summer to mid-winter. Exposed components may be insulated, heated, or cooled to reduce the effects of ambient temperature variations.

2.5.2.6 Storage Temperature. Consideration shall be given to prevent damage to the seal/instrument assembly caused by high and/or low ambient temperature while the assembly is in transit or storage.

2.5.2.7 Effect of Liquid Head. The specific gravity of the fluid may have a distorting effect because of the static head pressure. This static head pressure will be a function of the fluid specific gravity and the elevation difference between the diaphragm and the sensing element of the instrument.

2.5.2.8 Viscosity. The fluid viscosity or resistance to flow has an effect upon the speed or response of the pressure instrument to a pressure change at the diaphragm. This effect will be greater on a system in which the instrument is connected to a diaphragm seal by a length of capillary.

2.5.2.9 Vapor Pressure. The fill fluid vapor pressure must be compatible with the following:

- (a) evacuation and fill procedures
- (b) ambient temperatures
- (c) transport and storage temperatures
- (d) medium pressure and temperature

2.5.2.10 Compressibility. Compressibility of the fill fluid must be considered in higher pressure applications because of the finite displacement capability of the diaphragm. Movement of the diaphragm is required to produce both the volume of compression of the fill fluid and the displacement required for the pressure-sensing element to function.

2.5.2.11 Other Considerations. The fill fluid should not support bacteriological growth or react with the materials of the diaphragm seal or the instrument.

2.6 Selection of a Diaphragm Seal

The following attributes of an application should be considered by the user for each application of a diaphragm seal. This listing is intended as an outline only with paragraph references to detailed descriptions. The supplier should be consulted for assistance if required.

2.6.1 Degradation of Accuracy. The volumetric displacement and volumetric spring rate of the diaphragm must be adequate to actuate the sensing mechanism of the instrument. The addition of the seal will, however, affect the accuracy of the instrument. Because the diaphragm has a finite spring rate, it will require some pressure to displace the fluid necessary to operate the pressure element.

This effect will be greater on instruments with elements requiring more fluid displacement, with diaphragms having higher volumetric spring rates, and on lower pressure range instruments.

The need to recalibrate the instrument with the seal attached will depend on the range, and also the desired accuracy.

2.6.2 Process Pressure. Process pressure is the maximum and minimum medium pressure that will be applied to the diaphragm seal.

2.6.3 Temperature. The following are types of temperature:

- (a) process temperature (see para. 2.5.2.5)
- (b) ambient temperature (see para. 2.5.2.5)
- (c) storage temperature (see para. 2.5.2.6)

2.6.4 Mounting

2.6.4.1 Mounting Style. See para. 2.2 and the following:

- (a) attached to the outside of a pipe or vessel
- (b) in-line

2.6.4.2 Mounting Method. See para. 2.2 and the following:

- (a) threaded
- (b) flanged
- (c) welded
- (d) saddle
- (e) clamped (sanitary)

2.6.4.3 Process Connection. See para. 2.3.10 and the following:

- (a) thread (e.g., ½ in. 14 NPT)
- (b) flange size and rating and face configuration (e.g., ASME B16.5, 1½ in. Class 150 RF)
- (c) weld size and configuration (e.g., 1-in. socket weld)
- (d) saddle, pipe size (e.g., 3 in.)
- (e) clamp, size and type

2.6.5 Materials

See para. 2.4.

2.6.5.1 Parts in Contact With the Medium. The following parts are in contact with the medium:

- (a) diaphragm
- (b) lower housing
- (c) mid housing
- (d) gaskets
- (e) weld
- (f) flushing connection plug

2.6.5.2 Parts Not in Contact With Medium. The following parts are not in contact with the medium:

- (a) upper housing
- (b) bolts and nuts
- (c) reinforcing rings
- (d) seal within the filled system
- (e) fill/bleed screw

2.6.6 Instrument Connection. See para. 2.3.9. Also, see the following:

- (a) size (e.g., ½ in. 14 NPT female)
- (b) direct or remote

2.6.7 Fill Fluid. See para. 2.5.

2.6.8 Other Features. See para. 2.3. Also, see the following:

- (a) continuous/noncontinuous
- (b) removable/nonremovable
- (c) flushing connection (see para. 2.3.11)
- (d) locking device (see para. 2.3.15)

2.7 Reuse of Diaphragm Seals

It is not recommended that diaphragm seals be moved from one application to another for the reasons stated in paras. 2.7.1 through 2.7.4.

2.7.1 Chemical Compatibility. The consequence of re-use without cleaning can range from contamination to explosive failure. For example, moving an oil service diaphragm seal to oxygen service without cleaning for oxygen service can result in explosive failure (see Compressed Gas Association, Inc., STD. CGA 4.1, "Cleaning Equipment for Oxygen Service"). Diaphragm seals should be disassembled and cleaned with appropriate solvents prior to any reuse on different applications.

2.7.2 Partial Fatigue. The first installation may involve pressure pulsations that have expended most of the diaphragm fatigue life, resulting in early fatigue in the second installation.

2.7.3 Corrosion. Corrosion of the diaphragm, lower and mid-housings, gaskets, and other parts wetted by the medium in the first installation may be sufficient to cause early failure in the second installation.

2.7.4 Other Considerations. If reusing a diaphragm seal is required, all guidelines covered in this Standard, relative to applications of diaphragm seals, should be followed in the same manner as when a new diaphragm seal is selected (see para. 2.5.2).

2.8 Safety

All diaphragm seal components, including fasteners, must be selected considering all process and ambient operating conditions, including corrosion, temperature, and pressure, to prevent misapplication (see para. 2.4). Improper selection could result in failure and possible injury or property damage.

2.8.1 Because of its thin cross section, special attention must be given to diaphragm material selection. Sometimes a material more corrosion resistant than that of the heavier bottom housing or associated piping should be considered. Operating temperatures must not

exceed the limit for the materials selected, including that of the fill fluids.

2.8.2 The maximum allowable pressure must not be exceeded. Flanged seals are generally limited to the maximum rating of the flange itself. Plastic lower housing will not withstand the same pressures as metal equivalents. Maximum allowable pressures for all materials decrease as temperatures increase.

2.8.3 Fasteners used to secure the structural components of the diaphragm seal shall only be replaced with fasteners specified by the supplier.

2.8.4 The fill fluid must be capable of withstanding the operating temperature. Glycerin or silicone fill fluids are not suitable for all applications. These fluids must be avoided where strong oxidizing agents are involved including, but not limited to, oxygen, chlorine, nitric acid, and hydrogen peroxide. In the presence of oxidizing agents, potential hazard will result from chemical reaction, ignition, or explosion. Completely fluorinated or chlorinated fluids, or both, may be more suitable for such applications.

2.8.5 Specific applications of diaphragm seals may require specific types of handling and cleaning of parts during manufacture. Oil and/or hydrocarbon compounds should not be used on parts that will contact oxygen. Seals to be used on pharmaceutical or food processing application should be manufactured and/or cleaned in accordance with U.S. Food and Drug Administration, 3A Sanitary Standards, or other applicable standards.

2.8.6 The entire filled portion of the system must be leak-tight. It is not recommended that the user tamper with the pressure instrument and diaphragm seal assembly. Any loss of fill fluid will result in significant errors or complete failure to transmit pressure to the instrument. In addition, the exposure of the fill fluid to the medium and surrounding area could cause a hazardous condition.

2.8.7 Care should be taken when welding is used to connect the lower housing to the process line to avoid damage from overheating. Consult the supplier for installation instructions.

2.9 Filling Diaphragm Seals

2.9.1 Objective of the Filling Operation. The objective of the filling operation is to fill the sealed system consisting of the diaphragm seal top assembly, connections, and the instrument with the fill fluid. Air bubbles cause some loss of accuracy, but are particularly troublesome when operating either at high temperature or vacuum. Under these conditions the air expands, overfilling the limited volume within the sealed system, causing inaccurate pressure measurements and frequently distorting metal diaphragms.

2.9.2 Filling Stations

(a) The fill station shown on Fig. 20 consists of a vacuum pump, a sight glass, a liquid trap, and a regulated source of pressure. In operation, the system to be filled is attached to the fill station. When the vacuum is applied, the air is drawn from the sealed system and is visible as bubbles in the sight glass. When the vacuum is withdrawn, the fill fluid fills the sealed system. The fill fluid is automatically degassed during the fill operation.

(b) The fill station shown on Fig. 21 consists of a vacuum pump, a fill reservoir, and two valves. Fill fluid is placed in the reservoir. When the valves are positioned as shown in Fig. 21, illustration (a), the vacuum is applied to the sealed system and the fluid is degassed. When valves are positioned as shown in Fig. 21, illustration (b), the fill fluid enters the sealed system.

2.9.3 Filling Procedures. The procedures described within this section are generalized for use as guidelines. The diaphragm seal supplier should be consulted for assistance with specific procedures. Applying vacuum to low pressure instruments may damage the instrument. Consult the instrument supplier for specific procedures.

2.9.3.1 Filling Diaphragm Seal and Instrument After Assembly.

The seal should be attached to the instrument and all joints leak tested. The fill/bleed port should be connected to the manifold in the filling system. Vacuum is then applied to the assembly until all air is removed. Vacuum is then released and the fill fluid permitted to enter the interior of the assembly. After filling, before tightening the fill/bleed screw, the flatness of the diaphragm should be checked as follows:

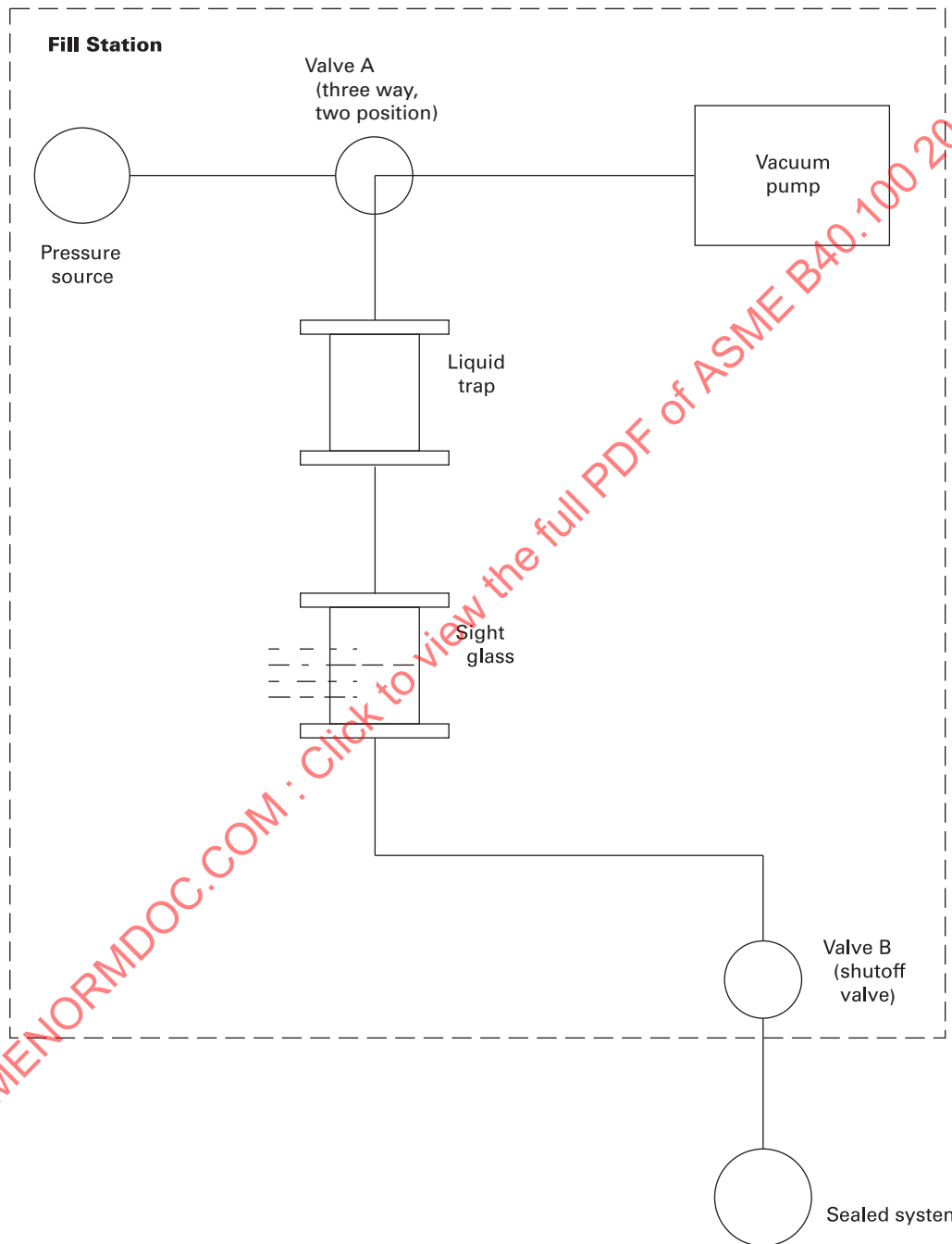
- (a) If the diaphragm is not flat, excessive nonlinearity and/or temperature error may result.
- (b) If the diaphragm is convex toward the process side (over-filled), gently press the diaphragm upward until it is flat and then tighten the fill/bleed screw.
- (c) If the diaphragm is concave, additional fill fluid should be added.

Special procedures may be required to fill diaphragm seals with elastomeric or Teflon® diaphragms because the diaphragm may be excessively distorted by the application of vacuum. The seal and instrument may also be filled per paras. 2.9.3.2 and 2.9.3.3.

2.9.3.2 Filling Diaphragm Seal and Instrument Before Assembly

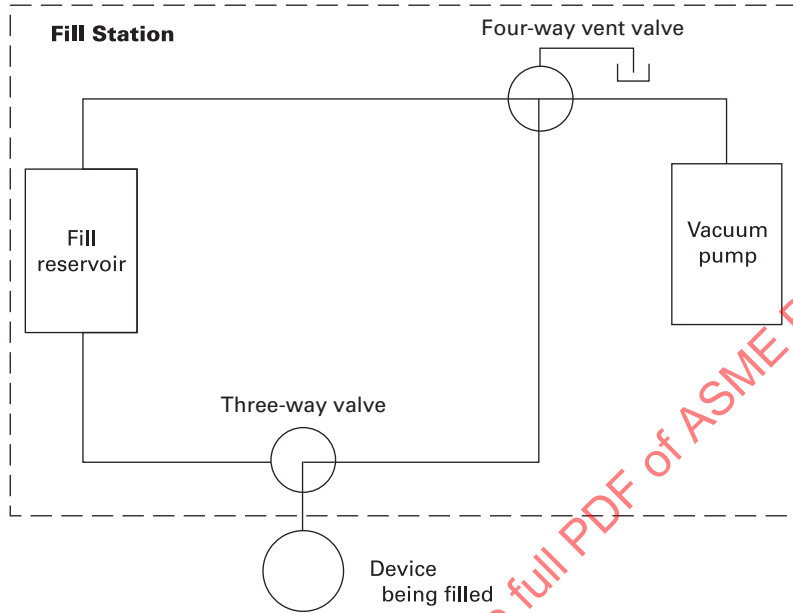
(a) *Filling a Diaphragm Seal.* A diaphragm seal without a fill/bleed screw can be filled using an oil can. The diaphragm should be flexed gently using a finger or pencil eraser on the process side to remove the air bubbles. Diaphragm seals with Teflon® or elastomeric diaphragms may also be filled by pouring the fill fluid into the seal. These diaphragms are soft and may sag when the liquid is poured. This sag may be prevented by attaching a low pressure source to the process side of the seal to support the diaphragm. The supplier should

Fig. 20 Sealed Setting

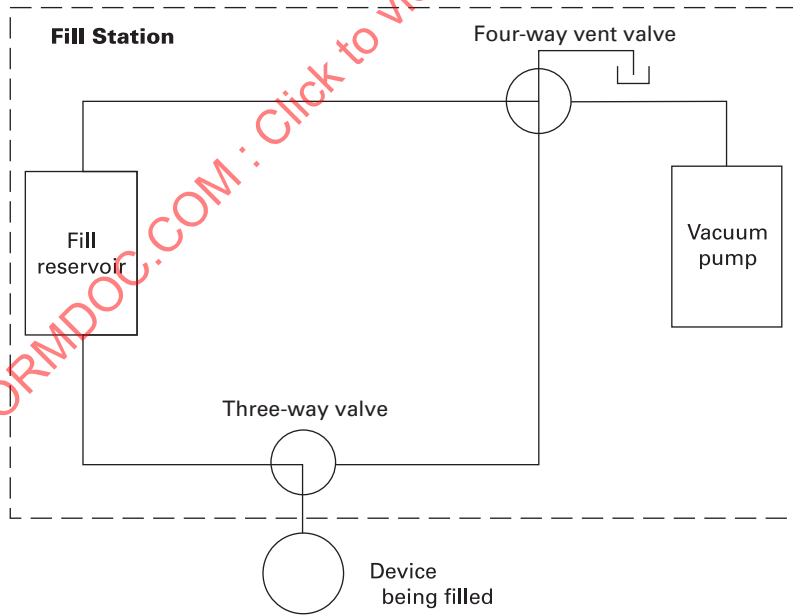


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Fig. 21 Fill Setting



(a)



(b)

be consulted for advice on the pressure required for diaphragm support.

(b) *Filling an Instrument.* An instrument may be filled by attaching it to a manifold and applying vacuum to the connection until all air is removed. The vacuum is then released and the fill fluid permitted to enter the interior of the instrument.

(c) *Assembling a Filled Seal to a Filled Instrument.* After filling both the seal [para. 2.9.3.2(a)] and the instrument [para. 2.9.3.2(b)], the connection of the instrument should be quickly inserted into the instrument connection on the seal, and tightened. The fill/bleed screw (if supplied) should be left open so that excess fluid can be allowed to escape. The diaphragm flatness should be checked in the same manner as described in para. 2.9.3.1.

If the seal does not contain a fill/bleed screw, the connection between the instrument and seal must be left slightly loosened until the diaphragm flatness has been achieved, and then the connection may be carefully tightened.

2.9.3.3 Filling a Seal With Capillary Between the Seal and the Pressure Instrument. These assemblies can be filled as a unit using the procedures described in para. 2.9.3.1.

If filled before assembly, first the seal and instrument should be filled as per paras. 2.9.3.2(a) and 2.9.3.2(b) and then the capillary filled either by pressurizing the fill fluid into one end and allowing flow until no bubbles appear at the other end, or by applying vacuum to one end of the capillary and immersing the other end into a container of fill fluid, continuing the process until all air is removed.

The filled capillary is then assembled to the instrument and seal in the same manner as the seal and instrument assembly described in para. 2.9.3.2(c).

2.10 Testing

2.10.1 Scope. This section is intended to provide an outline of the parameters used when evaluating the performance of diaphragm seal/instrument assemblies and to suggest evaluation outlines. These test methods may or may not satisfy the requirements of the intended application. When it is known that the diaphragm seal/instrument assembly will encounter conditions more or less severe than those specified, the test may be modified to more closely match the application. A functional test in the intended application is generally the best evaluation method.

2.10.2 General. All tests described within this section shall be conducted with a diaphragm seal instrument that is filled in accordance with the procedures described in para. 2.9. After assembly and filling, the instrument shall be recalibrated to its specified accuracy prior to conducting any accuracy testing of the diaphragm seal/instrument assembly. The accuracy and

other test parameters of the diaphragm seal/instrument assembly may exceed the specified parameters of the instrument used within the assembly. Acceptable performance specifications shall be agreed to by the supplier and user.

2.10.3 Calibration Standards

2.10.3.1 General Discussion

(a) Information regarding manometers and piston gages is contained in ASME PTC 19.2. In computing the accuracy of these instruments, their geographical location must be accurately ascertained and corrections applied as outlined in National Institute of Standards and Technology, NIST, (formerly National Bureau of Standards) Manometry Manual, and NIST Piston Gage Manual.

(b) Working standards shall be tested before and after a period of use. The frequency of recalibration will depend on their ability to retain their accuracy during use.

(c) For information regarding indicating dial gauges used as working standards, see ASME B40.1.

2.10.3.2 Recommended Standards. Standards shall have nominal errors no greater than $\frac{1}{4}$ of those permitted for the seal/instrument assembly being tested. If a liquid medium is used, correction for the difference in liquid head between the standard and the instrument being tested may be necessary.

CAUTION: Piston gages, or other standards that contain oil or other hydrocarbon fluids, shall not be used to test diaphragm seal/instrument assemblies cleaned for oxygen service.

2.10.4 Test Procedures

2.10.4.1 General. The following procedures are suggested when testing a diaphragm seal/instrument assembly. Statistical methods, alternate procedures, or both, may be used when agreed to by the supplier and user.

(a) *Reference Temperature.* A temperature of 73.4°F (23°C) shall be the reference standard for testing all diaphragm seal/instrument assemblies. Temperature-compensated pressure instruments shall be tested at several ambient temperatures within the range specified by the supplier.

(b) *Liquid Head.* When using a liquid-filled dead weight piston gage, appropriate compensation shall be made for liquid head effects.

2.10.4.2 Procedures. It is suggested that all testing be conducted on the assembly of a diaphragm seal and the attached pressure instrument. Statistical methods or alternate test procedures, or both, may be used when agreed to by the supplier and the user.

(a) *Accuracy.* The accuracy of the diaphragm seal/instrument assembly shall be tested using the procedures for the instrument alone. Procedures for accuracy

testing elastic element pressure gauges are described in ASME B40.1. Appropriate procedures should be applied to other types of pressure instruments.

(b) *Repeatability.* The repeatability of the diaphragm seal/instrument assembly shall be tested using the procedures for the instrument alone. Procedures for repeatability testing elastic element pressure gauges are described in ASME B40.1. Appropriate procedures should be applied to other types of pressure instruments.

(c) *Hysteresis.* The hysteresis of the diaphragm seal/instrument assembly shall be tested using the procedures for the instrument alone. Procedures for hysteresis testing of elastic element pressure gauges are described in ASME B40.1. Appropriate procedures should be applied to other types of pressure instruments.

(d) *High Temperature Error.* The diaphragm seal/instrument assembly shall be tested in accordance with para. 2.10.4.2(a). The assembly shall be placed in a temperature test chamber at a temperature not to exceed the supplier's maximum operating temperature and allowed to stabilize for a period of not less than 4 hr. The assembly shall then be checked for accuracy at this temperature, in accordance with para. 2.10.4.2(a). The difference in test readings at each test point between room temperature and the maximum operating temperature is the high temperature error.

(e) *Low Temperature.* The diaphragm seal/instrument assembly shall be tested in accordance with para. 2.10.4.2(a). The assembly shall be placed in a temperature test chamber at a temperature no lower than the supplier's low limit and allowed to stabilize for a period of not less than 4 hr. The assembly shall then be checked for accuracy at this temperature, in accordance with para. 2.10.4.2(a). The difference in test readings at each test point between room temperature and the minimum operating temperature is the low temperature error.

(f) *Storage Temperature.* The diaphragm seal/instrument assembly shall be tested for accuracy in accordance with para. 2.10.4.2(a). The assembly shall then be placed in a temperature test chamber at a temperature no higher than the supplier's high limit of storage temperature for a period of 24 hr. The assembly shall then be placed in a temperature test chamber at a temperature no lower than the supplier's low limit of storage temperature for a period of 24 hr. This 48-hr cycle shall be repeated for a total of two complete cycles. The assembly shall then be allowed to stabilize at room temperature and then checked for accuracy in accordance with para. 2.10.4.2(a). The difference between the two accuracy tests is the effect of storage temperature expressed as a percent of span.

(g) *Pressure Cycling.* The pressure cycling test shall be conducted with a diaphragm seal/instrument assembly as agreed to by the supplier and user. It is recommended that this test be performed utilizing the instrument that

has the largest actuating displacement (usually the lowest pressure) for the application which the test is being performed.

(1) Since the diaphragm is basically an isolator with nearly equal pressure on both sides, pressure stresses are very low. Working stresses, therefore, are mostly deflection related. Testing on a low pressure/large displacement seal/instrument assembly, therefore, would result in the highest diaphragm stresses.

(2) The diaphragm seal/instrument assembly shall be tested for accuracy in accordance with para. 2.10.4.2(a). The assembly shall then be subjected to repeated applications of a pressure (hydraulic preferred) that produces an indication of 20% to 80% of the range of the assembly at a rate of 0.5 Hz. The application and release of the pressure shall be as smooth as practicable, so as not to subject the instrument mechanism to excessive upscale or downscale accelerations or high amplitude impulses (pressure spikes). The assembly shall be tested for accuracy in accordance with the test specified in para. 2.10.4.2(a) not less than 1 hr after stopping the pressure cycling. The difference between the first set of readings at each test point and the last set of readings at each test point is the fatigue error at this point.

(3) The assembly shall also be examined periodically during the test for leakage of the diaphragm. The fatigue life is the number of cycles to leakage. If the instrument fails, the instrument shall be replaced and the test continued.

(h) *Continuous Duty.* This test is intended to be performed only on diaphragm seals that are specified for "Continuous Duty" performance per para. 2.3.2.1.

(1) The diaphragm seal/instrument assembly shall be filled in accordance with the procedures described in para. 2.9. The instrument may be recalibrated and the assembly shall be tested in accordance with para. 2.10.4.2(a). The instrument shall then be removed from the diaphragm seal and the instrument connection of the seal left open. The rated maximum operating pressure shall be applied to the process connection of the diaphragm seal for a period of 15 min. The diaphragm seal shall not show any evidence of leakage.

(2) After the test pressure is released, the instrument shall be reassembled to the diaphragm seal, the assembly refilled using the procedures described in para. 2.9. The instrument may be recalibrated and the assembly shall be tested for accuracy in accordance with para. 2.10.4.2(a). The assembly shall be within the accuracy limits observed prior to the test.

(i) *Continuous Seal.* This test is intended to be performed only on diaphragm seals that are specified for "Continuous Seal" performance per para. 2.3.2.2.

The diaphragm seal/instrument assembly shall be filled in accordance with para. 2.9. The instrument shall then be removed from the diaphragm seal and the instrument connection of the seal left open. The rated maximum operating pressure shall be applied to the pressure

connection of the diaphragm seal, with no instrument attached, for 15 min. The diaphragm seal shall not show any evidence of leakage.

(j) *Fatigue.* This test determines the fatigue life of the diaphragm. It shall be conducted on a diaphragm seal/instrument assembly, using the instrument with the largest actuating displacement (usually the lowest pressure range) for the intended application of the seal. Since the pressure is almost equal on both sides of the diaphragm, the highest stresses will be imposed when the diaphragm is displaced to its maximum.

(1) The diaphragm seal/instrument assembly shall be filled in accordance with para. 2.9. It shall then be subjected to repeated applications of pressure (hydraulic preferred) equal to approximately 20% to 80% of the range of the instrument, at a rate of 0.5 Hz. The rate of pressure change should approximate a sine wave, to avoid upscale or downscale impulses (spikes).

(2) The assembly shall be examined periodically for diaphragm leakage. The fatigue life is the number of cycles before leakage. If the instrument fails, it shall be replaced and the test continued.

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SNUBBERS

1 SCOPE

This Standard (B40.5) is confined to devices that are installed between the pressure source and the pressure-sensing element and are used to minimize the effect of pressure surges on positive and negative pressure-sensing instruments.

2 PURPOSE

These devices commonly known as snubbers, pulsation dampeners, pressure equalizers, gauge protectors, gauge savers, etc., are used to improve the output or readability of the instrument, and to reduce the effect of pressure surges on the instrument. They also limit the external discharge of the pressure medium, in the event a discontinuity should occur on the instrument side of the snubber.

3 GENERAL

3.1 Terminology Defined

Terms relevant to this Standard and its application are as follows:

amplitude: the maximum departure of the pressure from the average pressure.

fluctuation: a nonperiodic surge.

pulsation: a periodic surge.

rate of pressure change: pressure change per time interval.

response time: the time required for a change in system pressure to be indicated by the instrument.

snubber: a surge dampening device that is designed to minimize the effect of pressure spikes and surges on instruments while allowing changes in system pressure, and low frequency pulsations to be transmitted to the instrument.

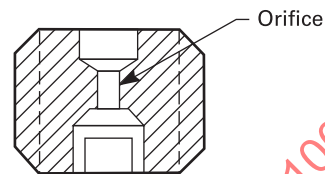
spike: a short duration, high amplitude surge.

surge: a sudden rise or drop in system pressure.

3.2 Connections

3.2.1 Type of Connection. Tapered pipe connections for pressure up through 20,000 psi or 160 000 kPa are usually $\frac{1}{8}$ in. 27 NPT, $\frac{1}{4}$ in. 18 NPT, or $\frac{1}{2}$ in. 14 NPT American Standard external or internal tapered pipe threads per ANSI B1.20.1, as required. Above this pressure, high pressure tubing connections, or equal, should be used. Other appropriately sized connections, that

Fig. 1 Fixed Orifice



GENERAL NOTE: Not intended to show design detail.

employ sealing means other than tapered threads are acceptable.

In applications of pipe-mounted instruments, where vibration is extremely severe, consideration should be given to the possibility of failure of the snubber or associated piping, caused by the vibrating mass. A larger connection (e.g., $\frac{1}{2}$ in. 14 NPT instead of $\frac{1}{4}$ in. 18 NPT) and/or a stronger material (e.g., stainless steel instead of brass) should be considered.

3.3 Materials

The internal materials must be compatible with the process and the external materials must be compatible with the environment. The effect of the structural or mechanical loading must also be considered. If elastomeric or nonmetallic materials are present, they should be selected to ensure compatibility with the process medium, temperature, and pressure.

3.4 Types of Snubbers

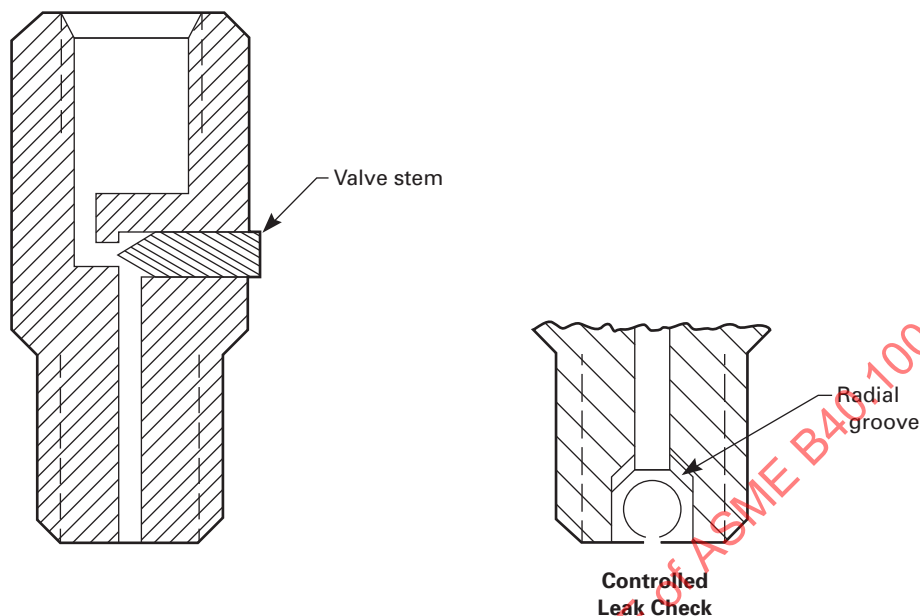
3.4.1 Fixed Orifice. This device contains one or more orifices, and is available in different sizes and configurations. The orifice may be in the form of a capillary. The fixed orifice is not adjustable and may become plugged in media with suspended solids. It can reduce moderate surges in clean systems (see Fig. 1).

3.4.2 Valve. This device consists of an externally adjustable valve. Closing the valve increases the dampening action. Some valves include long tapered plugs, filters, and/or controlled leak checks.

CAUTION: It may be possible to close off the valve completely (see Fig. 2).

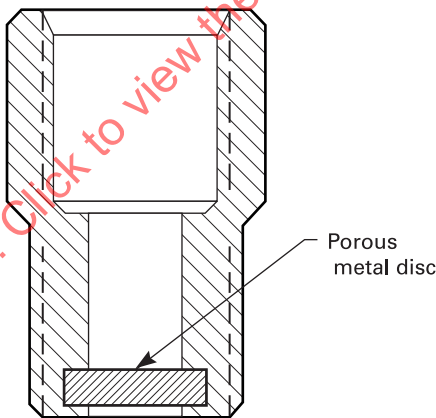
3.4.3 Porous Metal. This nonadjustable device consists of a porous metal element, available in several porosities, installed within a fitting. It has an increased range of dampening and a reduced tendency to plugging

Fig. 2 Valve



GENERAL NOTE: Not intended to show design detail.

Fig. 3 Porous Metal



GENERAL NOTE: Not intended to show design detail.

with suspended solids as compared to fixed orifices (see Fig. 3).

3.4.4 Felt Plug — Fluid Filled. This device consists of a bladder or diaphragm enclosing a fluid-filled chamber with felt plugs inserted between the chamber and the instrument. The pressure-sensing element of the instrument must be fluid filled. The felt plugs can be compressed to provide the required dampening and the fluid-filled bladder minimizes plugging by media solids (see Fig. 4).

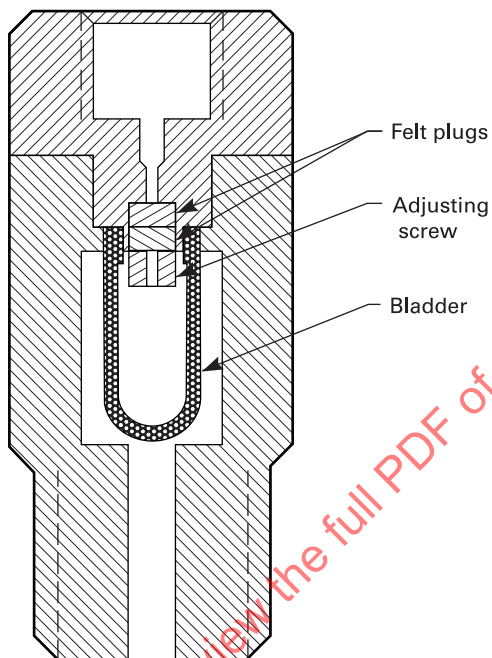
3.4.5 Piston. This device consists of a movable piston in a hole. The clearance between the piston and the

hole determines the amount of dampening. It is usually furnished with multiple pistons or a cylinder with multiple holes. The amount of snubbing can be changed by changing pistons or holes. Piston-type snubbers tend to be self cleaning because of the action of the piston (see Fig. 5).

3.5 Selection

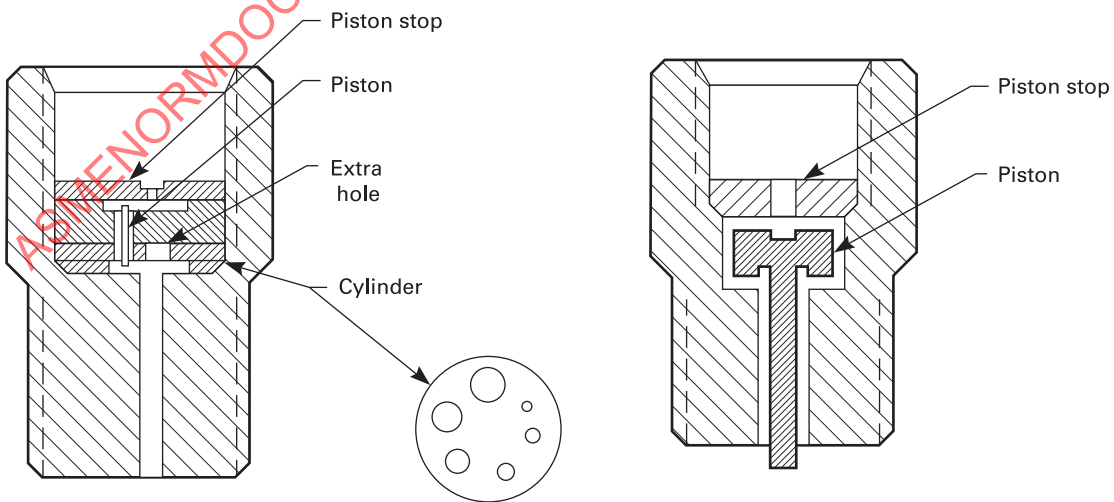
3.5.1 System Parameters. The following system parameters should be considered by the user for each application of a snubber. The effect of these parameters may vary depending on the instrument used. The supplier should be consulted for assistance, if required.

Fig. 4 Felt Plug – Fluid Filled



GENERAL NOTE: Not intended to show design detail.

Fig. 5 Piston



GENERAL NOTE: Not intended to show design detail.

3.5.1.1 Viscosity. More dampening is required for media of low viscosity.

3.5.1.2 Pressure. The higher the pressure the greater the amount of dampening required. Below approximately 10 psi the performance becomes less predictable. At lower pressure generally less dampening is required, and some experimentation may be required to obtain the desired amount of dampening.

3.5.1.3 Rate of Pressure Change. The higher the maximum rate of pressure change, the greater the amount of dampening required.

3.5.1.4 Amplitude of Pressure Change. The higher the amplitude of pressure change, the greater the amount of dampening required.

3.5.1.5 Volumetric Displacement of the Instrument. Generally less dampening is required with higher instrument volumetric displacement.

3.5.1.6 System Pressure. The snubber must be capable of withstanding the system pressure.

3.5.1.7 Suspended Solids. Some pressure media may contain solids. A snubber may be partially or completely plugged depending on its design. In these cases, it would be advisable to protect the instrument and the snubber with a diaphragm seal or similar device, unless this feature is provided in the snubber.

3.5.1.8 Materials of Construction. The internal material must be compatible with the process and the external materials must be compatible with the environment. The effect of the structural or mechanical loading must also be considered. If elastomeric or nonmetallic materials are present, they should be selected to ensure compatibility with the process medium, temperature, and pressure.

3.5.2 Consultation. Due to the extensive number of variables associated with the selection of snubber types, styles, operating parameters, etc., detailed selection criteria is beyond the scope of this Standard (B40.5). The user should consult the supplier for recommendation.

3.6 Performance

3.6.1 Pressure Transmission Characteristics. In systems that have surges, the snubber will minimize the effect of the peak pressures on the instrument. If high frequency pulsations are present, the instrument output will tend to be an average reading.

3.6.2 General. When the working parts are properly selected in accordance with para. 3.5, as well as compatibility with the pressure medium, and when the instrument and the snubber are filled completely with the pressure medium, the instrument should respond to changes in system pressure within an acceptable time span without overshoot. When the system is at operating

pressure, gradual fluctuation of the instrument output due to changes in pressure is permissible. The effect of pressure spikes on the instrument should be minimized.

3.6.3 Mechanical Vibration. Most snubbers will not be effective in reducing the effects of mechanical vibration.

3.6.4 Existing Systems. The installation of a new properly selected snubber in a system, containing a worn instrument may not provide the desired result.

3.6.5 Response Time. There are two response times that are of interest (paras. 3.6.5.1 and 3.6.5.2).

3.6.5.1 Response Time at Operating Pressure. On a properly selected and installed unit, a change in system pressure should be indicated within an acceptable time span. This time is shortened by reducing the volume between the snubber and the pressure-sensing element and on liquid-filled systems by eliminating all gas between the snubber and the pressure-sensing element. The response time may be reduced by reducing the amount of dampening.

3.6.5.2 Response Time on Start-Up. When a system is initially pressurized, the pressure will register slowly for the initial and final portion of the pressure rise, but will be rapid for the central portion. To decrease the overall response time, minimize the fluid volume from the snubber to the pressure-sensing element. In liquid-filled systems remove all gas from the snubber to the pressure-sensing element or reduce the amount of dampening.

3.6.6 Temperature Effect on Response Time. A lower temperature that results in a more viscous pressure medium will increase the response time. This will be most noticeable on start-up.

3.6.7 Location. The snubber should be located as close as possible to the instrument.

3.6.8 Entrapped Gas. Entrapped gas in a liquid-filled system will result in a slow response on initial pressurization, will cause the instrument to be slow to reach zero when pressure is removed, and will affect instrument accuracy to some extent.

4 SAFETY

4.1 Scope

This section of the standard presents certain information to guide users, suppliers, and manufacturers toward minimizing the hazards that could result from misuse or misapplication of pressure snubbers. The user should become familiar with all sections of this Standard (B40.5), as all aspects of safety cannot be covered in this section. Consult the supplier for advice whenever there is uncertainty about the application.

4.2 General Discussion

4.2.1 Planning. Adequate safety results from intelligent planning, careful selection, and proper installation. The user should inform the supplier of all conditions pertinent to the application and environment so that the supplier can make the most suitable recommendation for the application.

4.2.2 Hazardous Systems and/or Conditions. Systems such as, but not limited to the following, are considered potentially hazardous and must be carefully evaluated:

- (a) compressed gas systems
- (b) oxygen systems
- (c) systems containing hydrogen or free hydrogen atoms
- (d) corrosive fluid systems (gas and liquid)
- (e) pressure systems containing any explosive or flammable mixture or medium
- (f) steam systems
- (g) nonsteady pressure systems
- (h) systems where high overpressure could be accidentally applied
- (i) systems wherein interchangeability of snubber could result in hazardous internal contamination or where lower pressure snubbers could be installed in higher pressure systems
- (j) systems containing radioactive or toxic fluids (liquid or gases)
- (k) systems installed in a hazardous environment

4.2.3 Unique Media. When snubbers are to be used in contact with media having known or uncertain corrosive effects or known to be radioactive, random or unique destructive phenomena can occur. In such cases the user should always furnish the supplier with information relative to the application and solicit his advice prior to installation of the snubber.

4.2.4 Violent Effects. Fire and explosions within a pressure system can cause failure with very violent effects. Failure in a compressed gas system can be expected to produce violent effects. Violent effects may also be produced by other failure causes including, but not limited to the following:

- (a) hydrogen embrittlement
- (b) contamination of a compressed gas
- (c) formation of acetylides
- (d) weakening of soft soldered joints by steam or other heat sources
- (e) weakening of soft-soldered or silver-brazed joints caused by heat sources such as fires
- (f) corrosions
- (g) fatigue
- (h) mechanical shock
- (i) excessive vibration

4.2.5 Caution to Users

4.2.5.1 Contamination. Oil from instrument calibration or other sources should not come in contact with the internal part of the snubber that is intended for air, gas, or water service. If it does, unacceptable delays in the transmission of pressure may occur, resulting in accidental system over-pressure or failure.

4.2.5.2 Reuse. It is recommended that a snubber not be moved from one application to another. Should it be necessary, the following should be considered:

(a) *Chemical Compatibility.* The consequences of incompatibility can range from contamination to explosive failure. For example, moving an oil service device to oxygen or other oxidants can result in explosive failure.

(b) *Viscosity Compatibility.* The viscosity of the pressure medium must be within the range of the snubber being moved.

(c) *Pressure Compatibility.* The operating pressure of the new installation must not exceed the rating of the snubber being reused.

(d) *Other Considerations.* When reusing a snubber, all guidelines covered in this Standard (B40.5) relative to applications should be followed in the same manner as when a new snubber is selected.

5 TESTING

5.1 General

These tests are intended to provide an outline of the parameters used when evaluating new snubber performance and to suggest evaluation outlines. These tests may or may not satisfy the requirements of the intended application. When it is known that the snubber will encounter conditions more severe or less severe than those specified, the test may be modified to more closely match the application. A functional test in the intended application is generally the best evaluation method.

5.2 Surge Generation

To test the effectiveness of a snubber, a means of generating surges and a means of measuring pressure on the instrument side of the snubber are required.

5.3 Comparison Testing

If comparison tests are wanted, then the ability to repeat the surge and measure it with and without the snubber is necessary.

5.4 Test Fluid

The test fluid can be the fluid on which the snubber will operate or, if the test is for general effectiveness of the snubber, the fluid can be that which is used in existing test equipment. If the choice of fluids is optional, choose a low viscosity liquid such as water or a thin hydraulic fluid.

5.5 Test

WARNING: Failures during pressure testing are unpredictable and may cause parts to be propelled in any direction. All pressure testing should be conducted by qualified personnel using appropriate safety equipment such as safety glasses, shields, or enclosures, or a combination, to prevent personal injury and property damage. Read section 4 before conducting any testing.

5.5.1 Temperature Effect. If tests are to be compared to one another, the test temperatures should be the same. It may be worth noting that after a prolonged shut-down at cold temperatures, the first pressurization will be considerably slower than subsequent pressurization. This phenomenon can be overlooked if the system is pressurized for calibration immediately before the test.

5.5.2 Test Set-Up. See Fig. 6 for a test set-up that has been successfully used. It generates surges approximately twice the input pressure. A typical input surge is shown in Fig. 7.

5.5.3 Desirable Snubber Output. The dampened output should resemble Fig. 8. Generally the maximum rate of pressure rise would be from 5,000 psi/sec to 15,000 psi/sec; 30,000 psi/sec would be maximum for effective protection of the instrument without any pressure overshoot.

5.6 Equipment

Equipment can be added or changed to suit the test objectives. Electronic transducers and recording equipment reduce observation errors and give permanent test data. Simultaneous records of the input and output are an improvement. An environmental test chamber is necessary if high and/or low temperature tests are required.

5.6.1 Solenoids. The solenoids must be fast acting.

5.6.2 Twelve-Foot Coil. The 12-ft coil of tubing is to simulate system piping. It has very little effect on the rate of pressure rise, but it does reduce the frequency of the surges that follow the initial surge.

5.6.3 Transducer Location. It may be desirable to move the transducer out of the test chamber for tests at temperatures beyond the limits of the transducer. A second transducer could be added so surges could be measured with and without the snubber at the same time.

5.6.4 Needle Valves. The needle valves are in the system for convenience in setting up, but care must be taken because a partially closed valve could affect the test results.

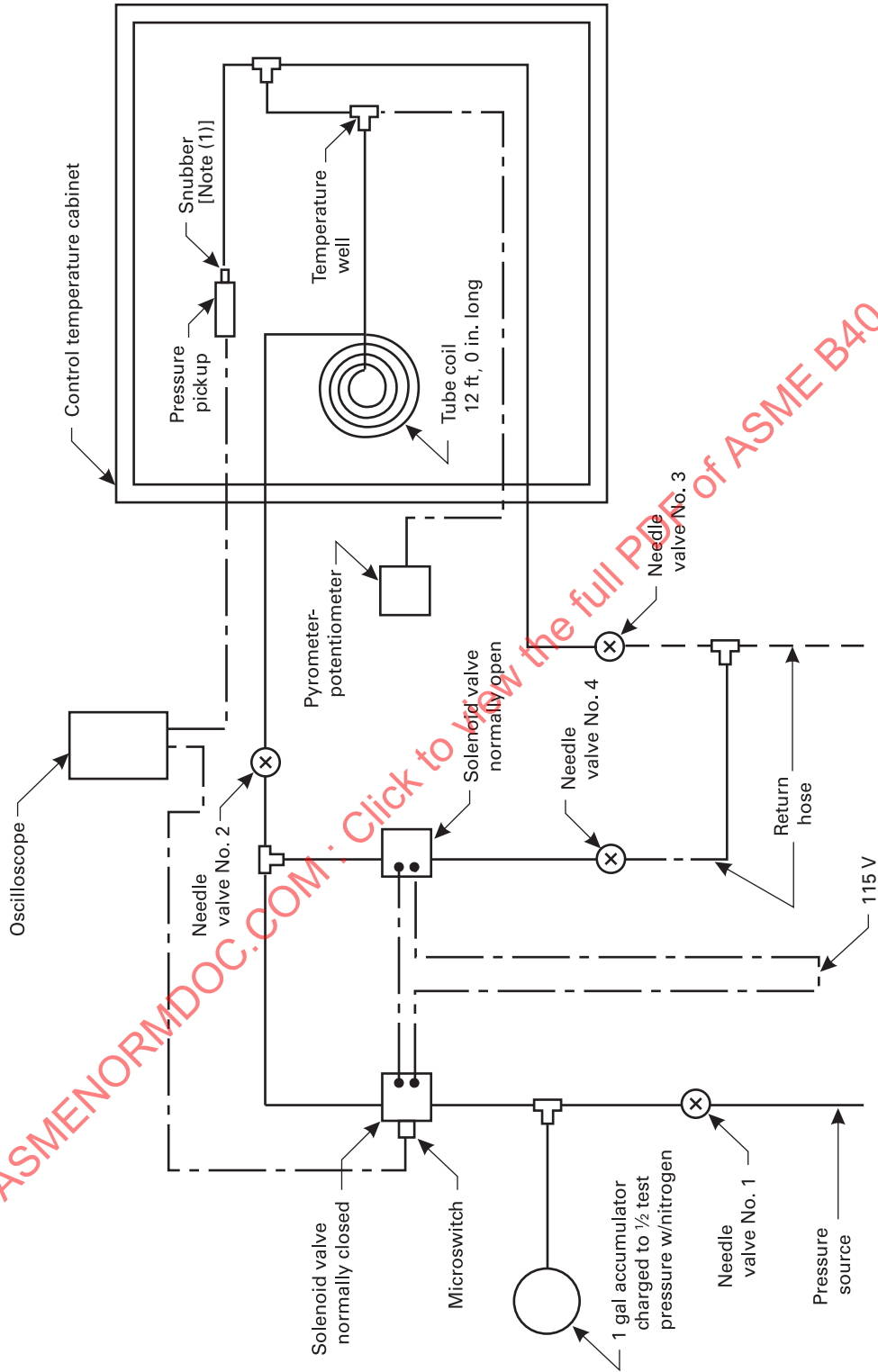
5.6.5 Temperature Measurement. The method of temperature measurement is not important, but it is advisable to measure the fluid temperature, as well as the ambient temperature, to be certain that all elements of the system are at the same temperature.

5.7 Test Procedure

(a) The system should be filled with the pressure medium, and all air bled from the system with particular attention being paid to the space between the pressure pick-up and the snubber. Filling at low pressure helps eliminate foam and air bubbles. Do as follows:

- (b) Open needle valves 1 through 4.
- (c) Close needle valve 3.
- (d) Pressurize the accumulator to the test pressure.
- (e) Actuate the solenoid valves to apply pressure to the system and start the oscilloscope trace.
- (f) When the results have been observed and/or recorded, actuate the solenoid valves to drop the system pressure.
- (g) To repeat start at para. 5.7(d).

Fig. 6 Test Set-Up

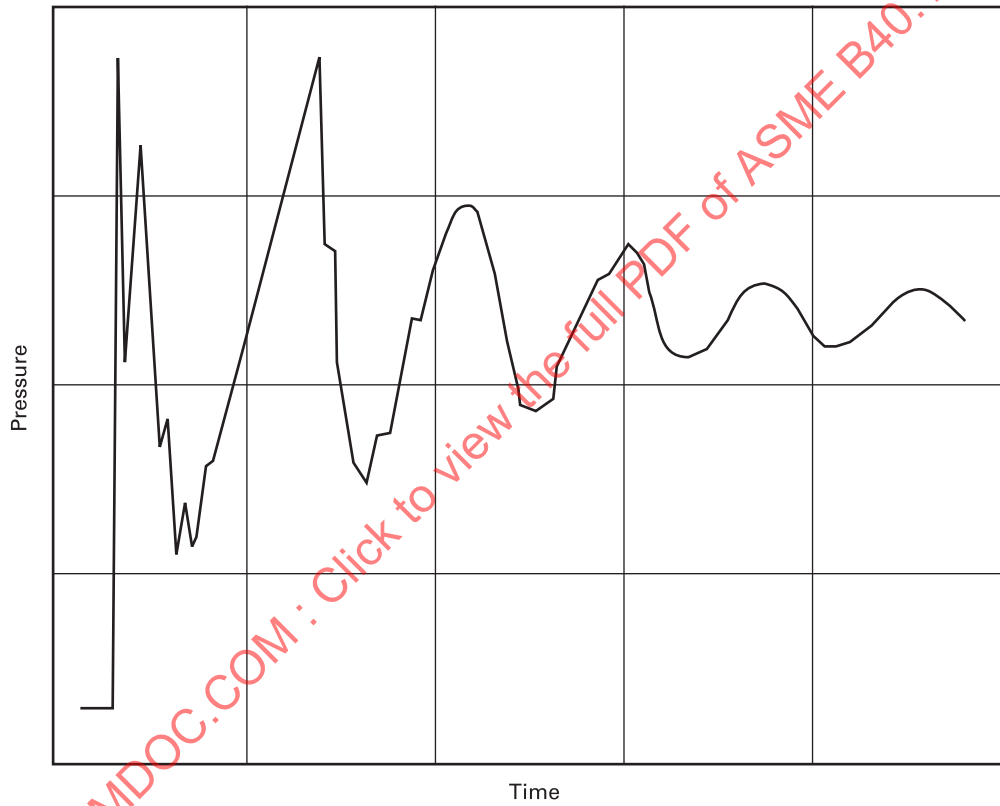


GENERAL NOTE: See para. 5.5.2.

NOTE:

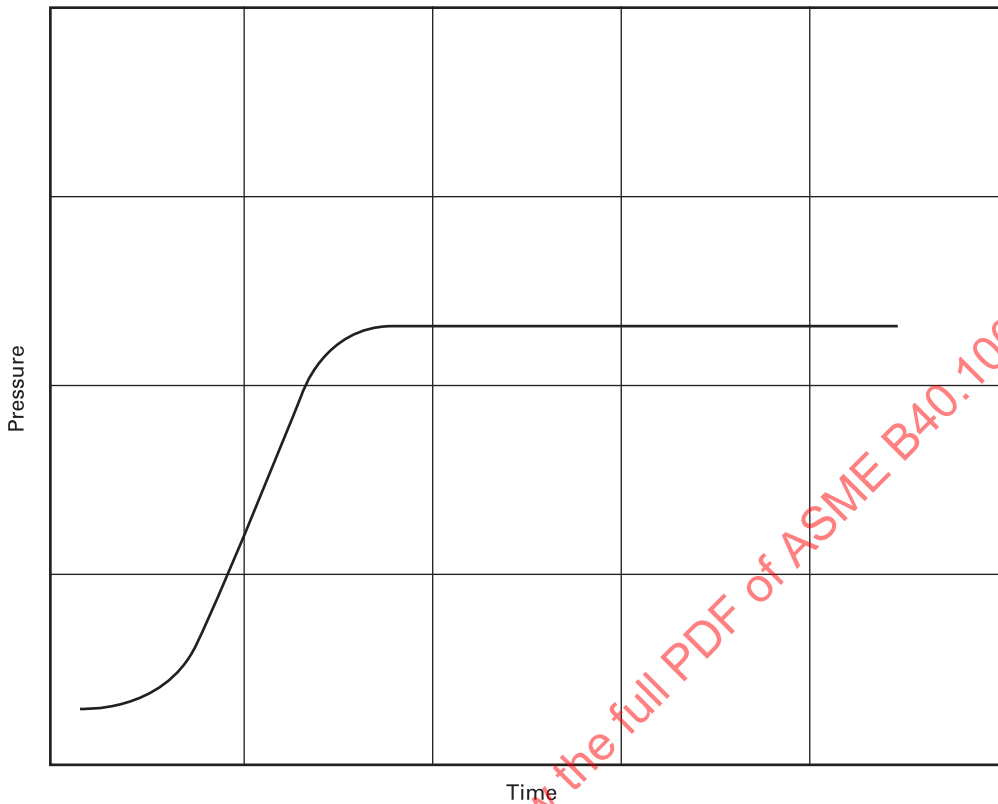
(1) Device under test.

Fig. 7 Typical Input Surge



GENERAL NOTE: See para. 5.5.2.

Fig. 8 Desirable Snubber Output



GENERAL NOTE: See para. 5.5.3.

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NONMANDATORY APPENDIX A

SUPPLEMENTAL REQUIREMENTS

The following supplementary requirements established for naval shipboard applications shall apply when specified in the contract or purchase order. When there is conflict between the Standard (ASME B40.5) and this supplement, the requirements of this supplement shall take precedence for equipment acquired by this supplement. This document supersedes MIL-S-2940, Snubbers, Fluid Pressure, Instrument Protection, for new ship construction.

A-1 SCOPE

This specification supplement covers shock resistant, environmentally hardened devices that are installed between the pressure source and the pressure-sensing element and are used to minimize the effect of pressure surges on positive and negative pressure-sensing instruments.

A-2 GENERAL

A-2.1 Connections

Materials used for connections shall be compatible with the specified snubber body composition.

A-2.1.1 General Pressure Applications. Snubbers used in pressure applications shall be as specified in paras. A-2.1.1.1 through A-2.1.1.4.

A-2.1.1.1 O-Ring Union Connection. Snubbers used for O-ring union pressure gauge applications shall have a connection in accordance with Figs. A-1 and A-2. When the O-ring union is specified, each snubber shall be furnished with a union nut, tailpiece, and O-ring as shown on Figs. A-1 and A-2.

A-2.1.1.2 Flareless (Bite Type) Connection. Snubbers used for flareless (bite type) pressure gauge applications shall have $\frac{7}{16}$ in. 20 UNF-2A external threads on the inlet connection and $\frac{7}{16}$ in. 20 UNF-2B internal threads on the outlet connection in accordance with SAE J 1926, 6000 psi for $\frac{1}{4}$ in., tubing.

A-2.1.1.3 Pressure Transducer Connection. Snubbers used for pressure transducer applications shall have a $\frac{7}{16}$ in. 20 UNF flareless tube connection [$\frac{1}{4}$ in., outside diameter (O.D.)] on the inlet connection. The outlet connection shall be $\frac{7}{16}$ in. 20 UNF-2A external thread to mate with the SAE J 1926 internal connection port of the pressure transducer. An O-ring shall be supplied on the outlet connection.

A-2.1.1.4 Other Connections. Snubbers not used in any of the above applications shall have connections specified in the contract or ordering data.

A-2.2 Materials

Materials for snubbers and guidance for proven materials are specified in paras. A-2.2.2.1 through A-2.2.2.6. Material for wetted parts shall be selected for long-term compatibility with the service fluid (see para. A-4.2.2) and shall be equal to or superior in corrosion resistance to that used in the body except that corrosion-resistant steel is prohibited for Type 4 (seawater) snubbers or for oxygen applications.

A-2.2.1 Recycled, Recovered, or Environmentally Preferable Materials. Recycled, recovered, or environmentally preferable materials should be used to the maximum extent possible, provided that the material meets or exceeds the operational and maintenance requirements and promotes economically advantageous life cycle costs.

A-2.2.2 Snubber Body. The materials for construction of the bodies of snubbers may be selected from compositions A, B, and C. Snubber body material shall be of composition X if other than A, B, or C.

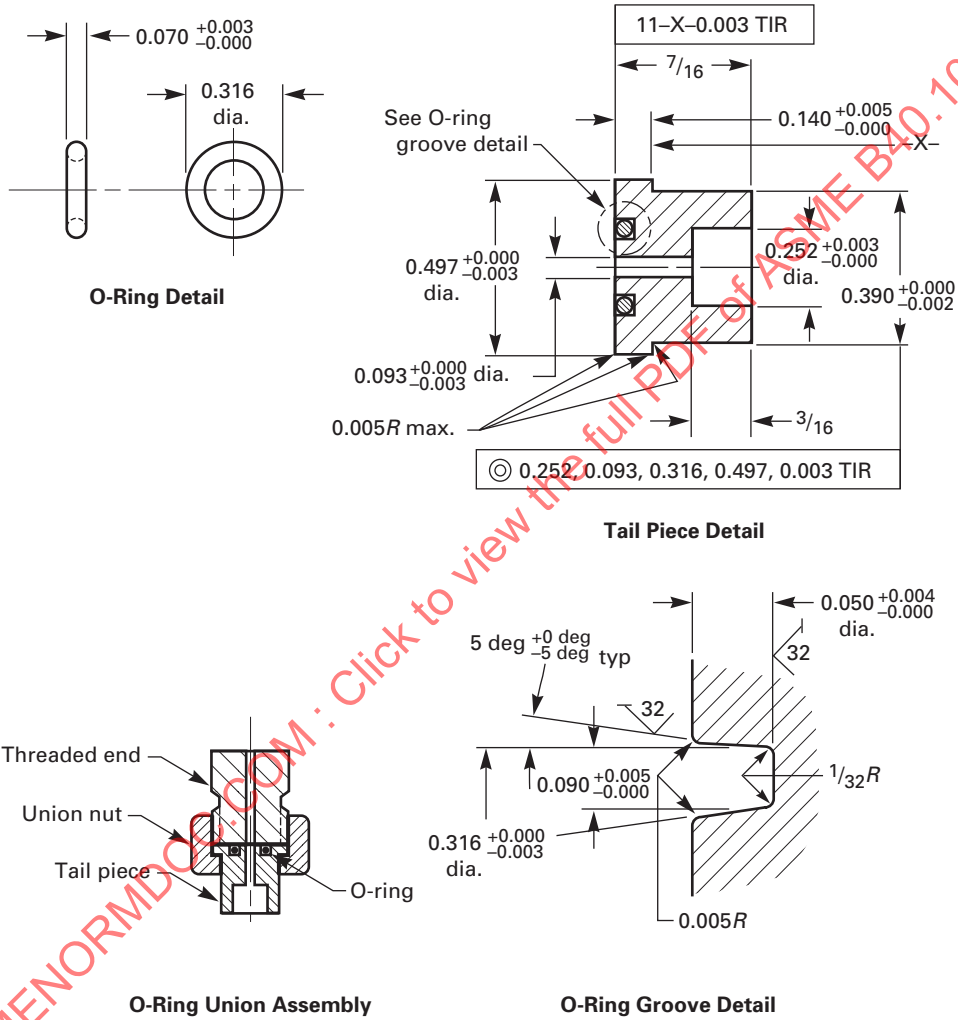
A-2.2.2.1 Composition A. The material for composition "A" shall be copper-nickel alloy in accordance with ASTM B122 and ASTM B151 and may be used for Types 1 through 4.

A-2.2.2.2 Composition B. The material for composition "B" shall be nickel-copper alloy in accordance with ASTM B127, ASTM B164, and ASTM B564, and may be used for Types 1 through 4.

A-2.2.2.3 Composition C. The material for composition "C" shall be corrosion-resistant steel (CRES), Classes 304L (UNS S30403), 316L (UNS S31603), 321 (UNS S32100), or 347 (UNS S34700) and may be used for Types 1 through 3, except oxygen applications. Where the end connections do not require welding, Classes 304 (UNS S30400) or 316 (UNS S31600) are also acceptable.

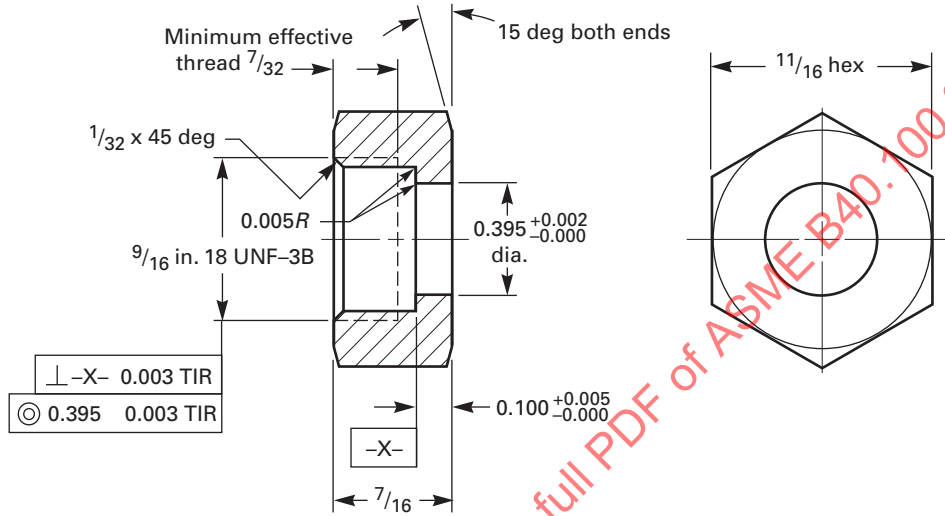
A-2.2.2.4 Composition X. The material for composition "X" is any material, metallic or nonmetallic, used for the snubber body not covered under compositions A through C. Material shall be compatible with the service

Fig. A-1 O-Ring Union Connection

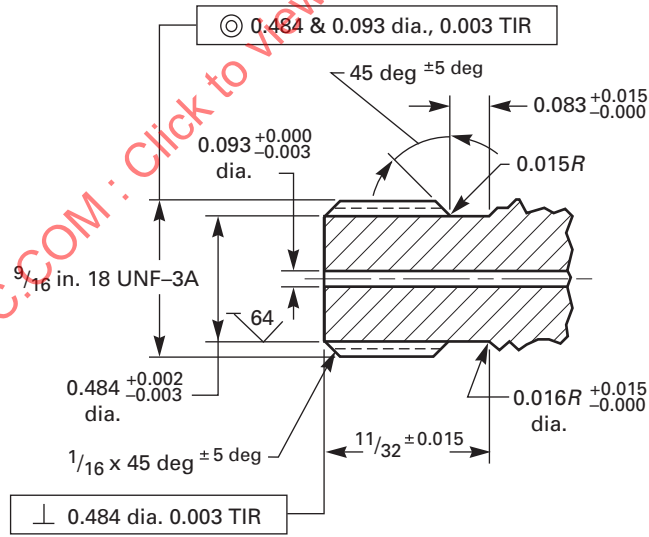


GENERAL NOTE: Dimensions are in inches.

Fig. A-2 O-Ring Union Nut/Threaded End Detail



Union Nut Detail



Threaded End Detail

GENERAL NOTE: Dimensions are in inches.

fluid. For composition "X," material identification shall be included in the snubber marking (see para. A-2.2.4).

A-2.2.2.5 Nonmetallic Materials. Nonmetals shall be moisture and flame resistant, shall not support fungus growth, and shall not be adversely affected by the ambient environments specified in the configuration and performance requirements of this specification. Nonmetals shall not chemically react, degrade, or outgas when subjected to the following:

- (a) air
- (b) distilled water
- (c) seawater
- (d) salt
- (e) petroleum- and silicone-based oils
- (f) oil solvents
- (g) prolonged (greater than 1 mo) periods of exposure to ambient temperatures
- (h) prolonged periods of exposure to elevated temperatures (up to 350°F)
- (i) exposure to prolonged cycling periods from ambient to elevated temperatures

Any material, which provides a nutrient medium for fungus and insects, shall not be used.

A-2.2.2.5.1 O-Ring. O-rings shall be fluorocarbon rubber with SAE AMS 7259, hardness of 85 to 95.

A-2.2.2.6 Porous Metal. Snubbers with a porous metal composition (internal parts and configuration) are prohibited for gas (Type 3) or for seawater (Type 4) service. When used for oil or water (Types 1 and 2) service, snubbers with porous metal compositions shall only be employed in systems with particulate contaminants less than 25 microns in size.

A-2.2.3 Snubber Body Size. The length of the assembled snubber body shall not exceed 4 in. The body shall have hexagonal cross sections of sufficient widths to allow the use of a wrench for installing and removing. The distance across the flats shall not exceed 1.25 in. The maximum diameter of the snubber body shall not exceed 2 in.

A-2.2.4 Marking. Each snubber shall be metal stamped with the following:

- (a) the maximum working pressure, followed by the abbreviation "psi" (e.g., 6,000 psi)
- (b) Part Identifying Number (see para. A-4.2)
- (c) manufacturer's stamp or trademark
- (d) material type (if composition "X" is used)

A-2.2.4.1 Flow Direction. The direction of flow through the snubber shall be indicated by an arrow with the word "sensor" at the point of the arrow. The arrow shall be raised from the surface (0.010 in. min.) or marked into the surface in a permanent manner and to the extent that it can be easily identified by human touch. The

word "sensor" shall be metal stamped or otherwise permanently marked.

A-2.2.4.2 Warning Label. Type 3 snubbers shall have a warning label included on its primary pack marked "oxygen" or "dry nitrogen" service, as applicable for the system use when cleaned for these applications.

A-2.3 Cleaning and Packaging

Surfaces of castings, forgings, molded parts, stampings, machined, and welded parts shall be free of defects such as cracks, porosity, undercuts, voids, and gaps as well as sand, dirt, fins, sharp edges, scale, flux, and other harmful or extraneous materials. External surfaces shall be smooth and edges shall be either rounded or beveled. There shall be no warpage or dimensional change due to heat from welding operations. There shall be no damage to adjacent parts resulting from welding. Unless special cleaning, drying, unit protection, and intermediate packaging are specified, the snubber shall be cleaned, dried, and bagged with boxing in accordance with ASTM D3951.

A-3 VERIFICATION

A-3.1 Responsibility for Inspection

Unless otherwise specified in the contract or purchase order, the manufacturer is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or purchase order, the manufacturer may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the buyer. The buyer reserves the right to perform any of the inspections set forth in the standard where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

A-3.1.1 Responsibility for Compliance. All items shall meet the requirements of sections A-2 and A-3. The inspection set forth in this specification shall become a part of the manufacturer's overall inspection system or quality program. The absence of any inspection requirements in this specification shall not relieve the manufacturer of the responsibility of assuring that all products or supplies submitted to the government for acceptance comply with all requirements of the contract. Sampling inspection, as part of the manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the buyer to accept defective material.

A-3.2 Classification of Inspections

A-3.2.1 Qualification Inspection. Qualification inspection shall consist of examination and tests specified in Table A-1 and shall be performed and passed

Table A-1 Qualification and Conformance Inspections

Inspection	Qualification Inspection	Conformance Inspection
Examination	X	X
Steady-state transmission	X	...
Dampening	X	X
Temperature	X	...
Vibration	X	...
Shock	X	...
Pressure integrity	X	...

prior to production. Qualification inspection shall be performed on samples that have been produced with equipment and procedures normally used in production.

A-3.2.1.1 Sample Size. Two snubber samples of each type, class, and composition shall be subjected to the qualification inspection.

A-3.2.2 Conformance Inspection. Conformance inspection shall be performed at the place of manufacture. Conformance inspection shall consist of the examination and tests specified in Table A-1 and shall be performed on samples selected from each lot.

A-3.2.2.1 Lot. A lot shall consist of all snubbers of the same type, class, composition, and end connection manufactured at one time.

A-3.2.2.2 Sampling. Sample selection shall be in accordance with ANSI/ASQC Z1.4, inspection level I, acceptable quality level (AQL); 1½% nonconformities apply.

A-3.2.2.3 Nonconformity. The AQL for each nonconformity is as shown in Table A-2.

A-3.2.3 Acceptance Criteria. If any snubber sample fails to meet the inspection requirements of Table A-1, no snubbers shall be accepted until the manufacturer has determined the cause of the defect and has taken the necessary action to correct or eliminate the defect from each snubber in the lot. The failed test shall be repeated to demonstrate that the corrective action will enable the snubbers to conform to the requirements of this specification. In addition, the results of previous tests may be deemed invalid, unless the manufacturer can prove to the satisfaction of the buyer that such test would not be adversely impacted by the corrective action.

A-3.3 Test Conditions

Test conditions shall be as specified in the applicable examinations and test procedures.

A-3.4 General Examination

The snubbers shall be subjected to a thorough examination to ascertain that the material, finish, workmanship, construction, assembly, dimensions, and marking are in conformance with the requirements of this specification. Examinations shall be limited to disassembling the snubbers to the extent that the performance, durability, or appearance would not be affected.

A-3.5 Test Procedures and Requirements

Tests shall be conducted as described below. For the dampening test, a storage oscilloscope, oscillographic recorder, or other data acquisition system with a frequency response sufficient to resolve full scale deflections in 10 milliseconds or less shall be used. Input signal resolution shall be 2% or less of full scale. Signals from both the test and monitoring transducers shall be recorded simultaneously (see para. A-3.5.2). With the exception of the dampening test, which requires the use of pressure transducers, all other tests may be monitored with either a pressure transducer or a pressure gauge of suitable range which shall have accuracies of 1% of span or better and shall have an overpressure rating of at least 125% of upper range value. To maintain sufficient accuracy, the maximum upper range limit for any pressure transducer or pressure gauge shall not exceed twice the maximum pressure expected in any test. In addition, controls of the storage oscilloscope, oscillographic recorder, or other data acquisition system should be set that recorded signals are at least 50% of full scale. Except for the dampening tests that require a specific fill fluid, the others may employ fresh water as the fill fluid. If fresh water is used as the fill fluid for the temperature test, provision should be made to employ a suitable additive to prevent freezing. As applicable, the snubber should be thoroughly cleaned prior to conducting the dampening test. The fill fluids for the dampening tests shall be as follows:

- for Type 1, 2190-TEP oil or equivalent
- for Types 2 and 4, fresh water
- for Type 3, air or nitrogen

Unless otherwise indicated, the pressure transducer or pressure gauge shall be connected to the output side of the snubber with only an adapter fitting between them. Except where temperature is a variable, the test in this specification shall be conducted at an ambient temperature of 75°F ±10°F.

A-3.5.1 Steady-State Transmission. A reference measurement shall be made employing either a pressure transducer, or pressure gauge, both with and without a snubber. The reference measurement shall be made both upscale and down scale at the test pressures for the applicable class (see para. A-4.2.3) as shown in Table A-3. The difference in indicated output with and without the snubber under test shall be within the accuracy limits of the pressure instrumentation employed.

Table A-2 AQL for Nonconformities

Categories	Nonconformities	AQL
Critical		
1	Evidence that snubbers for oxygen service are not cleaned, improperly marked, or improperly packaged.	0
2	Snubber does not meet the pressure integrity.	0
Major		
101	Evidence of unauthorized material.	0
102	Inspection systems are not provided, dimensional tolerances not maintained, mounting dimensions not interchangeable, pressure connection wrong design, or dimensions erroneous.	0
103	Snubber does not meet steady state transmission or dampening.	0
104	Markings not provided or erroneous; part number not provided.	0
Minor		
202	Evidence that snubber for nonoxygen service are not cleaned.	1½
203	Finish non-conforming, scratched, chipped; burrs not removed.	4
204	Cleaning, drying, preservation, packaging, or packing.	4

Table A-3 Steady-State Transmission Pressures

Snubber Class (See Para. A-4.2.3)	Operating Range Upper Limit, psi	Test Pressures, psi
L	10/1,000	10; 250; 500; 750; 1,000
H	1,001/6,000	1,200; 2,400; 3,600; 4,800; 6,000

A-3.5.2 Dampening. The dampening test shall be conducted using an apparatus similar to that shown on Fig. A-3. A step change shall be made from atmospheric pressure to 200 psi \pm 10 psi for Class L snubbers and from atmospheric pressure to 1,500 psi \pm 100 psi for Class H snubbers. The pressure step change shall be accomplished in 100 milliseconds or less as measured with the monitoring pressure transducer. Both the test and monitoring pressure transducers shall have frequency response characteristics sufficient to respond to and produce an electrical signal output in response to a full-scale pressure change occurring in 10 milliseconds or less. The pressure as indicated by the test pressure transducer shall satisfy the following criteria:

(a) Indicate a pressure of 25% or less of the final steady-state pressure at a time equal to that at which the monitoring pressure transducer initially reaches its step pressure level.

(b) Reach at least 90% of its final steady-state pressure in not more than 2.5 sec after initiation of the pressure step as indicated by the monitoring transducer.

A-3.5.2.1 Procedure. The following procedure, applicable to Fig. A-3, may be used to perform the dampening test:

(a) Ensure that V2 and V4 are closed and that V3 is open.

(b) Utilizing V3, introduce the fill fluid, as applicable in the monitoring and test transducer legs. Loosen the fittings at T1 and T2 to ensure a complete fill. Tighten all transducer fittings and close V3 after the fill procedure is complete.

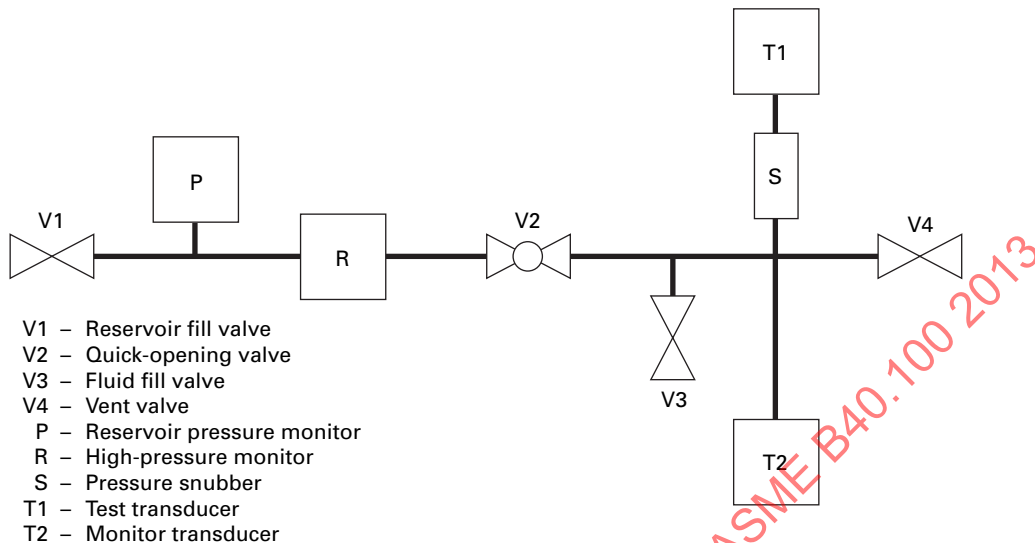
(c) Utilizing V1, pressurize the high pressure reservoir with nitrogen to a value sufficient to ensure that the pressure step change in the transducer legs will satisfy the criteria of para. A-3.5.2. Close V1.

(d) Energize the transducers and applicable monitoring equipment, and actuate V2.

(e) After steady state has been achieved, close V2 and relieve the test pressure by opening V4.

(f) As applicable, thoroughly clean the entire dampening apparatus to remove residual traces of the fill fluid.

Fig. A-3 Suggested Dampening Test Set-Up



A-3.5.3 Temperature

A-3.5.3.1 High Temperature. Place the snubber in an environmental chamber and pressurize the snubber to 250 psi \pm 10 psi for a Class L snubber and 1,500 psi \pm 50 psi for a Class H snubber. Increase the chamber temperature from ambient to 150°F \pm 5°F in not less than 1 hr. Adjust the pressure as necessary to maintain the required pressure. Maintain the pressure and temperature conditions for a minimum of 4 hr. Reduce the chamber to ambient temperature in not less than 1 hr. Remove the snubber from the chamber. Allow it to remain at ambient temperature for at least 1 hr. The snubber shall show no evidence of leakage or damage and shall meet the dampening requirement of para. A-3.5.2 after the high temperature test.

A-3.5.3.2 Low Temperature. Place the snubber in an environmental chamber and pressurize the snubber to 250 psi \pm 10 psi for a Class L snubber and 1,500 psi \pm 50 psi for a Class H snubber. Decrease the chamber temperature from ambient to 40°F \pm 5°F in not less than 1 hr. Adjust the pressure as necessary to maintain the required pressure. Maintain the pressure and temperature conditions for a minimum of 4 hr. Increase the chamber to ambient temperature in not less than 1 hr. Remove the snubber from the chamber and allow it to remain at ambient temperature for at least 1 hr. The snubber shall show no evidence of leakage or damage and shall meet the dampening requirement of para. A-3.5.2 after the low temperature test.

A-3.5.3.3 Temperature Cycling. Place the snubber in an environmental chamber. The snubber shall remain unpressurized during the temperature cycling. The test shall consist of four complete cycles (steps 1 through 4),

as shown in Table A-4. After completion of the fourth cycle, the snubber shall be removed from the chamber and allowed to stabilize at ambient conditions for at least 1 hr. The snubber shall show no evidence of leakage or damage and shall meet the dampening requirement of para. A-3.5.2 after the temperature cycling test.

A-3.5.4 Vibration. The snubber shall be tested in accordance with Type I (environmental) vibration of MIL-STD-167-1 except that the upper frequency shall be 175 Hz; the amplitude of vibration shall be in accordance with Table A-5; and for the variable frequency portion, the vibration level shall be maintained for 2 min at every integral value of frequency. If no resonances are observed, the 2-hr endurance test shall be conducted at 175 Hz. If a particular snubber is determined to be axisymmetric, then the vibration test need only be conducted along the two mutually perpendicular axes. The snubber shall be pressurized to 250 psi \pm 10 psi for a Class L snubber and 1,500 psi \pm 50 psi for a Class H snubber and monitored throughout the test. After this test, the snubber shall show no indication of leakage or damage and shall meet the dampening requirement of para. A-3.5.2.

A-3.5.4.1 Fixture. The snubber shall be connected to the outlet side of an instrument cutoff valve. The valve and snubber assembly shall be mounted to a vertical panel of the vibration fixture. A flexible hose shall be used to connect the pressure source to the inlet side of the instrument cutoff valve. A flexible hose shall be used to connect a pressure monitor (gauge or transducer) to the test connection port located in the stem of the instrument cutoff valve. Flexible pressure hoses shall be of sufficient length so as to not interfere with the vibration fixture and shall have appropriate pressure ratings.

Table A-4 Temperature Cycle

Step	Temperature Condition	Duration
1	Increase temperature [Note (1)] from 75°F ± 5°F to 150°F ± 5°F	1 hr
2	Constant temperature of 150°F ± 50°F	22 hr [Note (2)]
3	Decrease temperature to – 10°F ± 5°F	2 hr
4	Constant temperature of – 10°F ± 5°F	22 hr [Note (2)]
5	Increasing temperature to 75°F ± 5°F [Note (3)]	1 hr

NOTES:

- (1) Ambient temperature for the first cycle.
- (2) Minimum duration.
- (3) Ambient temperature for the last cycle.

Table A-5 Vibratory Displacement Criteria

Frequency Range, Hz (Inclusive)	Table Displacement, in. (Peak-to-Peak)	
	Exploratory Test	Variable Frequency Test
5 to 20	0.020 ± 0.004	0.060 ± 0.012
21 to 50	0.010 ± 0.002	0.040 ± 0.008
51 to 100	0.003 ± 0.0006	0.020 ± 0.004
101 to 175	0.001 ± 0.0002	0.003 ± 0.0006

After filling and pressurizing the system, the snubber and pressure monitor shall be isolated from the pressure source by means of the instrument cutoff valve. Test fixturing shall replicate typical shipboard installation.

A-3.5.5 Shock. A lightweight shock test shall be conducted in accordance with MIL-S-901 for Grade A, Class 1, Type A equipment. A total of nine blows shall be applied, three blows applied parallel to each axis of the snubber. The snubber shall be pressurized to 250 psi ± 10 psi for a Class L snubber and 1,500 psi ± 50 psi for a Class H snubber and monitored throughout the test. The snubber shall show no indication of leakage or damage and shall meet the dampening requirements of para. A-3.5.2.

A-3.5.5.1 Fixture. The snubber shall be connected to the outlet side of an instrument cutoff valve. The valve and snubber assembly shall be mounted to a vertical panel of a type 6D-1 adapter plate. A flexible hose shall be used to connect the pressure source to the inlet side of the instrument cutoff valve. A flexible hose shall be used to connect a pressure monitor (gauge or transducer) to the test connection port located in the stem of the instrument cutoff valve. Flexible pressure hoses shall be of sufficient length so as to not interfere with the shock fixture and shall have appropriate pressure ratings. After filling and pressurizing the system, the snubber and pressure monitor shall be isolated from the pressure source by means of the instrument cutoff valve. Test fixturing shall replicate typical shipboard installation.

A-3.5.6 Pressure Integrity. Pressurize the Class L snubber to 1,500 psi and the Class H snubber to 9,000 psi. Isolate the pressurized snubber from the pressure source and monitor the snubber pressure with the appropriate range pressure transducer or pressure gauge. Maintain the pressure for a period of 1 hr. After this test, the snubber shall show no evidence of leakage or damage and shall meet the dampening requirements of para. A-3.5.2.

A-4 ORDERING PARAMETERS

A-4.1 Acquisition Requirements

Acquisition documents should specify the following:

- (a) title, number, and date of this specification
- (b) Part Identifying Number (PIN)
- (c) when qualification is required
- (d) special marking

A-4.2 Part Identifying Number (PIN) Parameters

The parameters for PIN are as follows:

- (a) Type
- (b) Class
- (c) composition
- (d) end connection
- (e) cleanliness

A-4.2.1 Part Identifying Number (PIN) Format. The PINs to be used for items acquired to this supplement shall be created as follows:

EXAMPLE: B40.5A1-1LCPG

B40.5A1	1	L	C	P	G
Precedes classification	Type	Class	Composition	End connection	Cleanliness

A-4.2.2 Types. The type of service in which the snubber will be used shall be designated by one of the following numbers and shall be selected based on the expected fluid and fluid temperature (viscosity) at the snubber location.

Type	Service
1	Oil, hydraulic fluid above 20 centistokes at operating temperature. Oil above 225 saybolt universal seconds at operating temperatures
2	Fresh water, steam, gasoline, light oils below 20 centistokes at operating temperature
3	Gases
4	Seawater

A-4.2.3 Class. The range of operating pressures is designated by a single character.

Class	Operating Range Limit, psi
L	10 to 1,000
H	1,001 to 6,000

A-4.2.4 Composition. The material composition of the snubber is designated by one letter.

Composition	Material
A	Copper nickel alloy (see para. A-2.2.2.1)
B	Nickel-copper alloy (see para. A-2.2.2.2)
C	Corrosion resisting steel (see para. A-2.2.2.3)
X	Other (see para. A-2.2.2.4)

A-4.2.5 End Connection. The configuration for the snubber's end connection is designated by a single character.

End Connection	Application
P	Pressure gauge O-ring union (see para. A-2.1.1.1)
F	Pressure gauge flareless [Bite type (see para. A-2.1.1.2)]
T	Pressure transducer (see para. A-2.1.1.3)
S	Other. The end connections must be specified in the contract or ordering data.

A-4.2.6 Cleanliness. The level of cleanliness of the snubber is designated by a single character. Cleaning for oxygen applications shall be in accordance with MIL-STD-1330. Cleaning for general applications shall be in accordance with Cleanliness Level IV, Table 2 of ASME B40.1.

Cleanliness	Application
G	General
X	Oxygen and dry nitrogen

A-5 REFERENCES

ANSI/ASQC Z1.4, Sampling Procedures and Tables for Inspection by Attributes

Publisher: American National Standards Institute (ANSI), 25 West 43rd Street, New York, NY 10036 (www.ansi.org)

ASTM B122, Standard Specification for Copper-Nickel-Tin Alloy, Copper-Nickel-Zinc Alloy (Nickel Silver), and Copper-Nickel Alloy Plate, Sheet, Strip, and Rolled Bar

ASTM B127, Standard Specification for Nickel-Copper Alloy (UNS N04400) Plate, Sheet, and Strip

ASTM B151, Standard Specification for Copper-Nickel-Zinc Alloy (Nickel Silver) and Copper-Nickel Rod and Bar

ASTM B164, Standard Specification for Nickel-Copper Alloy Rod, Bar, and Wire

ASTM B564, Aluminum and Aluminum-Nickel Alloy Forgings

ASTM D3951, Standard Practice for Commercial Packaging

Publisher: American Society for Testing and Materials (ASTM International), 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959 (www.astm.org)

MIL-S-901, Shock Tests, High Impact, Shipboard Machinery, Equipment and Systems Requirements

MIL-STD-167-1, Mechanical Vibrations of Shipboard Equipment (Type I — Environmental and Type II — Internally Excited)

MIL-STD-1330, Standard Practice for Precision Cleaning and Testing of Shipboard Oxygen, Helium, Helium-Oxygen, Nitrogen and Hydrogen Systems

Publisher: Federal specifications available from: Superintendent of Documents, U.S. Government Printing Office (GPO), 732 N. Capitol Street, NW, Washington, DC 20401 (www.gpoaccess.gov/index.html)

SAE AMS 7259, Rings, Sealings, Fluorocarbon (FKM) Rubber High-Temperature-Fluid Resistant Very-Low Compression Set 85 to 95

SAE J 1926, Connections for General Use and Fluid Power — Ports and Stud Ends with ISO 725 Threads and O-Ring Sealing — Part 1: Threaded Port with O-Ring Seal in Truncated Housing

Publisher: Society of Automotive Engineers (SAE International), 400 Commonwealth Drive, Warrendale, PA 15096 (www.sae.org)

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ASME B40.6

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PRESSURE LIMITER VALVES

1 SCOPE

This Standard (B40.6) is confined to devices that protect pressure-sensing instruments from pressure sources in the event of system pressure rising above the adjusted closing pressure of the device. These devices are not pressure regulators. Pressure limiter valves are designed only to prevent the passage of excessive pressure to downstream pressure-sensing instruments. Hereafter, pressure limiter valves may be referred to as “devices.”

2 PRESSURE LIMITER VALVES, GENERAL

2.1 Purpose

Pressure limiter valves are used to protect pressure-sensing instruments against damage, loss of accuracy, and/or rupture in the event of excessive system pressure.

2.2 Principle of Operation

Generally, these devices consist of the following components:

- (a) body with inlet and outlet ports, designed to contain maximum system design pressure
- (b) pressure-sensing element
- (c) range spring
- (d) mechanism for sealing or isolating the outlet port from the inlet port

The pressure-sensing element has system pressure working against an adjustable range spring. The range spring holds the sealing mechanism in the open position, allowing system pressure into the instrument. Increasing load on the adjustable range spring increases closing pressure, and decreasing the load lowers closing pressure. As system pressure overcomes the force of the range spring, the pressure-sensing element moves, causing the sealing mechanism to close. With the sealing mechanism closed, the outlet side is isolated from increasing system pressure and the instrument is protected. As system pressure drops to the reopening pressure of the pressure limiter valve, the sealing mechanism opens and allows transmission of system pressure back into the instrument.

2.3 Pressure Limiter Valve Terminology

closing range: the minimum and maximum values of closing pressure.

element, pressure-sensing: the element that, in conjunction with a range spring, converts a pressure change into motion.

environment: the conditions external to the device, including weather, temperature, humidity, salt spray, vibration, corrosive atmosphere, and other similar conditions, that could affect the performance of the device.

medium: the process fluid (gas or liquid).

pressure, burst: the maximum pressure, above which a device may no longer hold pressure.

pressure, closing: the system pressure at which the sealing mechanism closes, isolating the pressure-sensing instrument from rising system pressure.

pressure, maximum inlet: the maximum pressure that can be applied to the inlet port of a pressure limiter valve continually or repeatedly without degradation in the performance of the valve.

pressure, maximum working: maximum inlet pressure; see *pressure, maximum inlet*.

pressure, over-range: the maximum pressure differential between inlet and outlet ports for a given closing pressure. This pressure may be continuously or repeatedly applied without degradation in performance. It may be expressed as a pressure or as a percentage of the closing pressure above the closing pressure.

pressure, proof: the pressure a device can withstand without degradation in performance. Repeated application of proof pressure may be destructive.

pressure, reopening: the system pressure at which a closed sealing mechanism reopens, generally expressed as a percentage of closing pressure.

pressure, rupture: the pressure differential between inlet and outlet ports at which the device may no longer limit pressure.

pressure-sensing instrument: instrument being protected by the pressure limiter valve.

pressure, set: closing pressure; see *pressure, closing*.

pressure, system: the pressure of the process medium at the inlet pressure connection.

pulsation: a periodic surge.

range spring: the spring against which the pressure-sensing element works. Changing the load on the range spring changes the closing pressure.

rate of pressure change: pressure change per time interval.

repeatability of closing pressure: the maximum difference between a number of consecutive closing pressures for the same applied rate of pressure change under the