



# AEROSPACE MATERIAL SPECIFICATION



AMS 2601G

Issued JUN 1940  
Revised MAY 1994  
Cancelled FEB 2004

Superseding AMS 2601F

Pressure Testing, Gaseous Media  
10 psi

## CANCELLATION NOTICE

This specification has been declared "CANCELLED" by the Aerospace Materials Division, SAE, as of February, 2004, and has been superseded by AMS 2610 using a test pressure of 10 to 15 psi. The requirements of the latest issue of AMS 2610 using a test pressure of 10 to 15 psi shall be fulfilled whenever reference is made to the cancelled AMS 2601. By this action, this document will remain listed in the Numerical Section of the Index of Aerospace Material Specifications noting that it is superseded by AMS 2610 using a test pressure of 10 to 15 psi.

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## 1. SCOPE:

This specification provides requirements and procedures for gas-pressure leak testing of parts.

1.1 MAM 2601 is the metric version of this AMS.

## 2. APPLICABLE DOCUMENTS:

There are no referenced publications specified herein.

## 3. TECHNICAL REQUIREMENTS:

### 3.1 Equipment:

3.1.1 Fixtures: Test fixtures shall not seal off areas of possible leakage or create excessive stresses on parts.

3.1.2 Gaskets: Suitable gasket material shall be used with plugs or blanking plates to prevent damage to finished surfaces.

3.1.3 Valves: Bleeder valves shall be provided to release entrapped gas.

3.1.4 Gauges: Pressure gauges shall have sufficient dial divisions to permit monitoring of specified pressure.

3.1.5 Compressed Gas Source: The source of compressed gas shall provide the required pressure and shall be equipped with a pressure regulator to control the pressure.

3.1.6 Safety Tank or Screen: A suitable tank or screen shall be provided to protect the operator in case of failure of a part.

3.1.7 Drying Oven: A circulating-air oven is required for drying parts subject to corrosion.

### 3.2 Test Media:

Shall be compressed gas for applying internal pressure to the part. In addition, a tank of tap water or other transparent liquid shall be provided for parts tested by immersion or liquid soap solution shall be used on parts not immersed during test.

### 3.3 Preparation:

3.3.1 Cleaning: The part shall be thoroughly cleaned before testing so that any leaks will be visible. Loose particles, machine shop chips, oils, and other foreign materials shall be removed before pressure testing.

- 3.3.2 Processes: The part or subassembly shall be tested following all machining, forming, straightening, welding, brazing, anodizing, etc, and prior to application of protective finishes such as paint, plating, coating, or surface finishes that may mask or blank off areas of possible leakage.
- 3.3.3 Preliminary Tests: Tests may be performed at any stage of manufacture in order to establish in-process integrity.
- 3.3.4 Material Removal: Sand blasting, pickling, or any other operation which may remove metal from surfaces shall be done before final pressure tests.

#### 3.4 Procedure:

All parts to be tested shall be fitted up for test and, while subjected internally to a gas pressure of 10 to 15 psi, shall be submerged in tap water or other transparent liquid or shall have the surfaces to be tested completely coated with liquid soap solution.

- 3.4.1 Duration: Parts shall be held at the specified pressure for not less than three minutes to permit complete visual inspection while at the specified pressure.
- 3.4.2 Cleaning: Parts, which have been tested under tap water or other transparent liquid, shall be cleaned and dried, immediately after test, to prevent corrosion due to entrapment of moisture. Visible moisture shall be removed by air blast. Parts containing areas of entrapment and all magnesium parts shall be dried in a circulating-air oven at  $250^{\circ}\text{F} \pm 25$  for at least one hour.
- 3.4.3 Orientation: The part shall be exposed to permit overall visual inspection during static pressure application.

#### 3.5 Acceptance Standards:

- 3.5.1 Parts shall not leak under pressure. The effect of any slight leakage of parts shall be considered by cognizant personnel and the parts accepted, repaired, or rejected.
- 3.5.2 The effect of any leakage of parts, other than as in 3.5.1, shall be reviewed by cognizant engineering organization and parts repaired and retested or rejected.
- 3.5.3 If slight leakage appears in a line, as if indicating a crack or a cold shut, the part shall be rejected.
- 3.5.4 Magnesium alloy castings which leak in a 2-inch diameter area more than 180 mL of gas per minute shall be rejected but those that leak less may be impregnated, when so specified, and the method to be used is approved by purchaser.
  - 3.5.4.1 Those sections of magnesium alloy castings, impregnated or not, which leak in a 2-inch diameter area less than 40 mL of gas per minute are acceptable unless the leakage is into the induction system of parts or through an external surface, in which case leakage is not desirable but acceptable to the extent of 0.1 mL of gas per minute in a 2-inch diameter area.