



## Procedure 4001: Hydrostatic Testing

effective 02/08

### Process

- 1. Identify test requirements. Refer to Procedure 4000: General Hydrostatic Testing Information (page 60).
- 2. Lay the assembly in a straight line.
- 3. Install test caps or test plugs on both ends.
- 4. Connect a bleed-off valve to one end.
- 5. Connect test pump's intermediate hose (minimum 15 ft length) to the other end.
- 6. Position the pump at a 90° angle to the test sample and as far away as possible.
- 7. Elevate the end with the bleed-off valve and open the valve.
- 8. Fill the assembly with water.
- 9. Purge the air and close bleed-off valve.  
*Caution!* Make certain all air is removed! 
- 10. Secure the ends to prevent damage in the event of an accidental coupling separation.
- 11. Activate the pump until the prescribed test pressure is achieved.  
*Warning!* Do not allow anyone to stand near the ends of the assembly while it is under pressure. 
- 12. Hold test pressure for the prescribed length of time.
- 13. Check for leaks and/or coupling movement.
- 14. Turn off the test pump and the water supply.
- 15. Use the bleed-off valve (either on the test pump or connected to the test sample) to relieve pressure.
- 16. Remove test fixtures, drain water, and inspect assembly. Reference Procedure 3005: General Assembly Inspection (page 55).
- 17. If the assembly passed the hydrostatic test (did not leak and the coupling(s) did not move):
  - a. Complete the test report. Test reports can be supplied by the hose manufacturer, coupling manufacturer, or may be self-generated.
  - b. Tag or mark the assembly with all necessary information such as distributor name, date of assembly, test date, test pressure, assembly working, and primary assembly service (air, water, oil, etc).
  - c. Prepare the assembly for shipment.
- 18. If the assembly failed the hydrostatic test (leaked or the coupling(s) moved during the test):
  - a. Re-tighten or reinstall the couplings.
  - b. Retest the assembly.
  - c. Continue this process until the assembly does not leak and the couplings do not move. This may require installing different couplings that are better suited for the intended assembly working pressure.