

MIL-V-24630(SH)
AMENDMENT 3
29 June 1990
SUPERSEDING
AMENDMENT 2
18 April 1988

MILITARY SPECIFICATION

VALVES, CHECK, IN-LINE, FOR HYDRAULIC FLUID
AND LUBRICATING OIL FLUID

This amendment forms a part of MIL-V-24630(SH), dated 19 March 1984, and is approved for use by the Naval Sea Systems Command, Department of the Navy, and is available for use by all Departments and Agencies of the Department of Defense.

PAGE 1

At bottom of page add:

"AMSC N/A

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PAGE 8

3.5.9, line 2: Delete "4000" and substitute "3000".

3.5.10, add: "The valve shall be subjected to a salt spray test if materials other than specified herein are used for the valve external body. When more than one design is developed by the same contractor who uses the same method of surface preservation for all designs, only one representative unit shall require this test, provided the same materials are used. Test data on similar equipment with the same base and coating materials and equivalent coating thickness may be used to meet this requirement."

3.5.13: Delete.

* 3.5.14 and Table II: Delete.

PAGE 10

3.9: Delete and substitute:

"3.9 Drawings. When specified (see 6.2.1), reproducible (or microfilm) assembly drawings identical to those specified in 4.3.2 shall be provided (see 6.2.2)."

PAGE 11

4.3, second sentence: Delete.

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1 of 4

MIL-V-24630(SH)
AMENDMENT 3

PAGES 11 AND 12

* Table III: Delete and substitute:

TABLE III. Qualification and quality conformance inspections.

Inspection	Requirement paragraph	Test method paragraph	Qualification 2/		Quality conformance
			Sample 1 (maximum clearance)	Sample 2 (minimum clearance)	
Visual, mechanical and radiographic inspection	3.1, 3.3, 3.4, 3.6, 3.7, 3.8 and 3.10	4.6.1		X	X
External	3.4.1	4.6.1.1	X	X	X
Internal	3.4.2	4.6.1.2	X	X	X
Interchangeability	3.6	4.6.1.3	X	X	
Maintainability	3.4.3, 3.4.3.1, 3.4.3.2	4.6.1.4		X	
Pressure drop at rated flow capacity	3.5.2, 3.5.3	4.7.1	X		
Proof pressure	3.5.4	4.7.2	X	X	X
Leakage	3.5.5	4.7.3	X	X	X
Operation	3.5.6	4.7.4	X	X	
Checking time	3.5.6.1	4.7.4.1	X	X	
Cracking pressure	3.5.6.2	4.7.4.2	X	X	X
Temperature extremes	3.5.7	4.7.5, 4.7.5.1, 4.7.5.3		X	
Endurance	3.5.8	4.7.6	X		
Fatigue rating	3.5.9	4.7.7	X 1/		
Salt spray	3.5.10	4.7.8		X	
Vibration	3.5.11	4.7.9		X	
Shock	3.5.12	4.7.10		X	

See footnotes at end of table.

MIL-V-24630(SH)
AMENDMENT 3

TABLE III. Qualification and quality conformance inspections. - Continued

Inspection	Requirement paragraph	Test method paragraph	Qualification 2/		Quality conformance
			Sample 1 (maximum clearance)	Sample 2 (minimum clearance)	
Structureborne noise	3.5.15	4.7.13	X		

1/ While tests can be conducted on a single sample, additional samples allow reduction in test pressure.

2/ For purpose of qualification, a valve of the next smaller or larger size may be used to fulfill the requirement for two samples.

4.3.1, item (b): Delete and substitute:

"Qualification tests shall normally be conducted on at least two specimens of each size valve, manufactured to the adverse dimensions of 4.3.1.1 and 4.3.1.2. However, qualification tests may be conducted on a single specimen manufactured to nominal dimensions when approved by the qualifying activity based on an engineering analysis, submitted with the application for qualification testing, which shows the valve will operate satisfactorily with adverse tolerances. When a single specimen is tested for qualification, the tests for sample 2 shall be conducted in addition to the tests for sample 1. Tests which are the same for both samples need not be repeated when a single sample is tested."

4.3.1, item (d): Add: "Only a single specimen is required for these tests, and the adverse tolerance requirements of 4.3.1.1 and 4.3.1.2 do not apply."

PAGE 13

4.3.2, first sentence: Delete and substitute: "Two sets of assembly drawings shall be furnished for each valve for which approval to conduct qualification tests is requested. In addition, machining drawings and sketches shall be provided identifying the normal tolerances for those portions of specimens which will be manufactured to minimum and maximum clearance as specified in 4.3.1.1 and 4.3.1.2."

MIL-V-24630(SH)
AMENDMENT 3

PAGE 15

4.7.3.1, line 9: Delete "in accordance with MIL-H-17672".

4.7.3.2, line 8: Delete "conforming to MIL-H-17672".

4.7.5: Add at the end of the last sentence: "or MIL-H-5606."

PAGE 16

4.7.8: Add "The salt fog test is not required if the valve body is constructed of material specified in 3.3.1, 3.3.1.1 and 3.3.1.2. For other body materials, the salt fog test may be waived, but only at the discretion of NAVSEA."

PAGE 17

4.7.11: Delete.

* 4.7.12: Delete.

NOTE: The margins of this amendment are marked with asterisks to indicate where changes (additions, modifications, corrections, deletions) from the previous amendment were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous amendment.

Preparing activity:
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