

ISO 18387:2019 (E)

Aerospace — Linear hydraulic utility actuator — General specifications

Contents

	Foreword
	Introduction
1	Scope
2	Normative references
3	Terms and definitions
4	General requirements
4.1	Order of precedence
4.2	Hydraulic system characteristics
4.3	Qualification
4.4	Airworthiness requirements
5	Functional requirements
5.1	General
5.2	Actuator type
5.3	Features incorporated within the utility actuator
5.4	Hydraulic fluid
5.5	Performance
5.5.1	General
5.5.2	Performance cases
5.5.2.1	General
5.5.2.2	Normal retraction and extension
5.5.2.3	Maximum retraction and extension
5.5.2.4	Alternate retraction or extension
5.5.3	Leakage
5.5.4	Seal and scraper friction
5.5.5	End of travel snubbing
5.5.5.1	General
5.5.5.2	End of travel snubbing pressures
5.5.6	Utility actuator locking means
5.5.6.1	General
5.5.6.2	Locking loads and unlocking pressures
5.5.6.3	Lock indications
5.5.6.3.1	General
5.5.6.3.2	Visual lock indication
5.5.6.3.3	Electrical lock indication
5.6	Endurance
5.6.1	General
5.6.2	Duty cycle
5.6.3	Endurance test
5.7	Fluid and ambient temperature
5.8	Fluid cleanliness
5.8.1	Operation
5.8.2	Malfunction
5.8.3	Equipment delivery
5.9	Environmental requirements
6	Detail design requirements
6.1	General
6.2	Prevention of incorrect assembly
6.3	Standard parts

- 6.4 Maintainability features
- 6.5 Seals and scrapers
 - 6.5.1 General
 - 6.5.2 Gland surface finishes
 - 6.5.3 Static seals
 - 6.5.4 Dynamic seals
 - 6.5.5 Scraper rings
 - 6.5.6 Back-up rings
 - 6.5.7 Lead in chamfers
- 6.6 Fluid porting through interfacing surfaces
- 6.7 Lubrication of hydraulic elements
- 6.8 Orifices
- 6.9 Retainer (snap) rings
- 6.10 Spring rings
- 6.11 Secondary locking
- 6.12 Drainage
- 6.13 Drillings
- 6.14 Fillet radii
- 6.15 Rod ends
- 6.16 Bearings
 - 6.16.1 General
 - 6.16.2 Lubrication
 - 6.16.3 Anti-roll feature
- 6.17 Threaded components
- 6.18 Electro-conductive bonding
- 6.19 Marking
 - 6.19.1 Nameplate
 - 6.19.2 Fluid identification
- 7 Strength requirements
 - 7.1 Hydraulic
 - 7.1.1 DOP definition
 - 7.1.2 Proof pressure
 - 7.1.3 Ultimate (burst) pressure
 - 7.1.4 Impulse fatigue
 - 7.1.5 Operation at full flow relief pressure
 - 7.2 Loads
 - 7.2.1 Buckling load
 - 7.2.2 Locking load (if applicable)
 - 7.2.3 Limit load
 - 7.2.4 Limit retraction and extension
 - 7.2.5 Ultimate load
 - 7.2.6 Bottoming loads
 - 7.2.7 Stall load
 - 7.2.8 Bench handling loads
 - 7.3 Combined hydraulic pressure and structural loading
 - 7.3.1 General
 - 7.3.2 Design operating pressure and limit structural load
 - 7.3.3 Proof pressure and ultimate structural load
 - 7.4 Mechanical fatigue
 - 7.5 Port strength
 - 7.6 Vibration
- 8 Construction
 - 8.1 Materials
 - 8.1.1 General
 - 8.1.2 Metals
 - 8.1.2.1 General
 - 8.1.2.2 Zinc and tin plating
 - 8.2 Corrosion protection
 - 8.2.1 General
 - 8.2.2 Ferrous and copper alloys
 - 8.2.3 Aluminium alloys
 - 8.3 Forgings

- 9 **Mass**
- 10 **Installation requirements**
 - 10.1 **Space envelope**
 - 10.2 **Overtravel**
 - 10.3 **Adjustment**
 - 10.4 **Dimensions**
 - 10.4.1 **Retracted length**
 - 10.4.2 **Extended length**
 - 10.5 **Interface document**
 - 10.6 **Installation drawing**
 - 10.7 **Mounting of the actuator to structure**
 - 10.8 **Hydraulic interfaces**
 - 10.9 **Electrical interfaces (if applicable)**
- 11 **Instrumented utility actuator**
- 12 **Maintainability requirements**
 - 12.1 **General**
 - 12.2 **Maintenance concept**
 - 12.3 **Service life limitations and storage specifications**
 - 12.4 **Reparability**
- 13 **Reliability requirements**
 - 13.1 **Requirements**
 - 13.2 **Equipment compliance**
- 14 **Quality assurance provisions**
 - 14.1 **Responsibility for inspection**
 - 14.2 **First article inspection (FAI)**
 - 14.2.1 **General**
 - 14.2.2 **First article samples**
 - 14.2.3 **First article inspection report**
 - 14.2.4 **Rejection**
 - 14.3 **Classification of tests**
 - 14.4 **Test stand requirements**
- 15 **Development tests**
- 16 **Acceptance tests**
 - 16.1 **General**
 - 16.2 **Examination of the product**
 - 16.3 **Test programme and inspection methods**
 - 16.3.1 **General**
 - 16.3.2 **Mass**
 - 16.3.3 **Run-in**
 - 16.3.4 **Proof pressure**
 - 16.3.5 **Leakage**
 - 16.3.5.1 **External leakage**
 - 16.3.5.2 **Internal leakage**
 - 16.3.5.3 **Dynamic leakage**
 - 16.3.5.4 **Low pressure leakage**
 - 16.3.6 **Performance tests**
 - 16.3.7 **Electro-conductive bonding**
 - 16.3.8 **Storage and packaging**
- 17 **Qualification**
 - 17.1 **Purpose**
 - 17.2 **Qualification procedure**
 - 17.2.1 **Qualification programme plan**
 - 17.2.2 **Qualification test procedure**
 - 17.2.3 **Similarity and analysis report**
 - 17.2.4 **Qualification test report**

- 17.2.5 Samples and programme of qualification tests
- 17.2.6 Acceptance tests
- 17.2.7 Dimensional check
- 17.2.8 Expanded envelope acceptance tests
- 17.2.9 Performance
 - 17.2.9.1 General
 - 17.2.9.2 Normal extension load
 - 17.2.9.3 Normal retraction load
 - 17.2.9.4 Maximum extension load
 - 17.2.9.5 Maximum retraction load
 - 17.2.9.6 Operation at full flow relief pressure
 - 17.2.9.6.1 Extension
 - 17.2.9.6.2 Retraction
 - 17.2.9.7 Stall load
 - 17.2.9.8 Alternate extension (if applicable)
 - 17.2.9.9 Alternate retraction (if applicable)
- 17.2.10 Endurance test
- 17.2.11 Structural tests
 - 17.2.11.1 General
 - 17.2.11.2 Proof pressure
 - 17.2.11.3 Ultimate (burst) pressure
 - 17.2.11.4 Limit load
 - 17.2.11.5 Ultimate load
 - 17.2.11.6 Design operating pressure and limit structural load
 - 17.2.11.7 Proof pressure and ultimate structural load
 - 17.2.11.8 Buckling load
 - 17.2.11.9 Locking loads
 - 17.2.11.10 Impulse fatigue
 - 17.2.11.11 Mechanical fatigue
 - 17.2.11.12 Bench handling loads
 - 17.2.11.13 Wrench loads
 - 17.2.11.14 Vibration
 - 17.2.11.14.1 Test set-up
 - 17.2.11.14.2 Test procedure
 - 17.2.11.14.3 Other vibration tests
 - 17.2.11.15 Operational shock
- 17.2.12 Environmental tests
- 17.2.13 Post qualification tests
 - 17.2.13.1 Acceptance tests
 - 17.2.13.2 Disassembly and inspection
- 17.2.14 Supplementary tests

Page count: 47