

AEROSPACE RECOMMENDED PRACTICE

ARP1281™

REV. C

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Superseding ARP1281B

(R) Actuators: Aircraft Flight Controls, Power Operated, Hydraulic,
General Specification For

RATIONALE

ARP1281C has been reaffirmed to comply with the SAE Five-Year Review policy.

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<https://www.sae.org/standards/content/ARP1281C/>

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1. SCOPE:

This aerospace recommended practice provides a framework and suggested procedures or values for requirements for the design, performance, and test of hydraulically powered servoactuators for use in aircraft flight control systems.

The original version of this document was intended for military usage: consequently, the requirements still often reflect such use. However, the basic requirements of this ARP may and should be applicable to commercial usage as well, provided that appropriate considerations are given for the applicable FAR/JAR 25 regulations, hydraulic fluids, and environmental conditions.

1.1 Purpose:

This recommended practice is a guide and surrogate specification for preparing a detail specification for a particular servoactuator application.

1.2 Product Classification:

Servoactuators covered by this recommended practice are of the following classes:

Class A - Power Actuators

Class B - Signal Conversion Actuators

Class C - Power and Signal Conversion Actuator Combination

For military aircraft, the servoactuators covered by this recommended practice include those in the following types of hydraulic systems:

- a. Type I - 65 to +160 °F (-54 to +71 °C) fluid temperature range
- b. Type II - 65 to +275 °F (-54 to +135 °C) fluid temperature range
- c. Type III - 65 to +390 °F (-54 to +199 °C) fluid temperature range

For commercial aircraft, the servoactuators covered by this recommended practice include those suitable for use with type IV and type V phosphate ester fluids.

1.3 Field of Application:

A servoactuator in the flight control system positions an aerodynamic control surface or other force effector to produce forces and moments on the aircraft for stability and control of the vehicle. These servoactuators may be controlled by mechanical, electrical, photonic or fluidic inputs, or combinations thereof, and may be powered by one or more hydraulic systems. The complete actuator assembly may incorporate basic components such as servovalve, input linkage and electrical, optical, and/or mechanical position feedback systems, and redundancy logic in addition to the actuating cylinder. These components are usually designed as an integral package, but in some cases are physically separated. Additional components may also be included and configured integrally or separately such as bypass valves, filters, pressure switches, motor or solenoid operated shutoff valves, thermostatic control valves, hydraulic logic, mechanical locking devices and electrical transducers.

2. REFERENCES:

Following are listings of documents and pertinent definitions associated with hydraulically powered aircraft flight control actuators. These publications form a part of this document to the extent referenced herein. The latest issue of all documents shall apply.

2.1 Applicable Documents:

2.1.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale PA 15096-0001.

AMS 2403	Plating, Nickel, General Purpose
AMS 2406	Plating, Chromium, Hard Deposit
AMS 2419	Cadmium-Titanium Plating
AMS 2426	Coating, Cadmium Vacuum Deposition
AMS-A-21180	Aluminum - Alloy Castings, High Strength
AMS-A-22771	Aluminum Alloy Forgings, Heat Treated
AMS-C-8837	Coating, Cadmium (Vacuum Deposited)
AMS-F-7190	Forgings, Steel, Aircraft/Aerospace Equipment and Special Ordnance Applications
AMS QQ-C-320	Chromium Plating (Electrodeposited)
AMS-S13165	Shot Peening of Metal Parts
AMS-STD-2175	Castings, Classification and Inspection of
ARP490	Electrohydraulic Flow Control Servovalves
ARP598	The Determination of Particulate Contamination in Hydraulic Fluids by the Particle Count Method
ARP926	Design Analysis Procedure for Failure Mode, Effects and Criticality Analysis (FMECA)
ARP1383	Impulse Testing of Hydraulic Actuators, Valves, Pressure Containers and Similar Fluid System Components
AIR4066	Hydraulic Servoactuator Materials
ARP4386	Terminology and Definitions for Aerospace Fluid Power, Actuation, and Control Technologies
ARP4493	Direct Drive Valves
ARP4763	Aerospace Fluid Power Relief Valves
AIR4922	Primary Flight Control Hydraulic Actuation System Interface Definition
ARP4945	Aerospace - Solenoid Valve, Hydraulic, Three-Way, Two-Position, Direct Acting
AS1241	Fire Resistant Phosphate Ester Hydraulic Fluid for Aircraft
AS1290	Graphic Symbols for Aircraft Hydraulic and Pneumatic Systems
AS4059	Aerospace Cleanliness Classification for Hydraulic Fluids
AS4088	Rod Scraper Gland Design Standard
AS4716	Gland Design, O-ring and Other Elastomeric Seals
AS4941	Hydraulic System Components, Commercial Aircraft, General Specification For
AS5169	Fitting, Port Plug and Bleeder FSC 4730
AS5440	Hydraulic Systems, Aircraft, Design and Installation Requirements for
AS6038	Bearings, Ball, Bellcrank, Antifriction, Airframe

2.1.1 (Continued):

AS6039	Bearings, Ball, Rod End, Double Row, Self-Aligning
AS7949	Bearings, Ball, Airframe, Antifriction
AS8775	Hydraulic System Components, Military Aircraft, General Specification for
AS8976	Bearings, Plain Self-Aligning, All-Metal
AS8879	Screw Threads - UNJ Profile, Inch
AS33649	Boss Fluid Connection - Internal Straight Thread
AS39901	Bearings, Roller, Needle, Airframe, Antifriction, Inch
J2470	Hydraulic Fluid Power – Valves – Method for Assessing the Lock Sensitivity to Contaminants

2.1.2 ASTM Publications: Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM B 381	Specification for Titanium and Titanium Alloy Forgings
ASTM D 1974	Fiberboard Shipping Containers, Methods of Closing, Sealing, and Reinforcing, Standard Practice for
ASTM E 1417	Standard Practice For Liquid Penetrant Examination
ASTM E 1444	Standard Practice For Magnetic Particle Examination

2.1.3 Government Publications: Available from Standardization Documents Order Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.

A-A-1898	Cushioning Material, Cellulosic, Packaging
A-A-66057	Panels, Wood/Wood Based; construction and Decorative
JSSG-2006	Aircraft Structures, General Specification For
MIL-A-8625	Anodic Coatings for Aluminum and Aluminum Alloys
MIL-DTL-5015	Connectors, Electrical, Circular Threaded, An Type, General Specification for
MIL-C-11796	Corrosion Preventive Compound, Petrolatum, Hot Application
MIL-C-26482	Connector, Electrical (Circular, Miniature, Quick Disconnect, Environment Resisting) & Suppl 1 Recepticals and Plugs, General Specification for (Inactive for New Design)
MIL-F-9490	Flight Control Systems - Design, Installation and Test of, Piloted Aircraft, General Specification for
MIL-H-5606	Hydraulic Fluid, Petroleum Base, Aircraft, Missile and Ordnance (Inactive for New Design)
MIL-HDBK-454	General Requirements for Electronic Standard Equipment
MIL-HDBK-470	Designing and Developing Maintainable Products and Systems
MIL-HDBK-831	Test Reports, Preparation of
MIL-HDBK-838	Lubrication of Military Equipment
MIL-PRF-131	Barrier Material, Water Vaporproof, Flexible
MIL-PRF-6083	Hydraulic Fluid, Petroleum Base for Preservation and Operation
MIL-PRF-8805	Switches and Switch Assemblies, Sensitive Push (Snap Action), General Specification for
MIL-PRF-8815	Filter and Filter Elements, Fluid Pressure, Hydraulic, Line, 15 Micron Absolute & 5 Micron Absolute, Type II System, General Specification for

2.1.3 (Continued):

MIL-PRF-22191	Barrier Materials, Transparent, Flexible, Heat Sealable
MIL-PRF-46170	Hydraulic Fluid, Rust Inhibited, Fire Resistant, Synthetic Hydrocarbon Base
MIL-PRF-83282	Hydraulic Fluid, Fire Resistant, Synthetic Hydrocarbon Base, Aircraft, Metric, NATO Code Number H-537
MIL-PRF-87257	Hydraulic Fluid, Fire Resistant, Low Temperature, Synthetic Hydrocarbon Base, Aircraft and Missile
MIL-STD-100	Engineering Drawings
MIL-STD-129	Standard Practice for Military Marking
MIL-STD-130	Identification Marking of U.S. Military Property
MIL-STD-461	Requirements for The Control of Electromagnetic Interference Characteristics of Systems and Equipment
MIL-STD-464	Electromagnetic Environmental Effects, requirements for Systems
MIL-STD-704	Aircraft Electric Power Characteristics
MIL-STD-810	Environmental Test Methods & Engineering Guidelines
MIL-STD-882	System Safety Program Requirements
MIL-STD-889	Dissimilar Metals
MIL-STD-1472	Human Engineering Design Criteria for Military System, Equipment and Facilities
MIL-STD-1839	Standard Practice for Calibration and Active Measurement Requirements
MIL-STD-2073-1	DOD Standard Practice for Military Packaging
MS 21343	Boss Spacing - Hydraulic Design, Standard for (Inactive for New Design)
AN 6204	Valve, Hydraulic Bleeder
MIL-HDBK-5	Metallic Materials and Elements for Aerospace Vehicle Structures
MIL-HDBK-17	Plastics for Flight Vehicles

Air Force Systems Command Design Handbook AFSC DH 1-6 System Safety

Technical Report AFFDL TR-74-116 Background Information and User Guide for MIL-F-9490
(Available from Defense Technical Information Center, Ft. Belvoir, VA 22060-6218)

2.1.4 NAS Publications: Available from Aerospace Industries Association, 1250 Eye Street NW, Washington, DC 20005.

NAS 847	Caps and Plugs, Protective, Dust and Moisture Seal
NASM 3369	Bolt, Self Retaining, Positive Locking, CRES 90KSI Fsu, 63KSI FtU, Hexagon Slotted Head, 450 Deg F. and 650 Deg F
NASM 15981	Fastener, Externally Threaded, Self-Locking, Design and Usage Limitations for
NASM 20995	Wire, Safety or Lock
NASM 21224	Nut, Self-locking, Castellated, Hexagon Counterbored, Assembled Washer, 250°F, Non-metallic Insert (for Self Retaining Bolts)
NASM 21244	Nut, Castellated, Hexagon Counterbored Assembled Washer, 450°F (for Self Retaining Bolts)
NASM 24665	Pin, Cotter (Split)
NASM 25027	Nut, Self-Locking, 250°F, 450°F, and 800°F

2.1.4 (Continued):

NASM 33540	Safety Wiring and Cotter Pinning
NASM 33588	Nuts, Self-Locking, Aircraft
NASM 33602	Bolt, Self Retaining, Aircraft Reliability and Maintainability Design and Usage Requirements for
NASM 83050	Bolt, Self-Retaining, Impedance Type

2.1.5 FAR Publications from the FAA: Available from the Federal Aviation Administration, 800 Independence Avenue, SW, Washington DC 20591.

FAR Part 25	Code of Federal Regulations, CFR1.1, Part 25 Airworthiness Standards, Transport Category Airplanes
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2.1.6 Joint Aviation Authorities Committee Documents: Available from Civil Aviation Authority Printing and Publications Services, Grenville House, Cheltenham, Glos. GL50 2BN, United Kingdom.

JAR 25	Joint Airworthiness Requirements, Large Airplanes
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2.1.7 Radio Technical Commission for Aeronautics Documents: Available from RTCA Secretariat, 44 Suite 500, 1425 K Street, Washington DC 20005.

RTCA/DO-160	Environmental Conditions and Test Procedures for Airborne Equipment
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2.1.8 American Society of Mechanical Engineers Documents: Available from ASME International, Three Park Avenue, M/S 10E, New York, NY 10016-5990.

ASME Y14.100	Engineering Drawing Practices
ASME Y14.24	Types and Applications of Engineering Drawings
ASME Y14.34M	Associated Lists
ASME Y14.35M	Revision of Engineering Drawings and Associated Documents
ASME Y14.38	Abbreviations and Acronyms

2.1.9 Information References: The following publications are provided for information purposes only and are not a required part of this document.

2.1.9.1 Military Documents:

MIL-STD-961	Military Specification and Associated Documents Preparation of
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2.2 Definitions and Abbreviations:

2.2.1 Definitions: The detail specification shall determine the definitions that shall apply. ARP4386 contains the terminology, nomenclature, and definitions appropriate for use in servoactuators.

2.2.2 Abbreviations: The detail specification shall determine the abbreviations that shall apply. ARP4386 contains abbreviations for the terminology defined therein.

3. TECHNICAL REQUIREMENTS:

3.1 General:

Servoactuators covered by this practice should be designed in accordance with a detail specification to be prepared by the airframe contractor. The detail specification shall specify the requirements necessary to satisfy the particular application. The format, elements, and detailed procedures or values contained in this ARP are strongly recommended for use in the detail specification. The methods set forth herein for the preparation of a specification should be used as a guide.

3.2 Design:

3.2.1 Hydraulic Control Valves:

3.2.1.1 Mechanical Input Servovalves: Mechanical input servovalves shall be designed to give smooth operation. Internal leakage shall be held to a practicable minimum consistent with permissible operating forces, temperature effects, control sensitivity, fluid contamination levels, and other governing factors. Critical parts of the control valve (e.g. spool and sleeve on a slide valve design) shall be made of materials which are compatible in mechanical properties, especially with respect to coefficient of expansion and galling tendencies.

3.2.1.2 Electrohydraulic Servovalves and Direct Drive Valves: Electrohydraulic servovalves shall be designed in accordance with ARP490 and the Direct Drive Valves shall be designed in accordance with ARP4493. Life and environmental requirements shall be consistent with those for the servoactuator. The detail specification shall include the electrical parameters of the valve.

3.2.1.3 Bypass Valves: If bypass valves are utilized to interconnect the cylinder ports during certain modes of operation, the detail specification shall define the type of valve normally "open" or normally "closed", control parameters (electrical and/or hydraulic), allowable pressure drop between cylinder ports at rated flow, and allowable leakage.

3.2.1.4 Motor-Operated Valves: Electric motors for operating valves shall conform to requirements of AS8775.

3.2.1.4.1 Limit Switches: When limit switches are used, they shall conform to MIL-PRF-8805 and shall be actuated by positively secured means. A failure of the switches shall not affect manual override.

3.2.1.4.2 Voltage for Motor-Operated Valves: Electrically actuated valves designed for 28-volt DC systems shall operate at a minimum of 18 volts with operating pressure applied to the valve, and shall operate at up to 1 1/2 times operating pressure at 28 volts. Electrically actuated valves designed for 115-volt AC systems shall operate at a minimum of 85 volts with operating pressure applied to the valve and shall operate up to 1 1/2 times operating pressure at a maximum of 115 volts. The above operating voltages shall be met at maximum fluid and ambient temperatures.

- 3.2.1.5 Solenoid Operated Valves: Solenoids for operating valves shall be in accordance with AS8775. Direct acting three way, two position solenoid operated valves, often used in hydraulic flight control servoactuators, shall conform to requirements of ARP4945. The operating time needs to be specified in the detailed specification.
- 3.2.1.5.1 Creepage and Clearance Distances: The minimum creepage distance of 0.250 inch and clearance distance of 0.125 inch shall apply between uninsulated current carrying parts and ground when voltages of 3.2.1.4.2 are used. The minimum spacing between uninsulated current carrying parts and any other portion of the solenoid (other than insulating material) shall be 0.125 inch.
- 3.2.1.6 Load Limiting Relief Valves: The detail specification shall specify relevant parameters of load limiting relief valves, when used, including supply and differential pressure extremes, flow relief criteria, and reseal pressure. Relief valves shall conform to requirements of ARP4763.
- 3.2.1.7 Fluidic or Optic Type Input Servovalves: Emerging technology on servovalves, including photonic and fluidic servovalves, may be specified in future systems. These servovalves shall be designed consistent with the requirements for the servoactuator application. The detail specification shall define the optic or fluidic parameters required of the servovalve as appropriate to its application.
- 3.2.2 Electrical Components:
- 3.2.2.1 Position Transducer: Electrical characteristics such as linearity, sensitivity, excitation voltage, null voltage, stroke from null, etc., and requirements relating to type, location, and electrical interface, shall be in accordance with the detail specification.
- 3.2.2.2 Dielectric and Insulation Properties: Minimum insulation resistance of valve coils and leadout wires should be specified under the full environment. For test purposes, it is recommended that this value be 100 megohms under room temperature and humidity conditions during a 60-second application of a dc differential equal to 500 V. Dielectric strength between mutually insulated circuits and between insulated circuits and ground should be specified. It is recommended that this value be 1050 VAC 60 Hz for one minute at sea level. Repeated applications of high voltage may eventually break down the coil insulation, so subsequent testing is usually done at 50% of the initial level.
- 3.2.2.3 Electrical Power: Electrical components, including solenoid valves, shall be capable of proper operation with electrical power in accordance with MIL-STD-704.
- 3.2.2.4 Electrical Connectors: Unless otherwise specified in the detail specification, electrical connectors conforming to MIL-DTL-5015 or MIL-C-26482 shall be installed as an integral part of the electrical component of the servoactuator to facilitate maintenance and replacement. Connectors shall be mounted to preclude nuisance warning indications and intermittent operation when subjected to applicable temperature differentials, vibration and shock. They shall be "polarized" so that it is impossible to mismatch them on a particular piece of equipment.

3.2.3 Physical Characteristics:

- 3.2.3.1 Weight: The detail specification shall specify the maximum dry weight or the maximum wet weight of the servoactuator. It shall be designed for the lightest weight compatible with specification requirements. Maximum consideration shall be given to achieving a minimum weight in accordance with good design practices, safety and vulnerability.
- 3.2.3.2 Dimensions: The detail specification shall specify the maximum permissible envelope dimensions of the servoactuator for (a) static condition, e.g. shipping and (b) operating condition, i.e. maximum space required for servoactuator, linkages, connectors, and related parts when installed and operated.
- 3.2.3.3 Mounting: Mounting provisions for the servoactuator shall be in accordance with the detail specification. Sufficient clearance shall be provided between servoactuator, structure and other components to preclude binding or jamming due to possible combination of actuator movement, temperature effects, loads and deflections, including structural deflections.
- 3.2.3.4 Moisture Pockets: Servoactuator housing designs which could result in pockets, wells, traps and the like into which water, condensed moisture or other liquids can drain into or collect, shall be avoided. If such designs are unavoidable, provisions for draining moisture from these pockets shall be incorporated, or areas adequately treated to preclude corrosion or damage due to extended periods of entrapment.

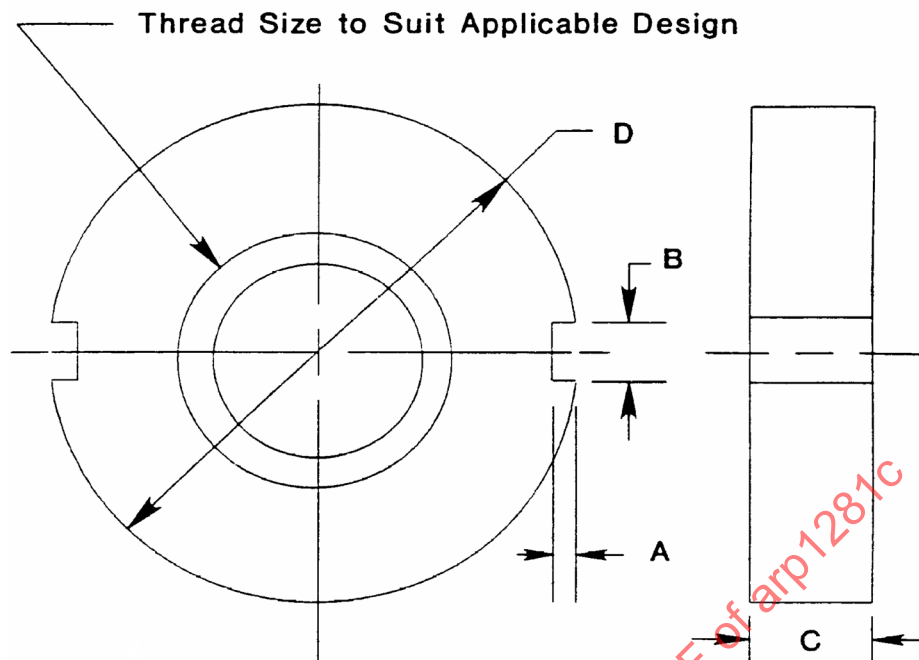
3.2.4 Structural Characteristics:

- 3.2.4.1 Strength: Unless otherwise specified, servoactuators shall be designed in accordance with the material strengths of MIL-HDBK-5 and MIL-HDBK-17.
- 3.2.4.2 Damage Tolerance: The elements of a servoactuator that are essential to aircraft safety shall meet the requirements of JSSG-2006. Servoactuators shall incorporate materials, stress levels, and structural configurations which allow incipient failure detection, routine in-service inspection, minimize crack initiation, and minimize failure due to the propagation of undetected flaws, cracks, or other damage. The detail specification shall specify magnitude, direction and type of all externally applied loads. All possible combinations of loading shall be specified, together with the diagram of the operational geometry. The return port passages shall be structurally acceptable at the rated system pressure.

3.2.5 Design Characteristics:

- 3.2.5.1 Cylinder Assembly: The cylinder assembly shall be designed in accordance with the detail specification. The design shall also consider the following requirements:
 - 3.2.5.1.1 Piston Head and Rod Assembly: Piston shall have adequate bearing area on the cylinder wall to carry compression, bending and vibration loads without discernible deformation or excessive wear. Rod bearing shall be of sufficient length to ensure satisfactory operation and adequate life.

- 3.2.5.1.2 Eccentricity: Total eccentricity of the piston head and rod including that of the bores for the same, shall not cause binding or galling over the specified operating condition.
- 3.2.5.1.3 Scraper Rings: The detail specification shall specify the type of scraper ring(s) to be used. Consideration shall be given to the latest design techniques and technology. Scraper ring glands shall conform to design standards of AS4088.
- 3.2.5.1.4 Rod Bushings: Rod Bushings shall be made from material (such as Aluminum - Bronze or Aluminum - Nickel - Bronze as defined in AMS 4640) that will not score the actuator rod. Deviations shall be specified in the detail specification.
- 3.2.5.1.5 Wiper Rings: The use of wiper rings is subject to approval of the procuring activity.
- 3.2.5.1.6 Dashpots and Snubbers: Where the kinetic energy of the cylinder and mechanism is too great to be adequately absorbed by an external stop, dashpots or snubbers may be used to reduce piston velocity gradually at the end of the stroke. A simple device, preferably self-cleaning, shall be used. An analysis shall be made to ensure sufficient structural strength and seal extrusion resistance to withstand the hydraulic pressures anticipated during operation. The rate of change of piston velocity and load inertia shall be as specified in the detail specification. Alternately, the maximum load allowed to be put into the adjoining structure by the actuator, in normal and failure conditions, will be specified in the detail specification.
- 3.2.5.1.7 End Caps, Locknuts and Adjustment Nuts (see Figure 1): End caps, locknuts, and adjustment nuts may have wrench flats or hexes, be knurled, or contain milled slots for spanner wrenches, as applicable to the design; when spanner wrench slots are used, they shall be dimensioned in accordance with Figure 1. Drilled hole-type nuts requiring the use of pin-type spanner wrenches shall not be used in servoactuator designs. Positive locking methods are to be used to prevent rotation of the end caps, locknuts, and adjustment nuts.
- 3.2.5.1.8 Rod Ends: These components shall be designed to minimize stress risers. Integral anti-rotation devices are preferred and shall be arranged to prevent excessive airframe attach fitting wear. Controlled radius root threads conforming to AS8879 or special threads with root radii greater than specified in AS8879 are required. The assembly of the rod end to the piston rod shall result in a minimum thread preload equivalent to the maximum rod end load. A positive locking arrangement, positively safetied, shall be used to maintain the thread preload. Safety wiring and cotter pinning shall be in accordance with NASM 33540.



D DIAMETER	A MIN	B MIN	C MIN
3/4 to 2 incl	0.120	0.120	1/4
1 3/4 to 4 incl	0.120	0.190	5/16
3 1/2 to 6 incl	0.190	0.250	3/8

FIGURE 1 - Dimensions for End Caps and Locknuts

- 3.2.5.1.9 Seals: Unless otherwise specified in the detail specification, seal design characteristics shall comply with the gland design requirements of AS4716. The seal designs whether vented or unvented (single or two stage) shall have the written approval of the procuring activity. The elastomeric seals shall be compatible with the hydraulic fluid to be used in the servoactuator. Seal operating life shall be specified in the detailed specification and may be given either in terms of total hours of operation or in number of cycles of operation of specified amplitudes and rates which represent actual usage.
- 3.2.5.1.10 Vulnerability: The detail specification shall establish the vulnerability requirements. These detail requirements shall stress rip stop designs, construction materials and proper positioning of the more critical components both electrical and hydraulic, so as to provide greater protection from a hostile ballistic environment such as enemy ground fire or internal explosions.

3.2.5.1.11 Proof Pressures: The portions of the servoactuator that are subject to supply pressure shall be capable of withstanding a pressure 1.5 times the rated system pressure for 3 minutes. The portions of the servoactuator that are subject to return pressure shall be capable of withstanding the rated system pressure for 3 minutes.

3.2.5.1.12 Burst Pressures: The detail specification shall specify the inlet and return burst pressures. Test and test conditions in 4.7.15 of this practice are set forth as a guide.

3.2.5.2 Ports and Plugs:

3.2.5.2.1 Ports: The location and size of all ports shall be in accordance with the detail specification. The return ports shall be physically different than the pressure ports to avoid improper connections when the unit is installed in the system. The return ports shall be oriented at the highest point in the installation to facilitate bleeding of entrapped air. Also, the hydraulic ports shall be located so that the electrical connectors are not polluted by the hydraulic fluid when disconnecting hydraulic lines. All ports for the tube connections shall be clearly and permanently marked. Where applicable, the directions of flow shall be indicated. Use of a single letter for marking, such as: "P" for pressure and "R" for return is not acceptable. Where space is limited, abbreviations of ASME Y14.38M are recommended and must be approved by the procuring activity. Decalcomanias shall not be considered a permanent marking. Raised letters, engraving, and/or stamping are preferred.

3.2.5.2.2 Fluid Porting through Interfaces: Fluid porting through interfacing surfaces which deflect under structural loading or pressure conditions shall utilize balanced quill tubes with seals on both ends. Face seals may be used for certain applications where the design is sufficiently rigid to prevent adverse deflections caused by pressure loads or structural loads.

3.2.5.2.3 Fillets: Unless otherwise specified in the detail specification, the intersection of highly stressed thin wall cylinder barrels with heavy bulkhead areas shall incorporate generous radii. The fatigue notch sensitivity factor (q) of any portion of the servoactuator shall be limited to 0.70 in the equation:

$$K_f = 1 + (K_t - 1) q \quad (\text{Eq. 1})$$

where (from MIL-HDBK-5):

K_f = fatigue strength reduction factor (dimensionless)

K_t = theoretical stress concentration factor (dimensionless)

q = fatigue notch sensitivity (dimensionless)

hence for above q value:

$$K_f = 0.70K_t + 0.30 \quad (\text{Eq. 2})$$

Additional information is in Appendix A under A.6.

- 3.2.5.2.4 Fluid Passages: Unless otherwise specified in the detail specification, all intersecting holes in manifold section which are machined shall be inclined at an angle not less than 60°. Material thickness between a cylinder bore and a parallel passage shall be equivalent to the basic cylinder wall thickness plus the wall thickness surrounding the passage.
- 3.2.5.2.5 Bosses: Unless otherwise specified in the detailed specification, threaded bosses for connecting fittings shall conform to AS33649. Spacing of parts for connecting fittings shall conform to MS 21343.
- 3.2.5.2.6 Plugs: Permanently installed plugs that will not be removed during the life of the servoactuator shall be of any form suitable for the purpose, except that pipe threaded plugs shall not be used. Removable plugs for Type I and Type II servoactuators shall conform to AS5169 and shall be compatible with seals specified in the detail specification. Plugs used for retention, shall be approved by procuring agency. In systems not otherwise capable of preventing air entrapment, suitable bleeder plugs shall be provided at the highest practicable point in the servoactuator. Suggested types are plugs conforming to AS5169, or valves conforming to AN 6204, installed in bosses conforming to AS33649. Other types may be used, subject to approval of the procuring organization.
- 3.2.5.3 Linkages: Servoactuator linkages shall consider designs and means for precluding sand, dust, water, or ice from impairing normal operation.
- 3.2.6 Materials: The materials used in servoactuators shall be suitable for the service and purpose intended and shall conform to the applicable material specification when such specifications exist for the type material being used. Nonspecification materials may be used provided it can be demonstrated that their use will result in a superior product. AIR4066 may be used for historical information on servoactuator materials. The use of each material in its application shall be substantiated. MIL-HDBK-5 shall be used as the authority for strength of all actuator metals. Use of materials for critical structural applications shall be approved by the procuring agency.
- 3.2.6.1 Metals: All metals shall be compatible with the hydraulic fluid used and with the intended temperature, function or service, and storage conditions to which the components will be exposed. The metals used shall possess adequate corrosion resistant characteristics or shall be suitably protected to resist corrosion which may result from such conditions as: dissimilar metal combinations, moisture, salt spray, and high temperature deterioration, as applicable. Requirements of MIL-STD-889 shall be followed regarding the use of dissimilar metals. Consideration shall be given to providing materials resistant to fluid erosion.
- 3.2.6.2 Castings and Forgings: Castings and forgings shall be designed to the criteria, as applicable, in AMS-STD-2175, AMS-F-7190, AMS-A-21180, AMS-A-22771, and ASTM B 381.

- 3.2.6.3 Type I and Type II Components: Unless otherwise specified, ferrous, titanium, or aluminum alloys shall be used for structural components which resist or transfer the primary load of the servo actuator. Wrought, forged, or cast aluminum alloys may be used to house the valving, internal linkage, and carry hydraulic fluid to the cylinders. Inclusion of a parting line through hydraulic ports is prohibited. Aluminum pressure vessels subjected to 3000 psi or greater shall be forged without flash formation at die parting lines.
- 3.2.6.4 Type III Components: Ferrous or titanium alloys shall be used for all structural components of the servoactuator. Aluminum alloys shall be limited to nonstructural application.
- 3.2.6.5 Fluids: For Type I and Type II systems, the servoactuator and its components shall be designed to operate and be compatible with hydraulic fluid MIL-PRF-83282, or MIL-PRF-87257 or AS1241 as specified. The detail specification shall specify the fluid to be used when components of the servoactuator are operating in a Type III system environment.
- 3.2.7 Parts:
- 3.2.7.1 Use of Standard Parts: Standard type parts not specified herein shall be selected from established standards and specifications, where such exist, providing that they are technically suitable. When two or more products will satisfy design requirements, the election shall be made in such manner as to be most economical to the purchaser.
- 3.2.7.2 Hydraulic Closures: Multi-screw retained flanges or covers for hydraulic components shall not be used where other methods are practical. When employed, structural and sealing adequacy shall be demonstrated by considering the most severe case of load and pressure, and all screws shall be positively safetied with lockwire in accordance with NASM 33540, or self-locking fasteners if approved by the procuring activity.
- 3.2.7.3 Filters and Screens: The requirements for an inlet filter as an integral component for the servoactuator shall be controlled by the detail specification. Screens shall be installed in all cylinder passages between the control servovalve and the cylinder when they are to be considered as individual maintenance items. They shall be located as specified in the detail specification. Screens shall be installed in the inlet to prevent hydraulic line contaminants from entering the servovalve or servoactuator provided that an integral filter is not a requirement. The screen pore size shall be stated in the detail specification.
- 3.2.7.4 Lock Wiring: All hardware and components which are not positively secured by other means, shall be secured by NASM 20995 lockwire or NASM 24665 cotter pins in accordance NASM 33540.
- 3.2.8 Identification and Marking:
- 3.2.8.1 Identification: The identification requirements for servoactuator shall be as specified in MIL-STD-130.

- 3.2.8.2 Marking and Serialization: Each servoactuator shall be marked and serialized. Placards shall be the engraved or chemically etched type and mechanically secured to the component parts. Adhesive foil placards use shall be approved by procuring activity. Placards and data plates shall be located such that they can be read when the component to which they are attached is installed in the air vehicle.
- 3.2.9 Safety: The servoactuator and its components shall be designed to provide a maximum of safety to personnel during the course of installation and maintenance. Adequate precautionary warnings are information that shall be affixed to components when considered necessary for safety or to prevent needless damage. An example is a component with a compressed spring. Special attachment or lift points shall be designated when the weight of the servoactuator requires special handling provisions. Servoactuators shall meet the safety requirements of AFSC DH 1-6 and MIL-HDBK-454. Applicable paragraphs of MIL-STD-882 shall be referred to for guidance.
- 3.2.10 Human Performance/Engineering: When applicable, the design shall consider and apply the principles, analysis, criteria and philosophies of Human Engineering as defined in MIL-STD-1472. This shall include the application, during all phases of the actuator design, of knowledge as to man's unique capabilities and limitations regarding the installation, operation and maintenance of the actuator package. The following general requirements are established to reduce the possibility of human errors during assembly and maintenance of the actuator package:
- a. When reversed or rotated mounting of an interfacing component cannot be tolerated, nonsymmetrical mounting arrangements (including keyways or pins) shall be used.
 - b. "Stacked" assemblies shall use flanged arrangements which prevent assembly if a part is omitted, or indicator markings which are exposed when the part is missing.
- 3.2.11 Bearings:
- 3.2.11.1 Antifriction Bearings: Approved type, ball bearings in accordance with AS6038, AS6039, and AS7949 shall be used except as indicated in the following paragraphs. Sealed bearings are preferable over shielded bearings in an atmospheric environment. Shielded or unprotected bearings are acceptable within the hydraulic fluid system environment. In the event design limitations do not permit the use of ball bearings, prelubricated, shielded roller or needle bearings may be used in accordance with AS39901. Where needle or roller bearings are used, consideration shall be given to relubrication provisions. The inner race of the bearing shall be clamped to prevent rotation of the inner race with respect to the pivot bolt. Bearing installation shall be arranged in such a manner that failure of the rollers or balls will not result in a complete separation of the attachment. Direct axial application of control forces to a bearing shall be avoided if possible.
- 3.2.11.2 Spherical Bearings: Where design limitations preclude the use of anti-friction bearings, spherical type, plain bearings approved by the procuring organization may be used.
- 3.2.11.3 Journal Bearings: The use of plain type journal bearings shall be avoided. However, where substantiated, and where play and friction are not major considerations, journal or plain bearings in accordance with AS8976 with adequate and accessible provisions for lubrication may be used.

- 3.2.11.4 Attachment Bearings: Self-aligning bearings or universal joints shall be used wherever necessary in end connections to remove excessive bending loads. Bending loads resulting from rotational friction in the bearing shall be taken into consideration. The detail specification shall specify the maximum amount of looseness of fit (backlash) of the attachment bearings (defined as bearings).
- 3.2.11.5 Sintered Bearings: Sintered type, or oil impregnated bearings shall not be used in those parts of the servoactuator which have slow moving or oscillating motions. Fast moving rotating applications such as in qualified motors are permissible.
- 3.3 Processes, Construction/Assembly Requirements:
- 3.3.1 Processes: Unless otherwise specified herein, processes or special tooling used in the design of this unit shall conform to the following:
- 3.3.1.1 Metal Coatings: Ferrous alloys heat-treated to 200,000 psi ultimate tensile strength and above shall utilize protective coatings which minimize or eliminate hydrogen embrittlement. These include vacuum deposited cadmium (AMS 2426 or AMS-C-8837), titanium cadmium (AMS 2419), or chromium applied in accordance with AMS 2406 or AMS QQ-C-320. External surfaces of ferrous alloy parts, including external seal grooves need not be coated if the chromium content of the alloy is greater than 12%. Anodized coatings shall be in accordance with MIL-A-8625.
- 3.3.1.2 Grinding: Grinding of high strength steel shall be in accordance with established procedures. Grinding of chrome-plated steel shall be in accordance with AMS 2403.
- 3.3.1.3 Stabilization: The detail specification shall specify the materials and processing required for dimensional stability. Martensitic steels heat treated to hardness of 50 RC or higher should be sub-zero treated during the hardening process in order to complete transformation for approximate dimensional stability.
- 3.3.1.4 Residual Magnetism: All parts made of materials that are capable of retaining residual magnetism, but are not intended to function as magnets, shall be demagnetized sufficiently to prevent system or component malfunction, including malfunction due to accumulation of magnetic contaminants.
- 3.3.1.5 Shot Peening: "Shot peening" for relief of metal stress shall be in accordance with AMS-S-13165.
- 3.3.2 Construction/Assembly Requirements:
- 3.3.2.1 Electrical Bonding and Grounding: Electrical bonding and grounding shall conform with the requirements of MIL-STD-464.
- 3.3.2.2 Staking, Peening, and Swaging: Each application of staking, peening, and swaging, or any other means of permanent deformation for locking purposes, shall be subject to procuring activity approval.

- 3.3.2.3 Safetying: Where practicable, threaded parts shall be safety wired in accordance with NASM 33540. Other means of safetying shall be subject to procuring agency approval.
- 3.3.2.4 Mechanical Joining: Individual parts may be mechanically joined with removable fasteners, or threaded connections, or by qualified methods for permanent joining.
- 3.3.2.5 Joining with Removable Fasteners: Unless otherwise specified, in the detail specification, all removable fasteners shall be selected and used as follows:
- Bolts smaller than 1/4 inch shall not be used to make single bolt connections, or connections essential to the structural performance of the servoactuator.
 - Pin joints on linkage that form a part of the actuator assembly and which do not require removal during installation shall be of the semi-permanent (huck bolt) type. In areas considered critical to safety of flight, and where practicable, NASM 33602 or NASM 3369 self-retaining bolts with NASM 21244 or NASM 21224 nuts in accordance with NASM 83050 shall be used. Other methods shall be subject to approval of the procuring activity.
 - Bolt joints shall use a positive method of retention such as self-locking nuts, plate nuts or safety wire. Self-locking nuts shall be in accordance with NASM 25027 or NASM 33588. However, if failure of a single fastener joint could result in reduction or loss of control then a dual locking device should be used.
- 3.3.2.6 Retention of Removable Fasteners: Removable fasteners, unless restrained from moving by the attachment of adjoining parts, shall incorporate a positive locking means or be safetied with cotter pins in accordance with NASM 24665 or be safety wired with NASM 20995 lockwire. Cotter pins and safety wiring shall be installed in accordance with NASM 33540. Self-locking externally threaded fasteners or self-locking nuts shall not be used except within the limitations specified in NASM 15981 and NASM 24665.
- 3.3.2.7 Threaded Joints: All threaded joints shall be provided with adequate wrenching and holding provisions for assembly and disassembly of the joint before and after service use. Internal screw threads and external threads shall be in accordance with the thread form requirements of AS8879. Pipe threads shall not be used.
- 3.3.2.8 Joint Retention: All adjoining parts shall be secured in a manner that will preclude loosening when subjected to internal or external loads or vibration.
- 3.3.2.9 Use of Retainer Rings: Retainer rings or pins shall not be used to retain loaded parts unless the rings are positively confined by a means other than depending on internal pressure or external loads. They shall not allow freeplay which could result in structurally destructive action or fatigue failure of the retained parts or failure of gaskets or packings. Where used, retainer rings shall be commercially available types which can be installed and removed with standard tools.

3.3.3 Workmanship:

- 3.3.3.1 Quality: The servoactuator manufacturer shall exercise extreme care in fabricating, assembling, handling, and packing units to assure that all parts are free from pits, rust, scrapes, splits, cracks, burrs, sharp edges, and discontinuities. An internal-external microscopic examination shall be made to determine parts are free of contaminants, e.g. metal chips. Any part or component appearing to have a crack shall be subject to microscopic examination and/or tests of 3.2.3.2.
- 3.3.3.2 Physical Defect Inspection: All magnetizable highly stressed parts shall be subjected to magnetic inspection in Accordance with ASTM E 1444. All nonmagnetizable highly stressed parts shall be subjected to fluorescent penetrant inspection in accordance with ASTM E 1417. Cracks or other injurious defects disclosed by the inspection shall be cause for rejection.
- 3.3.3.3 Control and Inspection of Forgings: Forgings and materials used in the assembly shall be controlled and inspected in accordance with the requirements of AMS-F-7190 or ASTM E 1444.

3.4 Performance:

- 3.4.1 Performance, Standard Conditions: The detail specification shall specify the operating conditions such as supply and return pressures, temperature, actuator load, magnitude of input, degree of filtration, etc., whenever a test is conducted to verify a stated requirement. All values of performance and the tolerances related thereto shall be stated in the detail specification.
 - 3.4.1.1 Dynamic Characteristics: Unless otherwise stated, the servoactuator shall meet the requirements and performance parameters set forth in Table 1.
 - 3.4.1.2 Control Valves:
 - 3.4.1.2.1 Synchronization: Servovalves in multiple channel servoactuators shall produce cylinder pressure in each hydraulic system which are synchronized to the degree specified in the detail specification. It is desirable to minimize the differential pressure between systems in order to minimize structural fatigue and degradation of performance. It is also desirable to minimize pressure fluctuations which may result from continuous, small amplitude, slow movement commands coupled with valve land overlap unbalances which may result in pressure vessel fatigue in single channel servoactuators.
 - 3.4.1.2.2 Flow Forces: When control valve flow force compensation is used to meet the valve input operating force requirements, it shall not produce a net negative force which tends to move the valve away from null. Therefore, the use of negative flow force on individual valve porting elements is not prohibited but limited to the extent that the next valve flow force will tend to return the valve to null.

TABLE 1 - Dynamic Characteristics

Parameter	Requirements
Frequency Response	An input of 2 to 5% total amplitude and an input of 10 to 25% total amplitude shall be used. The output at these inputs to be within specified maximum and minimum limits.
Transient Response	Step input of 5%, 10%, 25% and/or 100% of total amplitude for both loaded and unloaded conditions.
Linearity	As defined in detail specification.
Rated Velocity	As defined in detail specification.
Threshold	As defined in detail specification.
Hysteresis	As defined in detail specification.
Null Shift	As defined in detail specification for changes in temperature, hydraulic supply pressure, acceleration, life, and use.
External Loads	As defined in detail specification.
Attachment Bearing Friction under Load	As defined in detail specification.
Open Loop Gain	As defined in detail specification.
Chatter	As defined in detail specification.
Gain Margin and Phase Margin	As defined in detail specification and in accordance and compatible with the MIL-F-9490 nonaerodynamic loops.
Stiffness	As defined in detail specification including test methods and procedures set forth in AFFDL-TR-74-116.
Damping Factor under Various Operating Modes	As defined in detail specification.
Solenoid Valve Operated Device Response Time	As defined in detail specification.
Position Sensitivity	As defined in detail specification.

- 3.4.1.2.3 Friction: Breakout and dynamic friction shall be in accordance with the detail specification.
- 3.4.1.2.4 Servovalve Stops: The servovalve travel shall be limited in both directions by (internal or external) stops that are integral to the actuator. These stops shall withstand a limit load specified in the detail specification without deformation or jamming.
- 3.4.1.2.5 Direction of Force: The detail specification shall specify the permissible change in input operating force due to misalignment of the input to the valve.
- 3.4.1.2.6 Input/Valve Operating Force: The detail specification shall specify the force requirements that will be applied to the valve and linkage or generated within the actuator:
- for shearing any particle of contamination that may enter the valve
 - when actuator is bottomed-out during maximum rate or displacement
 - to move or to hold valve in any position.

3.4.2 Leakage:

- 3.4.2.1 External Leakage: The detail specification shall establish allowable external leakage rates past hydraulic seals which contact components moving relative to the seals such as rod end glands. Methods of checking the leakage and conditions shall be specified based on the assembly configuration.
- 3.4.2.2 Internal Leakage: Maximum (and minimum, if required) leakage from inlet to return and the associated conditions shall be specified in the detail specification. The leakage value shall represent the total for all individual components including seals and the control valve.
- 3.4.2.3 Intersystem Leakage: Allowable leakage between systems for multi-hydraulic supplied actuators shall be specified. The leakage value shall be specified under conditions of temperature and extreme differences between systems supply and return pressures.

3.4.3 Reliability:

- 3.4.3.1 Mean Time Between Failure: The mean time between failure (MTBF) of the servoactuator shall be specified in the detail specification and shall conform to the value established for the airframe contractor based on environment, utilization, complexity, and alternate modes of operation of the system. Different values of MTBF may be defined for specific failure modes. The MTBF shall be defined in terms of duty cycles or hours together with the confidence level. In addition, a MTBF shall be specified for actual flight test and service operation. Failure shall be defined as any malfunction causing performance degradation outside the limits as defined in the detail specification.
- 3.4.4 Performance, Environmental Conditions: The servoactuator shall not suffer any damage, deterioration, or degradation of performance when subjected to any environment or any natural combination of environments within the aircraft operational envelope as encountered during worldwide ground and airborne operations, as specified in MIL-STD-810 and in the detail specification. The servoactuator shall meet all the requirements listed in Table 2. The detail specification shall specify when applicable, the allowable damage and degraded performance after an extended life period for the servoactuator.
- 3.4.5 Input and Output Limit Loads:
 - 3.4.5.1 Input Limit Loads: Where mechanical pilot inputs are required, the detail specification shall specify the limit load which may be reached through the input and feedback linkage system in either direction in any position, including stops, with hydraulic systems energized or deenergized without permanent deformation set or brinelling of parts.

TABLE 2 - Environmental Criteria

Environment	Applicable Document (s)
Temperature, Ambient	Per detail specification
Fluid Temperature	Per detail specification
Altitude	Per MIL-STD-810, Method 500 or RTCA/DO-160
Thermal Shock	Per detail specification
Salt Spray	Per MIL-STD-810, Method 509 or RTCA/DO-160
Sand and Dust	Per MIL-STD-810, Method 510 or RTCA/DO-160
Mechanical Shock	Per MIL-STD-810, Method 516 or RTCA/DO-160
Acoustic Noise	Per MIL-STD-810, Method 515 or RTCA/DO-160
Acceleration	Per detail specification
Humidity	Per detail specification
Fungus	Per detail specification
Icing Conditions	Per MIL-STD-810, Method 521.1 or RTCA/DO-160
Vibration	Per MIL-STD-810, Method 514 or RTCA/DO-160

- 3.4.5.2 Output Limit Loads: The detail specification shall specify the maximum output limit load including inertial loads resulting from the maximum pressure differential which can be generated by any sustained pressure transient in the hydraulic system, above the normal operating pressures, across the actuator for all stroke positions of the actuator, without permanent deformation or brinelling of parts. When the output load contains a significant inertial component the detailed specification shall establish the on-ground full travel operation of the actuator. These loads shall be combined with the acceleration limit load factors as defined in 3.4.4.
- 3.4.5.3 Output and Input Ultimate Load: The detailed specification shall define the input and output ultimate loads and specify the period of time that the servoactuator must withstand without failure with the output restrained. A nominal value for the ultimate loads is 1.5 times the limit loads specified in 3.4.5.1 and 3.4.5.2.
- 3.4.6 Load Capability of Dual-Load-Path-Elements: The load path remaining after a single failure in dual-load-path elements shall meet the following requirements:
- Where the failure is not evident by visual inspection, the remaining path shall be capable of sustaining a fatigue spectrum equivalent to the period between overhauls or as specified in the detail specification.
 - Where the single failure is obvious, the remaining load path shall be capable of withstanding, as ultimate load, loading equal to 1.15 times limit loads.
- 3.4.7 Fatigue: The servoactuator shall be designed to withstand all loading requirements for its specified application without the occurrence of fatigue failures during its specified useful life. The load cycles spectrum shown in Table 4 in 4.7.14.2 is a design example.

3.4.8 Operating Life:

- 3.4.8.1 Total Cycles: The detail specification shall define an operating spectrum of percent stroke versus number of cycles for the servoactuator which shall be commensurate with its operational use as defined in MIL-F-9490.
- 3.4.8.2 Impulse Cycles: The detail specification shall specify the total number of impulse cycles the servoactuator shall be subjected to at the most critical output positions (e.g., retract and extend, if most critical).
- 3.4.8.3 Useful Life: The detail specification shall specify the useful life of the servoactuator which shall be considered as the time of its delivery from the supplier's facility until its identity is destroyed.

3.5 Installation/Maintenance Requirements:

3.5.1 Maintainability:

- 3.5.1.1 Maintainability Characteristics: Unless otherwise specified in the detail specification, the maintainability requirements shall be in accordance with MIL-HDBK-470. The servoactuator shall be designed such that the planned mission can be accomplished with a minimum expenditure of maintenance man-hours, elapsed time, personnel skills, Aerospace Ground Equipment (AGE), and technical data. The specific quantitative maintainability requirements shall be specified in terms of:
 - a. The mean elapsed time required to perform corrective maintenance (M_{ct}) on the servoactuator while installed in the air vehicle.
 - b. The 90 percentile maximum elapsed time required to perform corrective maintenance (M_{max}) on the servoactuator while installed in the air vehicle.
 - c. The mean elapsed time required to perform preventive maintenance (M_{pt}) on the servoactuator while installed in the air vehicle.
 - d. The mean maintenance man-hours required to perform a maintenance task, including overhaul, in the field and depot maintenance shops.
 - e. The mean, elapsed time required to perform servicing maintenance (M_{st}) on the unit while installed in the air vehicle.
 - f. The mean time between unscheduled removals (MTUR).
 - g. The mean time between unscheduled maintenance actions (MTBUM).
- 3.5.1.2 Maintenance and Repair Cycles: The detail specification shall specify the time interval between preventative maintenance tasks for actuator operating hours. The time interval between filter element replacement shall be specified in actuator operating hours and shall be based upon maintaining the hydraulic fluid cleanliness within the actuator at all times to Class 7 (military) or Class 8 (commercial) per AS4059 or better.

- 3.5.1.3 Installation and Accessibility: The servoactuator shall be designed, installed and located such that inspection, rigging, repair, lubrication and connection of such test equipment as may be required for field maintenance, can be readily accomplished without removal of the servoactuator from the aircraft. Installation should be implemented without requiring adjustments of the servoactuator. The design shall permit use of standard tools and test equipment. Suitable provisions for rigging pins, or the equivalent, shall be made in the mechanical input linkage. The detail specification shall define, as required, the method and accuracy of rigging the input.
- 3.5.1.4 Lubrication: All components requiring lubrication other than those being lubricated with the hydraulic fluid shall be capable of being lubricated in accordance with MIL-HDBK-838. Lubricator fittings and bushings or equivalent shall be provided in all end connections where relative motion between the mating parts exists, other than that caused by deflections between mating parts, unless ball or permanently lubricated bearings are used. Design of the end connection shall permit installation of oversize bushings when required. Whenever possible, permanently lubricated components shall be provided.
- 3.5.2 Contamination: The servoactuator including all control valves (servo, electrohydraulic, hydraulic logic, solenoid, etc.) shall be capable of meeting detail specification performance requirements for a specified period while operating in a hydraulic fluid with a contamination level of Class 8 or less as defined in AS4059. An appropriate higher value of fluid contamination level may be specified to ensure adequate insensitivity of servoactuator to fluid contamination.
- 3.5.3 Electromagnetic Interference: Servoactuators operated and controlled by an electrical input shall be designed to meet the requirements of MIL-STD-461 and MIL-STD-464. The degree of compliance per MIL-STD-461 for actuator performance, test procedures and test equipment shall be as set forth in MIL-STD-461 and the detail specification.
- 3.5.4 Interchangeability: Parts, components, sub-assemblies, and assemblies shall be interchangeable both physically and performance-wise with other parts bearing the same part number.
- 3.6 Documentation:
- 3.6.1 Analysis Requirements: The detail specification shall indicate the general analysis approach and analysis procedures that could be applicable to all servoactuator designs for the specific vehicle.
- 3.6.2 Reliability Analysis: A reliability analysis of the servoactuator using a reliability mathematical model shall be performed. The failure mode and effects portion of this analysis shall be prepared in accordance with ARP926.
- 3.6.3 Design Analysis: As a minimum, the following areas shall be considered:
- 3.6.3.1 Performance: Substantiation of servoactuator performance and limits thereof.
- 3.6.3.2 Moving Parts Clearance: Demonstration of adequate clearance of all moving parts under all combinations of environments and loads.

- 3.6.3.3 Selection of Materials and Minimum Size of Structural Members: Justification shall be provided for materials and processes employed and for all operational stress levels anticipated.
- 3.6.4 Qualification Analysis: When items, components, or complete servoactuators are qualified on similarity basis, sufficient data, i.e. test and/or analytical data shall be furnished to the procuring activity to demonstrate that those part, or parts, can be fully qualified.
- 3.6.5 Drawings: Unless otherwise specified in the detail specification, drawings applicable to parts, components, subassemblies and the complete servoactuator assembly shall be in accordance with ASME Y14.100, ASME Y14.24, ASME Y14.34M, ASME Y14.35M. Schematic drawings of the servoactuator's hydraulic, electrical and mechanical linkage systems shall form a part of the drawings to be submitted. Hydraulic schematics shall use AS1290 graphic symbols.
- 3.6.6 Plastic Model: A plastic model (full scale) may be submitted in lieu of written documentation to demonstrate non-interference of moving parts, spacing of fluid passages, etc., on complex servoactuator sections or of the complete assembly.

4. QUALITY ASSURANCE PROVISIONS:

4.1 General:

The quality assurance provisions shall be in accordance with the detail specification and as specified herein. The supplier shall have a quality system which conforms to the requirements of the procuring agency. Except as otherwise specified, the supplier may utilize his own or any other inspection facilities and services acceptable to the procuring activity or airframe contractor as specified in the contract.

4.2 Test Requirements:

Appropriate testing, as outlined herein, shall be conducted during the development and production of servoactuators to insure proper design and performance, continuing quality throughout production, and the degree of unit reliability expected in service.

- 4.2.1 Optional Procedures: At the option of the procuring organization any of the test requirements specified herein may be waived, or modified, owing to design experience or operating considerations. Request for waiver or modification of test requirements shall be accompanied by complete detailed information and justification.

4.3 Classification of Tests:

The following test programs, for the purpose of demonstrating compliance of servoactuators with the requirements of this specification, shall be classified as follows:

- 4.3.1 Acceptance Tests: These tests are performed on each servoactuator to demonstrate baseline performance.

- 4.3.2 Preproduction Tests: These tests are performed on the initial unit(s) to provide a basis for preliminary design approval to proceed with the production program and initial aircraft flight tests. The preproduction test specimens shall approximate as nearly as practicable the intended units in design configuration, material, processing and production techniques. Safety of flight assurance tests, in addition to the acceptance tests, shall be as specified in the detail specification and should include tests as outlined in 4.7.
- 4.3.3 Qualification Tests: These tests are performed on production configuration servoactuators to confirm full compliance with the requirements of the detail specification. Each test specimen shall initially and periodically throughout the qualification tests, be subjected to the Acceptance Tests per 4.3.1.

4.4 Test Procedures:

- 4.4.1 Acceptance Test: The acceptance test procedure shall specify those tests which each servoactuator shall satisfactorily complete as a condition for acceptance. The procedure shall insure that each servoactuator which is accepted meets the basic dimensional and performance requirements. It shall describe tests in detail indicating the environmental conditions, specifying the test fixtures, equipment and instrumentation, the format of the individual unit test data sheet or test log, and the measurements and observations which shall be recorded. The procedure shall be updated when subsequent testing or usage indicates additional or modified tests should be incorporated.

The acceptance test limits may be more restrictive than the specification limits because they apply to new equipment in a test laboratory environment while the specification applies to a unit in the operational environment for the whole service life.

- 4.4.2 Preproduction Test Procedure: The preproduction or safety of flight test procedure shall specify those tests which are necessary to demonstrate the servoactuator is satisfactory for limited life usage for initial flight tests prior to formal qualification test completion. Cycle testing tests may be abbreviated to meet expected environmental conditions during flight tests. As a minimum, the preproduction or safety of flight tests shall include the tests of 4.7.
- 4.4.3 Qualification Test Procedure: The qualification test procedure shall specify those tests which are necessary to demonstrate that the servoactuator is satisfactory for the use for which it is intended. As a minimum, the qualification tests shall include all the applicable tests specified in 4.8 and its subparagraphs. These tests shall demonstrate that adequate margins exist with respect to all the critical parameters associated with the intended use of the servoactuator. Additional tests shall be added to the plan whenever it appears that the specified tests do not measure all of the parameters which may be critical in a particular application, such as certain dynamic characteristics of the servoactuator. The qualification test procedure shall prescribe the format for the test log and detail instructions for maintaining the test log. Also, provisions shall be included in the test procedure for certification by a representative of the procuring activity at stated periods during testing. The test procedure shall establish the procedure to be followed when the test specimens do not meet the individual test requirements.

4.5 Test Conditions:

- 4.5.1 Test Fluid: Unless otherwise specified in the detail specification, the test fluid for Type I and Type II system components on military aircraft shall conform to Specification MIL-PRF-83282, MIL-PRF-87257, or MIL-PRF-46170. The test fluid for Type III components on military aircraft shall be the same as or equivalent to the fluid specified in the detail specification. The test fluid for the commercial aircraft application shall be per AS1241. For preproduction and qualification tests, the test fluid shall be the same fluid as that to be used in the system in which the actuator will be installed.
- 4.5.2 Fluid Temperature: Unless otherwise specified the fluid temperature shall be maintained as specified for each individual test with a tolerance of $\pm 10^{\circ}\text{F}$ ($\pm 6^{\circ}\text{C}$). If the fluid temperature is not specified, the temperature shall be $100^{\circ}\text{F} \pm 10^{\circ}\text{F}$ ($38^{\circ}\text{C} \pm 6^{\circ}\text{C}$). The fluid temperature shall be measured as near as practicable to the servoactuators and shall be bled of air and inert gas and maintained full of fluid per 4.5.1.
- 4.5.3 Test Fluid Filtration: Unless otherwise specified in the detail specification, the test fluid shall be continuously filtered through a filter element which conforms to specification MIL-PRF-8815 (15 micron or equivalent efficiency). The filter and element used shall be satisfactory for the temperature range encountered. Unless otherwise specified in the detail specification, the degree of contamination in the test set up, except for those tests required per 4.8.21, shall not exceed Class 7 (military) or Class 8 (commercial) per AS4059.
- 4.5.4 Hydraulic Power Supply: Tests shall be conducted with a power driven pump or fluid power source capable of supplying pressures and flow at the servoactuator ports as required by the detail specification. The test setup shall be such as to prevent air or moisture from coming in contact with the hydraulic fluid. Pressure spikes, pump ripple, contamination level, etc. shall be specified by the detail specification.
- 4.5.5 Environmental Conditions: Unless otherwise specified in the detail specification, the ambient temperature tolerance shall be $\pm 1^{\circ}\text{F}$ ($\pm 0.6^{\circ}\text{C}$) for test values specified herein. If environmental conditions are not specified or if "room conditions" are specified, the ambient temperature shall be $73^{\circ}\text{F} \pm 18^{\circ}\text{F}$ ($23^{\circ}\text{C} \pm 10^{\circ}\text{C}$), the barometric pressure shall be 27.3 inches of mercury ± 3.3 inches of mercury, and the relative humidity shall not exceed 80%.
- 4.5.6 Test Instruments: The instruments used to measure and record required test parameters shall be calibrated in accordance with MIL-STD-1839 and shall meet the accuracy requirements of MIL-STD-810. These instruments shall be recalibrated as necessary to insure accuracy of test results.
- 4.5.7 Test Fixtures: The servoactuators shall be mounted in appropriate test fixtures during testing outlined herein. The detail specification shall specify the degree to which the fixture will simulate the aircraft installation including structural compliance. The aerodynamic and inertia loading shall be utilized during the performance and endurance portion of the qualification tests.

- 4.5.8 **Steady-State Tests:** Steady-state tests are defined as tests conducted under selected steady-state conditions. Each test is usually conducted as an individual test, but in some cases may be combined, subject to the selected constant conditions. These tests do not include all the conditions to which the servoactuator will be subjected, but will be representative of those conditions and are intended to provide proof that the unit will operate satisfactorily in service under these conditions.
- 4.5.9 **Mission-Profile Tests:** Because of the advance in aircraft performance with the accompanying complexity in requirements, purely steady-state condition tests may be insufficient to provide proof that the component will operate satisfactorily in service. In such cases, it will be necessary to conduct tests simulating the frequency, magnitude, and duration of the conditions which the servoactuator is expected to encounter during the course of an actual air vehicle mission. Mission-shock, altitude, vibration, acceleration, shock, performance, and endurance tests as one integrated test, or as specified in the detail specification.
- 4.6 **Acceptance Test Methods:**
- 4.6.1 **General:** Each servoactuator shall be subjected to the following examination and acceptance tests specified in the detail specification. These tests may be supplemented by individual component tests when required.
- 4.6.2 **Examination of Product:** The servoactuator shall be carefully examined to determine conformance with the requirements of this specification and the detail specification for workmanship, marking, conformance to applicable engineering drawings, conformance to applicable specifications and standards, and for any visible defects.
- 4.6.3 **Operation and External Leakage:** The servoactuator shall be cycled with the piston rod unrestrained through at least 500 full stroke cycles to demonstrate satisfactory operation, stroke, adjustment, freedom of motion, and other characteristics when specified in the detail specification. Pressure shall build up to system pressure at the end of each stroke. There shall be no leakage allowed at any joint or boss. Leakage, at each point where motion through external packings exist, shall meet the requirements of the detail specification.
- 4.6.4 **Chatter:** During the course of testing, the output motion of the servoactuator shall be monitored for evidence of adverse noise, chatter or instability. If a special test is required, testing procedure shall be as specified in the detail specification.
- 4.6.5 **Proof Pressure:**
- 4.6.5.1 **Inlet Proof Pressure:** The inlet port of the servoactuator shall be subjected to a pressure of 5 psig and also to 1.5 times the nominal operating pressure or the applicable proof pressure as specified, whichever is greater, for a period of 3 minutes for each pressure application. These pressures shall be applied with a maximum input signal or command position and the piston in both the fully extended and retracted directions. There shall be no evidence of external leakage (other than slight wetting at seals insufficient to form a drop), excessive distortion or permanent set.

- 4.6.5.2 Return Proof Pressure: The return port of the servoactuator shall be subjected to the rated system pressure or the specified return proof pressure whichever is greater, for a period of 3 minutes. There shall be no evidence of external leakage (other than a slight wetting at seals insufficient to form a drop), excessive distortion or permanent set.
- 4.6.6 Internal Leakage: The servoactuator shall be subjected to nominal operating pressure at the inlet port with the return port vented to atmosphere for a period of 5 minutes for each pressure application. The pressure shall be applied with a neutral or zero input signal or position and the servoactuator in its neutral position, and at each end of the stroke with extend and retract signal applied. The leakage measurement shall be taken in the last 3 minutes of the 5 minute period. Rate of leakage shall be within the range specified in the detail specification.
- 4.6.7 Supplementary Acceptance Tests: The detail specification shall specify the applicable acceptance test procedures from Table 1.

TABLE 3 - Acceptance Test

Paragraph No.	Test	Reference Paragraph
4.6.7.1	Loop Gain	Table 1
4.6.7.2	Position Sensitivity	Table 1
4.6.7.3	Rated Velocity	Table 1
4.6.7.4	Threshold	Table 1
4.6.7.5	Hysteresis	Table 1
4.6.7.6	Frequency Response	Table 1
4.6.7.7	Transient Response	Table 1
4.6.7.8	Chatter	Table 1
4.6.7.9	Stiffness	Table 1
4.6.7.10	External Load	Table 1
4.6.7.11	Null shift	Table 1
4.6.7.12	Gain Margin and Phase Margin	Table 1
4.6.7.13	Synchronization	3.3.1.2.1
4.6.7.14	Electrohydraulic Servovalve	3.1.1.2
4.6.7.15	Dielectric Strength	3.1.2.2
4.6.7.16	Snubbing Rates	3.1.5.1.5
4.6.7.17	Linearity	Table 1

- 4.6.8 Rejection and Retest: Failure of any servoactuator to conform to any of the acceptance tests shall be cause for rejection of that assembly. Servoactuator assemblies which have been rejected may be reworked or have parts replaced to correct the defects found in the original and resubmitted for acceptance. Replaced parts shall be in accordance with outstanding detail design drawings.

4.7 Preproduction Test Methods:

- 4.7.1 Sampling and Tests: The number of specimens to be used in testing, the applicable tests, and the order of combination in which the tests will be performed for each specimen shall be in accordance with the detail specification.

- 4.7.2 Pretest Inspection: The diameters, out of roundness, and finish smoothness on sliding surfaces such as cylinder bore, piston rods, and control linkage bearing surfaces, shall be accurately determined for each test specimen and recorded prior to initiation of the test program in order to determine degradation of the equipment due to the specified test.
- 4.7.3 Acceptance Tests: Each test specimen shall be subjected to the acceptance tests as defined in 4.6, to determine baseline capability and performance.
- 4.7.4 Proof Load: The inlet proof pressure test per 4.6.5 shall be repeated except the servoactuator shall be installed in a fixture with the piston rod restrained in an extended piston at one or more of its critical positions as a column (piston not bottomed). The test shall be conducted with both ambient and hydraulic fluid temperatures corresponding to the maximum rated value for the servoactuator type classification.
- 4.7.5 Pressure Drop: Pressure drop characteristics for the flow range specified in the detail specification shall be determined for each test unit.
- 4.7.6 Cylinder Friction: The minimum differential pressure or force required to move an unrestrained piston rod through its complete extend and retract strokes shall be conducted upon a completely assembled unit to include effects of distortion due to torquing and manifold attachments.
- 4.7.7 Immersion: Servoactuators containing nonmetallic parts other than standard seals and glands conforming to AS4716, shall be immersed in the specified hydraulic fluid for a period of 12 hours prior to conducting subsequent tests listed herein. The fluid temperature level shall be 160 °F ± 2 °F for Type I units, 275 °F ± 5 °F for Type II units, and 390 °F ± 8 °F for Type III units.
- 4.7.8 Performance Verification Tests: The portion of the acceptance tests per 4.6 to be conducted before, during or after each of the following tests shall be as specified in the detail specification. These tests shall be in addition to the MIL-STD-810 requirements for a particular test method. In addition to the specified tests involving solenoid dielectric strength before, during, or after each test, additional dielectric tests should be conducted to prove compliance with the requirements of 3.2.2.2.
- 4.7.9 Extreme Temperature Performance: The detailed specification shall describe the actual procedure for accomplishing the following:
- 4.7.9.1 High Temperature: The servoactuator shall be filled with fluid at a static head of 1 to 3 feet, then shall be subjected to the maximum temperature for the servoactuator type classification for a period of 2 hours, following stabilization of the temperature of the test unit. With the servoactuator at the specified temperature, it shall be slowly cycled through 25 full stroke cycles with pressure buildup to operating pressure at the end of each stroke. The first full cycle shall be made with fluid at the specified temperature. There shall be no evidence of binding of mating parts and leakage shall not exceed the requirements specified in the detail specification.