

Road vehicles — Cleanliness of components of fluid circuits —

Part 3: Method of extraction of contaminants by pressure rinsing

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National foreword

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This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

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**Road vehicles — Cleanliness of
components of fluid circuits —**

Part 3:

**Method of extraction of contaminants by
pressure rinsing**

*Véhicules routiers — Propreté des composants des circuits de fluide —
Partie 3: Méthode d'extraction des contaminants par aspersion*



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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 16232-3 was prepared by Technical Committee ISO/TC 22, *Road vehicles*, Subcommittee SC 5, *Engine tests*.

ISO 16232 consists of the following parts, under the general title *Road vehicles — Cleanliness of components of fluid circuits*:

- *Part 1: Vocabulary*
- *Part 2: Method of extraction of contaminants by agitation*
- *Part 3: Method of extraction of contaminants by pressure rinsing*
- *Part 4: Method of extraction of contaminants by ultrasonic techniques*
- *Part 5: Method of extraction of contaminants on functional test bench*
- *Part 6: Particle mass determination by gravimetric analysis*
- *Part 7: Particle sizing and counting by microscopic analysis*
- *Part 8: Particle nature determination by microscopic analysis*
- *Part 9: Particle sizing and counting by automatic light extinction particle counter*
- *Part 10: Expression of results*

Introduction

The presence of particulate contamination in a fluid system is acknowledged to be a major factor governing the life and reliability of that system. The presence of particles residual from the manufacturing and assembly processes will cause a substantial increase in the wear rates of the system during the initial run-up and early life, and may even cause catastrophic failures.

In order to achieve reliable performance of components and systems, control over the amount of particles introduced during the build phase is necessary, and measurement of particulate contaminants is the basis of control.

The ISO 16232 series has been drafted to fulfil the requirements of the automotive industry, since the function and performance of modern automotive fluid components and systems are sensitive to the presence of a single or a few critically sized particles. Consequently, ISO 16232 requires the analysis of the total volume of extraction liquid and of all contaminants collected using an approved extraction method.

The ISO 16232 series has been based on existing ISO International Standards such as those developed by ISO/TC 131/SC6. These International Standards have been extended, modified and new ones have been developed to produce a comprehensive suite of International Standards to measure and report the cleanliness levels of parts and components fitted to automotive fluid circuits.

This part of ISO 16232 defines procedures for the removal and collection of contaminants from components by rinsing with a jet of test liquid so that their cleanliness can be evaluated.

The cleanliness level of a component, as determined according to this method, depends to a large extent on the test parameters (e.g. rinsing pressure, volume of liquid, type of jet). All parameters should be included in the cleanliness specification and in the inspection document and should be rigorously followed by the test staff.

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Road vehicles — Cleanliness of components of fluid circuits —

Part 3:

Method of extraction of contaminants by pressure rinsing

1 Scope

This part of ISO 16232 describes the principles of extraction of contaminants from a component by pressure rinsing. It is preferably applied to components of which the surface to be examined is accessible by a jet of test liquid.

This method can be employed on its own or in association with other methods of extraction described in the ISO 16232 series.

Unless otherwise specified, this part of ISO 16232 deals with particulate contamination only. It does not, therefore, cover appearance defects or contamination by liquid or gaseous materials. It covers the amount and the nature of residual particles resulting from manufacturing processes and from the environment.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 16232-1, *Road vehicles — Cleanliness of components of fluid circuits — Part 1: Vocabulary*

ISO 16232-2, *Road vehicles — Cleanliness of components of fluid circuits — Part 2: Method of extraction of contaminants by agitation*

ISO 16232-4, *Road vehicles — Cleanliness of components of fluid circuits — Part 4: Method of extraction of contaminants by ultrasonic techniques*

ISO 16232-5, *Road vehicles — Cleanliness of components of fluid circuits — Part 5: Method of extraction of contaminants on functional test bench*

ISO 16232-6, *Road vehicles — Cleanliness of components of fluid circuits — Part 6: Particle mass determination by gravimetric analysis*

ISO 16232-7, *Road vehicles — Cleanliness of components of fluid circuits — Part 7: Particle sizing and counting by microscopic analysis*

ISO 16232-8, *Road vehicles — Cleanliness of components of fluid circuits — Part 8: Particle nature determination by microscopic analysis*

ISO 16232-9, *Road vehicles — Cleanliness of components of fluid circuits — Part 9: Particle sizing and counting by automatic light extinction particle counter*

ISO 16232-10:2007, *Road vehicles — Cleanliness of components of fluid circuits — Part 10: Expression of results*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 16232-1 apply.

4 Principle

The contaminants are extracted from the controlled surface of the component by pressure rinsing with a jet of test liquid which carries away the particles for subsequent analysis.

5 Equipment

5.1 General

The equipment used shall neither alter nor modify the size distribution of the extracted particles.

5.2 Test liquid

The test liquid shall be compatible with all the materials in the component, with the liquid used in the final system and with the test equipment, including seals, membrane filter and clean-up filter. A test liquid of low viscosity ($\leq 5 \text{ mm}^2/\text{s}$) and having the capability of removing (or dissolving) oil and grease is recommended. It should be filtered to attain the requirements of 6.3.3.

SAFETY PRECAUTIONS — In case a tested component will be reclaimed for final use, application of incompatible test liquid may cause hazardous damage.

5.3 Test component container

A closed container should be used for the transfer of the component from the place of sampling to the place of particle extraction. This container shall be appropriate to the shape of the component and made of material compatible with the test liquid. Its degree of cleanliness shall comply with the blank requirements specified in 6.3.3.

5.4 Pressure rinsing liquid dispenser

The pressure liquid dispenser is a device that provides clean test liquid specified in 5.2 at a pressure and flow rate capable of extracting the contaminants in an effective manner. The dispenser can also be used to rinse the test equipment and all other items.

5.5 Clean-up filter

If used, a clean-up filter of the test liquid shall achieve the blank level specified and have a retention capacity such that it does not require replacement too often in order to not introduce particles.

5.6 Vacuum suction system

If necessary, use an assembly consisting of a source of vacuum, a vacuum flask previously cleaned and a flexible tube of suitable dimensions and shape for recovery of the extraction liquid and the contaminants accumulated in the component under examination.

5.7 Collection equipment

The collection equipment shall allow effective draining of particles. A conical base is preferred.

The collection equipment shall be cleaned to achieve the requirement of 6.3.3.

It is possible for contaminants remaining on the equipment to be transferred to the sample and thus be erroneously included as part of the particles removed from the component. All collection equipment shall be cleaned and covered before use in order to limit contamination from the environment.

5.8 Sampling containers

The sampling containers (glassware, etc.) required for transferring the extraction liquid from the collection equipment to the analysis equipment shall be cleaned to achieve the requirements of 6.3.3.

5.9 Environmental conditions

The cleanliness of the environment where the extraction is performed shall be consistent with the presumed cleanliness of the component to test. This requirement may result in the test being carried out in a laboratory or controlled workplace. The suitability of the environment is validated when performing the blank test.

5.10 Health and safety

5.10.1 Local Health and Safety procedures shall be followed at all times, any equipment shall be operated in accordance with the manufacturer's instruction and personal protection equipment used where appropriate.

5.10.2 Chemicals used in the procedures can be harmful, toxic or flammable. Good laboratory practices shall be observed in the preparation and use of these chemicals. Care shall be taken to ensure compatibility of the chemicals with the materials used (refer to each Material Safety Data Sheet [MSDS]). Follow the precautions for safe handling and usage as described in the MSDS available from the supplier.

5.10.3 Volatile liquids; care shall be taken with flammable liquids to ensure that they are used in accordance with the MSDS, at temperatures below the stated flash point and away from potential sources of ignition. Appropriate precautions should be taken to avoid inhalation of fumes from these solvents. Always use suitable protective equipment.

5.10.4 Electrical; appropriate care should be applied in the use of electrical power.

5.10.5 Disposal; all liquids and substances shall be disposed of in accordance with local environmental procedures. In the event of spillage it shall be cleaned-up in the manner detailed in the MSDS.

6 Procedure

6.1 Handling and storage

6.1.1 During handling and storage of test components, it shall be ensured that no contaminants are deposited on or removed from controlled surfaces.

6.1.2 To prevent loss from particles during transport it may be necessary to seal openings of the test components, e.g. with suitable plugs.

6.2 Extraction procedure set-up and validation

6.2.1 The number of components to be analysed shall be chosen so as to measure a significant number of contaminants, so that it complies with the requirements for a blank (see 6.2.18 NOTE 3).

6.2.2 If the break-in of the component is part of its manufacturing process the extraction procedure should be agreed between parties and included in the inspection document because break-in may alter the component's initial cleanliness level.

6.2.3 For active components, it may be necessary to operate them in order to pass the test liquid through during the extraction procedure. In this case, the initial contamination level may be altered. The extraction conditions should be agreed upon between parties and included in the inspection document.

6.2.4 If the particles detached during transportation of the test component and particles from the packaging shall be included in the cleanliness inspection, they shall be collected using the appropriate extraction method (e.g. low pressure rinsing) as agreed upon between parties and included in the inspection document.

6.2.5 The effectiveness of pressure rinsing depends on the following, non-exhaustive list of parameters: pressure, flow rate, distance, angle, size and shape of the nozzle (flat, circular, etc.), sequence/procedure, how the components are treated, time/liquid volume per unit area. A synopsis of the operations to perform is given in Annex A. The detailed description of operating conditions and equipment used in application of this standard to rinse and empty the component constitutes the extraction procedure. This procedure shall be established for each component and shall be both agreed between parties and included in the inspection document. Details of the procedure shall be reported on a suitable data sheet (for an example of an extraction procedure data sheet see Annex B).

6.2.6 If needed for reporting results and if not specified, determine the controlled volume and/or controlled surface area of the component under examination (see Annex B of ISO 16232-10:2007). Report and/or specify their values in the inspection document.

6.2.7 Before starting to set up or validate any extraction protocol/equipment, it is necessary to perform an initial blank test to know the cleanliness of the equipment. This is performed after cleaning the equipment and the initial blank shall exhibit values stated in 6.3.3.

NOTE Conditioning and cleaning serves the purpose of obtaining a suitable cleanliness level of the inspection set-up. It is recommended that a basic procedure for conditioning the inspection set up be defined. For example, by performing a cleanliness analysis of a defined volume of liquid after the cleaning procedure of the set-up, it can be determined whether the inspection environment is in suitable conditions and acceptable for carrying out a validation procedure. The initial blank shall exhibit values stated in 6.3.3.

6.2.8 If necessary, demagnetise the component and/or clean those external surfaces which are not involved in the cleanliness inspection. The external surface should be cleaned in a physically different place from where extraction is to be carried out. Ensure that no particles are deposited on or removed from controlled surfaces. For example, if the component is of large size (like a tank), clean only those external surfaces which might contribute to contamination during the extraction process.

6.2.9 If necessary, remove all covers and other plugs fitted for transport of the component. If the component contains a shipment liquid, empty it out, measure its volume and analyse its contaminants according to Clause 7.

NOTE Dismantling or removal of plugs might generate particles to contribute to the original contamination.

6.2.10 Place the component over the clean collection equipment as specified in 5.7.

When components are heavy or large, they should be manipulated and moved to a suitable position with appropriate supports (e.g. a sling, a frame or a pulley block). This position shall enable the extraction liquid to flow easily into a collection equipment or sampling container. For components which are difficult to empty, such as tanks, it is possible to use a vacuum suction system to collect the whole extraction liquid.

6.2.11 If dismantling is necessary to obtain access to all the surfaces to be inspected, do so with care.

NOTE Any operation of dismantling might generate particles which could be added to or lost from the original amount of particles.

6.2.12 Equip the test liquid dispenser with one or more spray nozzle(s), suitable for the surfaces to be pressure rinsed.

6.2.13 Adjust the pressure of the test liquid to obtain a jet of sufficient power to remove and transport the particles from the controlled surfaces without degrading or dissolving the surface material of the component.

6.2.14 Rinse the controlled surfaces carefully with test liquid sprayed on through the nozzle, ensuring that the whole controlled surface has been swept by the jet in order to extract the particles from the component(s). Depending on the presumed amount of particles or extraction liquid volume, collect the extraction liquid in either a single or several sampling containers or, if appropriate, by using the vacuum suction system.

6.2.15 Collect all recovered extraction liquids and particles. Carefully rinse the collection equipment and collect all of the accumulated particles in a clean sampling container. Identify the sampling container.

NOTE 1 As a function of the level of particle observed in the extraction liquid, it may be necessary to divide the total volume among several sampling containers to facilitate their subsequent analysis, to avoid either clogging of the membrane filter during filtration, the saturation of an APC or overlapping particles in the case of microscopic analysis.

NOTE 2 Instead of collecting in a container, the liquid samples may also be directed through a membrane filter directly connected to the outlet of the collection equipment.

6.2.16 Analyse the extraction liquid in accordance with Clause 7 and label the result obtained as S_1 .

6.2.17 Repeat 6.2.14 to 6.2.16 twice more on the same component, using, when necessary, a different container for each extraction liquid volume and label the result obtained as S_2 and S_3 .

NOTE The extractions should be made directly the one after the other.

6.2.18 Validate the contamination extraction procedure to ensure its efficacy as follows:

- a) for each of the three samples analysed in 6.2.16 and 6.2.17, establish the total mass of contaminants and/or the total number of particles. For the particle count, this is applicable to the total number of particles larger than the smallest particle size specified in the inspection document. This particle size shall be chosen to enable counting significant numbers of particles;
- b) divide the result of the last sample (S_3) by the sum of all the values obtained in 6.2.18 a);
- c) if the value obtained is less than or equal to 10 %, the end-point is reached and the extraction is completed.

NOTE 1 This procedure enables the extraction curve to be drawn and the end-point ($\leq 0,10$) to be demonstrated (see Figure 1).

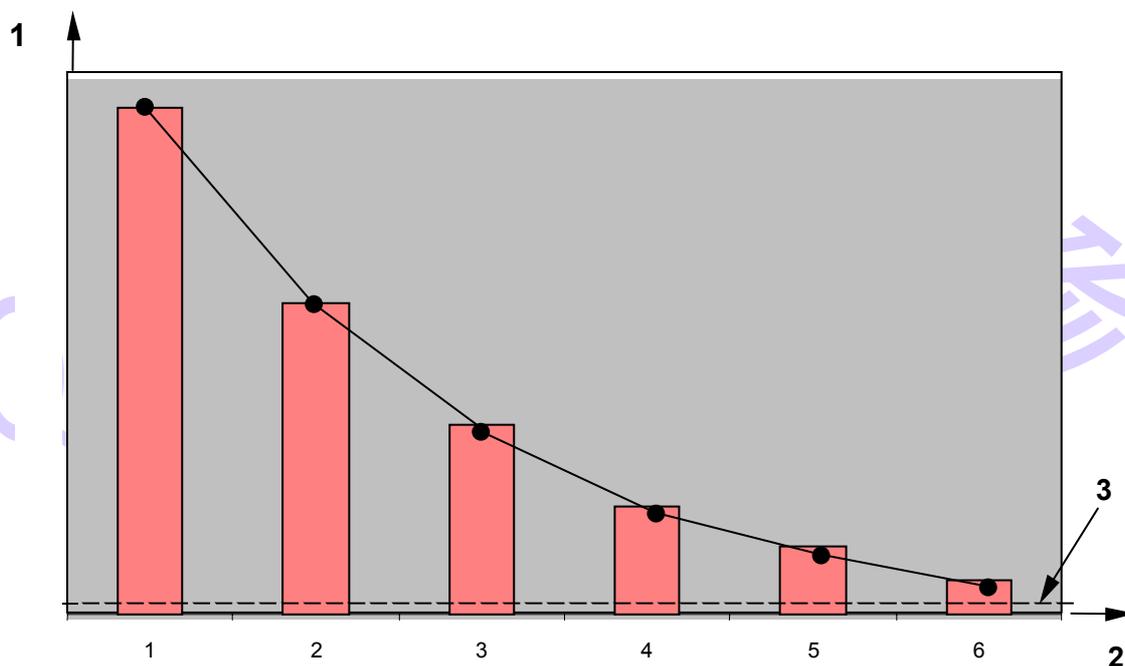
NOTE 2 The cleanliness level of the component is the sum of the extractions.

NOTE 3 In some cases (for example: a very low contamination level, difficulties in extracting particles, inappropriate blank level, etc.) the extraction curve may not be of the form seen in Figure 1. If this is the case, it is ensured that all extraction parameters have been properly investigated.

- d) If the value obtained is $> 0,10$, a further extraction is necessary. Repeat stages 6.2.14 to 6.2.18 until the last sample (S_n) produces a result $\leq 0,10$ of the total of the whole samples ($S_n \leq \frac{10}{100} \sum_{i=1}^n S_i$).

6.2.19 If six extractions have been performed without reaching a value $\leq 0,10$, then the extraction parameters are not suitable and shall be modified. Then repeat operations 6.2.14 to 6.2.18 with new parameters on a new component.

6.2.20 If this criterion is not fulfilled, set up a new extraction protocol and validate it according to 6.2 or apply another extraction method as defined in ISO 16232-2, ISO 16232-4 and ISO 16232-5.

**Key**

- 1 cleanliness level of S_i
- 2 extraction samples i
- 3 blank level

Figure 1 — Example of extraction curve

6.3 Blank test**6.3.1 Sources of blank contamination**

6.3.1.1 The blank value accounts for contamination resulting from handling and testing the component, beginning when it is unpacked and ending after analysis procedure. Main sources of blank contamination are:

- environment (air, operator, working area, etc.);
- test liquid;
- all non-component surfaces that come into contact with the extraction liquid such as containers and equipment for collecting and sampling the extraction liquid;
- analysis of the extraction liquid;
- membrane filter or optical particle counter and associated equipment;
- handling during preparation and analysis of extraction liquid samples.

The blank value results from the combination and interaction of the above factors being applied for a specified test task.

6.3.1.2 The cleanliness of the environment where the cleanliness inspection is performed should be known and be consistent with the presumed cleanliness of the component to be tested. This is validated when performing the blank test.

6.3.1.3 If the blank value level shifts towards higher values, the sources of blank contamination shall be investigated in order to avoid cross contamination.

6.3.2 System blank test

6.3.2.1 A blank test is performed to verify that the operating conditions, equipment and products used in the extraction procedure do not contribute a significant amount of contamination to the component analysed. To ensure process consistency, a blank test should be performed at regular intervals using identical test parameters.

6.3.2.2 For the determination of system blank values, identical conditions as the one applied during testing of the component shall be applied but with the component omitted.

The blank value shall be determined and shall comply with the requirements for each analysis method specified in the inspection document.

6.3.2.3 Proceed as specified in 6.2.14 to 6.2.17 with the same equipment and total volume of test liquid as required for analysis of the component, but without the component.

6.3.2.4 Analyse the extraction liquid as specified in Clause 7.

6.3.3 Blank value

6.3.3.1 General

The acceptable blank value depends on the component's presumed or specified cleanliness level and, depending on the analysis method, is as follows.

6.3.3.2 Gravimetric analysis

Less than 10 % of the presumed gravimetric contamination level.

NOTE Using a 4-digit balance under uncontrolled environmental conditions (uncontrolled humidity and temperature) the minimum measurable blank value is 0,3 mg. Thus at least 3 mg should be collected during the component test in order to meet the 10 % criterion.

6.3.3.3 Particle counting and sizing

a) Particle counts: less than 10 % of the presumed or specified numbers, at the relevant sizes, each calculated number being rounded down.

EXAMPLE:

For one particle size, the specified number is 16,

$16 \times 10 \% = 1,6$

rounded value = 1

Conclusion: 1 particle is accepted in the blank.

NOTE The sizes specified in the inspection document for the blank should be as close as possible to the maximum particle size acceptable for the component and chosen to allow counting significant numbers of particles.

- b) Maximum particle size: no particle at the ISO 16232-10 size range next lower to the half of the maximum particle size presumed or specified.

EXAMPLE:

maximum acceptable particle size $X = 350 \mu\text{m} \rightarrow 350 \mu\text{m}/2 = 175 \mu\text{m}$.

This is size class G according to ISO 16232-10.

Next lower size class is F. That means no particles larger than $100 \mu\text{m}$ for the blank.

- c) If the component cleanliness level is neither presumed nor specified, the blank shall exhibit:
- less than 4 000 particles larger than $5 \mu\text{m}$ and less than 500 particles larger than $15 \mu\text{m}$ per 100 mL of extraction liquid;
 - no particle larger than $50 \mu\text{m}$.

6.3.3.4 If the blank level exceeds 10 %, it is possible to increase the number of test components analyzed in order to collect more particles and thus fulfill the 10 % limit.

6.4 Component routine test

6.4.1 A synopsis of the procedure is given in Annex C.

6.4.2 Apply the extraction procedure described in 6.2.1 to 6.2.15 to the test item. It may be possible to use a combined extraction method by using the same overall test liquid volume used to validate the extraction procedure. In this case the resulting cleanliness level may differ. This simplified method shall be validated and shall be agreed between parties and included in the inspection document.

If the particles detached during transportation of the test component and particles from the packaging have to be included in the cleanliness test, they shall be collected using the appropriate extraction method (e.g. low pressure rinsing) as agreed upon between parties and included in the inspection document.

6.4.3 When several identical components are measured by a validated method, the cleanliness level of each extraction liquid needs not be measured. All the liquids collected in 6.2.15 can then be mixed and analysed as specified in Clause 7.

NOTE When the extraction method is applied to several components due to their high level of cleanliness (in relation to the value of the blank level, etc.) it is not necessary to measure the contamination level of each extraction liquid. All the liquids collected in 6.2.15 are then mixed and analysed as specified in Clause 7.

7 Analysis of the extraction liquid

7.1 All of the extraction liquid shall be analysed by the method appropriate to the expression of the result of the cleanliness test as specified in the inspection document:

- gravimetric analysis in accordance with ISO 16232-6;
- particle sizing and counting by microscopic analysis in accordance with ISO 16232-7;
- particle nature analysis by scanning electron microscopy and EDX in accordance with ISO 16232-8;
- particle sizing and counting by light extinction automatic particle counter in accordance with ISO 16232-9.

7.2 The analysis shall relate to the total volume of liquid used. All or some, as specified in the inspection document, of the following liquid samples have to be analysed together provided that the liquids are completely miscible:

- those containing the extracted particles;
- those containing the particles from rinsing the collection equipment;
- those containing the particles from rinsing any packaging;
- those containing all liquid drained from the test item prior to the extraction process.

If the samples contain immiscible liquids then they shall be analysed separately, unless it can be verified that it will not interfere with the analysis method chosen.

8 Presentation of results

An example of a pressure rinsing extraction data sheet is given in Annex B.

Express the results of the cleanliness measurement according to ISO 16232-10.

Annex A (informative)

Synopsis of the extraction procedure set-up and validation

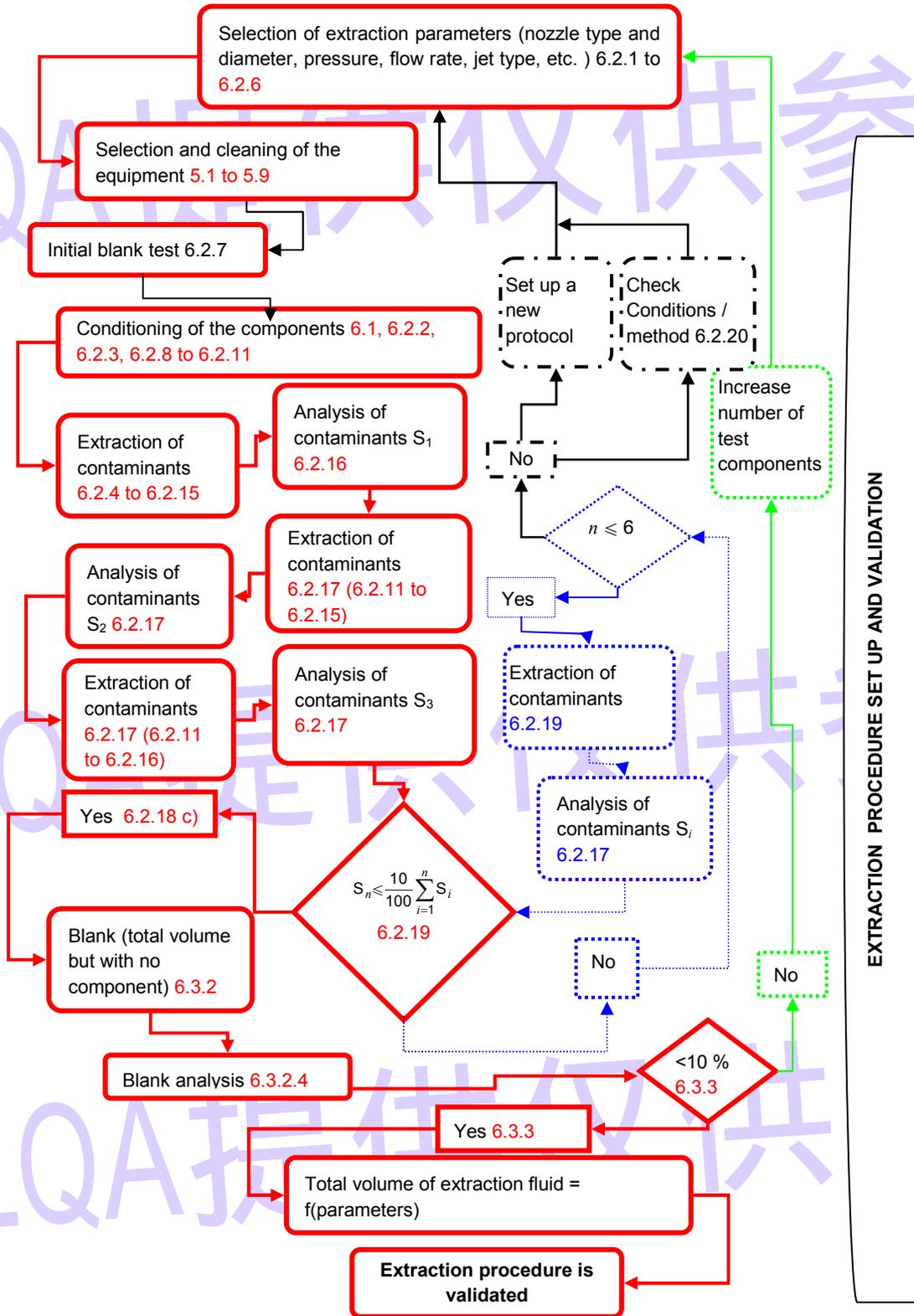


Figure A.1 — Synopsis of the extraction procedure set up and validation

Annex B (informative)

Example of data sheet for the extraction procedure by pressure rinsing

B.1 Operator identification

Date: _____ Operator : _____ Company: _____

B.2 Test Item Identification

Type: _____ Controlled volume $V_C =$ _____ cm^3

Reference: _____ Controlled surface area: $A_C =$ _____ cm^2

Supplier: _____ Number analysed: _____

Prior external rinse: YES NO Plugging Caps YES NO

Dismantling: YES NO Reference : _____

Demagnetising: YES NO

Packaging or container rinsing Analysis of shipment liquid

YES NO YES NO

Packaging or container rinsing YES NO

Time between production or shipment & test hours

B.3 Environment

Industrial Laboratory Controlled (ISO class 14644-1, class: _____)

B.4 Test liquid identification

Identification: _____ Kinematic viscosity: _____ mm^2/s Temperature: _____ $^{\circ}\text{C}$

B.5 Pressure rinsing conditions

Nozzle/jet shape:	Conical <input type="checkbox"/>	Flat <input type="checkbox"/>	Straight <input type="checkbox"/>	Multiple hole <input type="checkbox"/>	Other, ID <input type="checkbox"/>
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Extraction liquid

Pressure:

Flow rate:

Volume:

Extraction volume:

B.6 Extraction curve and validation

Extraction number (<i>i</i>)	Blank level	1	2	3	4	5	6
Cumulative volume (mL)							
Cumulative mass (mg)							
Cumulative particle count at <i>x</i> (µm)							
% extraction							

NOTE 1 Extraction is validated when an analysis result is less than or equal to 10 % of the sum of all the results

$$(S_n \leq \frac{10}{100} \sum_{i=1}^n S_i \text{ with } n \leq 6)$$

NOTE 2 Report particle count data on as many lines as particle sizes used for this validation.

B.7 Illustrations (pictures or drawings to be inserted)

Figure B.7.1 – Diagram or view in 2D or 3D of the component



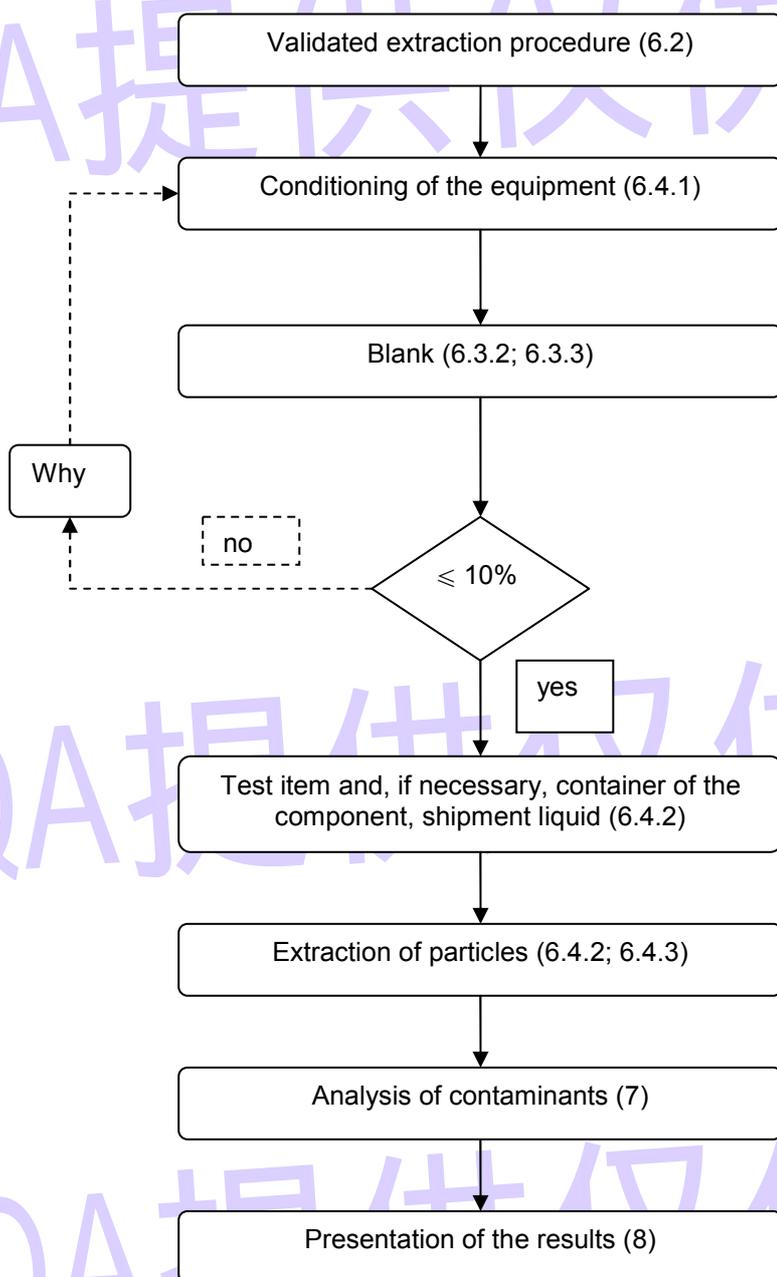
Figure B.7.2 – Position or state at rinsing (6.2.11)



Figure B.7.3 – Movements imposed to the jet (6.2.15)



Figure B.7.4 – Position or state during collection (6.2.15)

Annex C
(informative)**Synopsis of the routine test procedure****Figure C.1 — Synopsis of the test procedure**

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- [11] NF E 48-658, *Hydraulic fluid power — Fluids — Determination of particulate contamination by automatic counting using the light interruption principle*
- [12] NF E 48-660, *Hydraulic fluid systems — Fluids — Determination of solid particulate contamination by optical microscope and image analysis.*

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