



- Leak Testing -

INTEGRATED SYSTEMS FOR: HYDRAULIC AND PNEUMATIC PARTS

Specialist in leak testing since 1973



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TESTING HYDRAULIC AND PNEUMATIC PARTS

Nolek has extensive experience constructing systems to leak test a wide variety of parts and products within the hydraulic and pneumatic industry. In addition, we have gained a lot of knowledge working with both Bosch Rexroth and Sauer-Danfoss, two prominent industry manufacturers. The machines we have built test, for example: different types of hydraulic and pneumatic components, valves, hydraulic motors, cylinders, all types of tubing, pipes and couplings, different types of water mixers, outboard drives, compressors, pressure tanks, bottle gas tanks, WC flushing mechanisms, and different types of jacks.



Measuring method: Helium based or Pressure decay
Leak rate range: 10^{-3} cm³/sec to 10^{-7} cm³/sec
Cycle times: from 8 seconds and up
Helium consumption: Depending on mix with air
Automatic calibration
Compact design
Available in/with single or double chamber/tooling



Description of procedure:

1. The part to be tested is manually or automatically loaded in the test chamber and is connected with the fixture.
2. The test chamber is then closed and evacuation in the vacuum chamber begins.
3. Then we measure if there is a pressure change inside the product. If in the first moments a pressure change is detected in the product, it is declared as having a "Gross leak".
4. If the test is ok, we evacuate the product and if we do not reach vacuum in the estimated time it will also be declared to have a Gross leak.
5. If the two first tests are ok and we have reached vacuum in the chamber we connect the helium leak detector to the chamber and conduct a background check in the chamber. The background check is carried out to guarantee that we have no helium in the surrounding atmosphere before we fill the product with helium. Helium filling is split up in two steps; first step we add a small amount of helium and check for gross leak with helium, second step we fill up to the specified pressure.
6. If the product has a leak the helium leak detector will detect it. The detector measure continuously from the background check and onwards.
7. After the test the product will be evacuated to atmospheric pressure.
8. If there was a leak with a manual system, the chamber will stay closed until the operator has pressed the reset button. If the system is automatic the machines separates leaking products from not leaking ones.
9. During the test cycle there is off course a lot more sequences e.g. to remove helium, flush chambers etc. to always keep a clean atmosphere in the surrounding area and in the machine.
10. If it is a manual machine helium can remain in the part if there is a leak and the chamber will open and you can conduct a manual leak search.