

**Screw Compressor Standard Inspection Procedures**  
**Document No. SCSD-009-02**  
**Gas Leak Test**

**Moriya Plant, Mayekawa Mfg. Co., Ltd.**

02	2016/11/21	Iisaka	Sasaki	Kawasaki	Title changed
01	2011/07/01	Sasaki	Ikehara	Shozu	Review and revised
00	2006/6/5	Ikehara	Amada	Koizumi	Newly created
Revision	Date	Created by	confirmed by	Approved by	Description

## Gas Leak Test

### 1. Scope

This procedure defines the gas leak test performed at Moriya Plant, by the Compressor Manufacturing Division.

### 2. Gas Leak Test

#### 2.1 Test procedure

The gas leak test should be performed after the hydrostatic test.

The gas leak test is performed under the conditions shown in Table-1 by submerging the compressor under water for 30 minutes.

Table-1

Design pressure	2.6MPaG
Test pressure	2.6MPaG

Note: Two pressure gauges are used.

The test pressure is the same as the design pressure.

The gas used for the gas leak test is dry air as standard.

### 3. Acceptance Criteria

The acceptance criterion is a visual inspection to ensure no air bubbles are evident.

### 4. Records

The test results are recorded in Appendix-1:Hydrostatic & Gas Leak Tests Report.

SAMPLE

Appendix-1:Hydrostatic &amp; Gas Leak Tests Report

**MYCOM**

Report No. 0

**Hydrostatic & Gas Leak Test Report**

<b>Item No.</b>	-
<b>Type of Compressor</b>	<b>Screw Compressor</b>
<b>Compressor Model No.</b>	<b>0</b>
<b>Compressor Serial No.</b>	<b>0</b>

**TEST RECORD**

Item	Design Pressure MPaG	Test Pressure MPaG	Used Fluid	Hold Time(Min)	Tested Date	Judgment
Hydrostatic test	2.6	3.9	OIL	30		Accepted
Gas Leak test	2.6	2.6	Air	30		Accepted

**USED PRESSURE GAUGES**

Item	Dia × Max. Pres. MPa.G	Manufacturer	Class(JIS)	No.
Hydrostatic test	φ 100 × 7.0	NAGANO	1.5	1, 2
Gas Leak test	φ 100 × 5.0	NAGANO	1.5	3, 4

Note :

No.	Registration No.	Terms of validity
1	AA-70105	Feb,2017
2	AA-70107	Feb,2017
3	AA-50005	Oct,2016
4	AA-50006	Oct,2016

SURVEYOR

Checked by : \_\_\_\_\_

Approved by : \_\_\_\_\_

MAYEKAWA MFG. CO.,LTD Moriya Plant