

15. Procedure

15.1 Assemble the test system and determine the system volume (see [Annex A3](#)). An isolation valve should be used between the test vessel and test system for isolation purposes.

15.2 Perform a leak test of the test system with the isolation valve closed and ensure that the leakage of the test system is less than 1 % of the target test value for the test vessel.

15.3 Determine the test parameters (initial pressure and test time) and calculate the test resolution and accuracies according to [Annex A1](#) and [Annex A2](#). Ensure that the calculated test resolution is at least ten times less than the target leakage rate. Ensure that the test accuracy is at least four times less than the target leakage rate.

15.4 Pressurize the vessel to the target pressure and close the isolation valve 2.

15.5 *Stabilization Time (Setting Time)*—After pressurization, the temperature and pressure should be monitored as a function of time over the test duration previously established in 5.1. The pressure should be recorded at a minimum of ten time intervals during the test sequence. The temperature should be recorded at the beginning and end of the test to ensure that the temperature is stable to within the previously assumed limits. Illustrative pressure decay leak test data is shown in [Fig. 2](#). During the charge phase, gas is added to the test system. The pressure in the test system will naturally decay due to a number of factors (pressure equilibrating within the test system, gas temperature equilibrating, and so forth). The settling time will be dependent on the geometry of the test system, the test pressures, filling times, type of gas used, and other environmental factors.

The leak rate should be calculated from the individual measurements with the following equations:

$$N = (\Delta PV)/(RT (\Delta t)), \text{mol/s} \quad (1)$$

$$N = ((\Delta PV)/(\Delta t))(T_R/T), \text{Pa} \cdot \text{m}^3/\text{s}, \text{ or Std cc/s} \quad (2)$$

where:

- V = the vessel volume
- R = the universal gas constant 8.3144 J/mol K (8.3144 Pa m³/(mol K))
- T = the vessel temperature, K
- T_R = the reference temperature for the units (typically 273.15 K)
- ΔP = the change in pressure between successive points
- Δt = the change in time in seconds between successive points

Examples are provided in [Eq 3](#) and 4

where:

- ΔP = 10000 Pa (0.1 atm)
- V = 0.0001 m³
- Δt = 100 sec.
- T_R = 273.15
- T = 298 K

$$N = \frac{(10000 \text{ Pa}) \cdot (0.0001 \text{ m}^3) \cdot 273.15 \text{ K}}{100 \text{ s} \cdot 298 \text{ K}} = 9.3 \times 10^{-7} \text{ Pa} \cdot \text{m}^3/\text{s} \quad (3)$$

$$N = \frac{(0.1 \text{ atm}) \cdot 100 \text{ cm}^3 \cdot 273.15 \text{ K}}{100 \text{ s} \cdot 298 \text{ K}} = 9.3 \times 10^{-7} \text{ Std cm}^3/\text{s} \quad (4)$$

15.6 Depending upon the test conditions, it may require seconds to hours for the indicated leak rate to stabilize. Stabilization criteria should be based on point to point variations in the measured leak rate with a target of less than three times the calculated test resolution. The test data used in the leak calculation in [Section 16](#) will utilize data collected after stabilization.

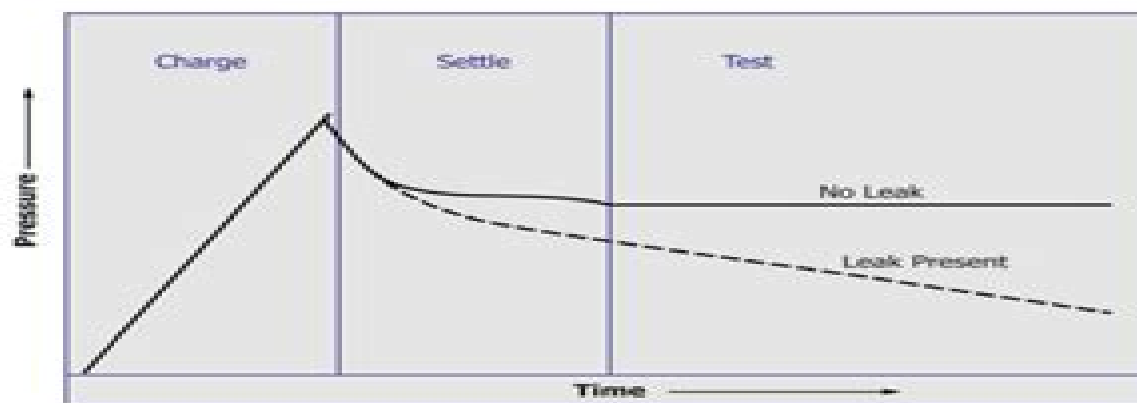


FIG. 2 Illustration of Pressure Decay Test Data

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