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# **Pneumatic fluid power — Determination of flow-rate characteristics of components using compressible fluids —**

## **Part 1: General rules and test methods for steady-state flow**

*Transmissions pneumatiques — Détermination des caractéristiques  
de débit des composants traversés par un fluide compressible —*

*Partie 1: Règles générales et méthodes d'essai en régime stationnaire*



Reference number  
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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 6358-1 was prepared by Technical Committee ISO/TC 131, *Fluid power systems*, Subcommittee SC 5, *Control products and components*.

This first edition of ISO 6358-1, together with ISO 6358-2 and ISO 6358-3, cancels and replaces ISO 6358:1989, which has been technically revised. However, ISO 6358-2 and ISO 6358-3 are new standards whose scopes were not included in ISO 6358:1989.

ISO 6358 consists of the following parts, under the general title *Pneumatic fluid power — Determination of flow-rate characteristics of components using compressible fluid*:

*Part 1: General rules and test methods for steady-state flow*

*Part 2: Alternative test methods*

The following parts are under preparation:

— *Part 3: Method for calculating steady-state flow-rate characteristics of assemblies*

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## Introduction

In pneumatic fluid power systems, power is transmitted and controlled through a gas under pressure within a circuit. Components that make up such a circuit are inherently resistive to the flow of the gas and it is necessary, therefore, to define and determine the flow-rate characteristics that describe their performance.

ISO 6358:1989 was developed to determine the flow-rate characteristics of pneumatic valves, based upon a model of converging nozzles. The method included two characteristic parameters: sonic conductance,  $C$ , and critical pressure ratio,  $b$ , used in a proposed mathematical approximation of the flow behaviour. The result described flow performance of a pneumatic valve from choked flow to subsonic flow, based on static pressure. This new edition uses stagnation pressure instead, to take into account the influence of flow velocity on the measurement of pressures.

Experience has demonstrated that many pneumatic valves have converging-diverging characteristics that do not fit the ISO 6358:1989 model very well. Furthermore, new developments have allowed the application of this method to additional components beyond pneumatic valves. However, this now requires the use of four parameters ( $C$ ,  $b$ ,  $m$ , and  $\Delta p_c$ ) to define the flow performance in both the choked and subsonic flow regions.

This part of ISO 6358 describes a set of four flow-rate characteristic parameters determined from test results. These parameters are described as follows and are listed in decreasing order of priority:

The sonic conductance,  $C$ , corresponding to the maximum flow rate (choked) is the most important parameter. This parameter is defined by the upstream stagnation conditions.

The critical back-pressure ratio,  $b$ , representing the boundary between choked and subsonic flow is second in importance. Its definition differs here from the one in ISO 6358:1989 because it corresponds to the ratio of downstream to upstream stagnation pressures.

The subsonic index,  $m$ , is used if necessary to represent more accurately the subsonic flow behaviour. For components with a fixed flow path,  $m$  is distributed around 0,5. In these cases, only the first two characteristic parameters  $C$  and  $b$  are necessary. For many other components,  $m$  varies widely. In these cases, it is necessary to determine  $C$ ,  $b$ , and  $m$ .

The parameter  $\Delta p_c$  is the cracking pressure. This parameter is used only for pneumatic components that open with increasing upstream pressure, such as non-return (check) valves or one-way flow control valves.

Several changes to the test equipment were made to overcome apparent violations of the theory of compressible fluid flow. This includes expanded inlet pressure-measuring tubes to satisfy the assumptions of negligible inlet velocity to the item under test and to allow the inlet stagnation pressure to be measured directly. Expanded outlet tubes allow the direct measurement of downstream stagnation pressure to better accommodate the different component models. The difference between stagnation pressure at upstream and downstream of component means a loss of pressure energy.

For testing a component with a large nominal bore, to shorten testing time or to reduce energy consumption, it is desirable to apply the methods specified in ISO 6358-2, which covers a discharge test and a charge test as alternative test methods.

ISO 6358-3 can be used to calculate without measurements an estimate of the overall flow-rate characteristics of an assembly of components and piping, using the characteristics of each component and piping determined in accordance with this part of ISO 6358 or ISO 6358-2.

It should be noted that performance characteristics measured in accordance with this edition of ISO 6358 differ from those measured in accordance with ISO 6358:1989.