

NAVSEA  
STANDARD ITEM

**FY-28**

ITEM NO: 009-025  
DATE: **01 OCT 2025**  
CATEGORY: II

1. SCOPE:

1.1 Title: Structural Boundary Test; accomplish

2. REFERENCES:

2.1 S9AA0-AB-GOS-010, General Specifications for Overhaul of Surface Ships (GSO)

2.2 S9086-RJ-STM-010/CH-504, Pressure, Temperature, and other Mechanical and Electromechanical Measuring Instruments

3. REQUIREMENTS:

3.1 Accomplish a completion air test of spaces in accordance with Section 192 of 2.1 and the following:

3.1.1 Install 2 independent pressure gauges. Each test gauge must conform to gauge range and graduation shown on 504-3.5.1 and 504-6.1.5 of 2.2.

3.1.2 Install 2 relief valves set at a maximum of 10 percent above test pressure.

3.1.3 Install one vent valve.

3.1.4 The air source must not exceed 25 PSIG and must have a supply capability less than the exhaust capability of either relief valve.

3.1.5 Pressurize the tank/void/space to be tested to the pressure specified in the invoking Work Item.

3.1.5.1 Isolate the pressure source and hold pressure for 15 minutes for temperature stabilization prior to commencing the pressure drop test.

3.1.5.2 Measure the pressure drop of the tested space for 10 minutes. Allowable pressure drop must be as specified in the invoking Work Item.

3.1.6 Accomplish unobstructed airflow test of air escape and overflow piping in accordance with Section 506h of 2.1.

3.1.7 Accomplish a visual inspection of disturbed mechanical joints for leakage upon completion of filling each tank. Allowable leakage: None.

3.1.8 Submit one legible copy, in approved transferrable media, reporting the results of the test listing the requirements of 3.1 through 3.1.7 to the SUPERVISOR.

3.2 Accomplish a running air test of spaces in accordance with Section 192 of 2.1, and the following:

3.2.1 Install 2 independent pressure gauges. Each test gauge must conform to gauge range and graduation shown on 504-3.5.1 and 504-6.1.5 of 2.2.

3.2.2 Install 2 relief valves set at a maximum of 10 percent above test pressure.

3.2.3 Install one vent valve.

3.2.4 The air source must not exceed 25 PSIG and must have a supply capability less than the exhaust capability of either relief valve.

3.2.5 Apply a soapy solution to the opposite side of the structure, associated tank piping, overflow and air escape piping, and inspect for leaks.

3.2.6 Inspect for leakage by observing for formation of bubbles. Allowable leakage: None.

3.2.7 Accomplish unobstructed airflow test of air escape and overflow piping in accordance with Section 506h of 2.1.

3.2.8 Accomplish a visual inspection of disturbed mechanical joints for leakage upon completion of filling each tank. Allowable leakage: None.

3.2.9 Submit one legible copy, in approved transferrable media, reporting the results of the test listing the requirements of 3.2 through 3.2.8 to the SUPERVISOR.

3.3 Accomplish a local air hose test in accordance with Section 192 of 2.1 and the following:

3.3.1 ***Install one pressure gauge near the air hose nozzle. The test gauge must conform to the gauge range and graduation shown on 504-3.5.1 of 2.2.***

3.3.1.1 The minimum nozzle diameter must be 3/8 inch and the nozzle pressure must be 90 plus or minus 5 PSIG ***at the pressure gauge.***

3.3.2 Apply a soapy solution to the opposite side of the structure and inspect for leaks.

3.3.3 Inspect joint or fitting for leakage by observing for formation of bubbles. Allowable leakage: None.

3.3.4 Submit one legible copy, in approved transferrable media, reporting the results of the test listing the requirements of 3.3 through 3.3.3 to the SUPERVISOR.

3.4 Accomplish a water hose test in accordance with Section 192 of 2.1 and the following:

3.4.1 Use a one and one-half inch hose with a minimum nozzle diameter of one-half inch. Pressure at the nozzle must be no less than 50 PSIG at a maximum distance of 10 feet from the surface being tested.

3.4.2 The stream of water must be directed against the structure in a manner most likely to disclose leaks. The opposite side of the structure must be inspected to detect and locate leaks. Allowable leakage: None.

3.4.3 Submit one legible copy, in approved transferrable media, reporting the results of the test listing the requirements of 3.4 through 3.4.2 to the SUPERVISOR.

3.5 Accomplish a local vacuum box test in accordance with Section 192 of 2.1 and the following:

3.5.1 Apply a soapy solution to the structure being tested.

3.5.2 Install a vacuum box with a clear cover over each joint or each fitting being tested.

3.5.2.1 Install the vacuum box so that the pressure differential is in the direction of an air test.

3.5.3 Draw a vacuum of at least 10.2 inches of mercury and inspect for leaks.

3.5.3.1 Inspect the joint or fitting for leakage by observing through the clear cover for no formation of bubbles. Allowable leakage: None.

3.5.3.2 When the joint length exceeds the available vacuum box size, a minimum of 10 percent of the previous inspection area must be overlapped with the new inspection area when moved to adjacent inspection area.

3.5.4 Submit one legible copy, in approved transferrable media, reporting the results of the test listing the requirements of 3.5 through 3.5.3.2 to the SUPERVISOR.

3.6 Accomplish a cofferdam test in accordance with Section 192 of 2.1 and the following:

3.6.1 Install the cofferdam over the joint or fitting to be tested so that the pressure differential will be in the same direction of an air test.

3.6.2 Pressurize the air space inside the cofferdam to the test pressure specified for the air test.

3.6.3 Apply a soapy solution to the opposite side of the structure being tested.

3.6.4 Inspect the joint or fitting for leakage by observing for formation of bubbles. Allowable leakage: None.

3.6.5 If the opposite side of the structure is inaccessible, an alternate method of proving tightness is to measure the drop in pressure within the cofferdam over a 10 minute period. The gasket and fittings in the cofferdam should be checked for leakage using a soapy solution. Allowable drop in pressure: None.

3.6.6 Submit one legible copy, in approved transferrable media, reporting the results of the test listing the requirements of 3.6 through 3.6.5 to the SUPERVISOR.

3.7 Prior to strength or compartment test, accomplish a chalk test of each knife edge or mating surface and gasket on watertight doors, hatches, and scuttles.

3.7.1 Apply chalk to the bearing surface of the each knife edge or mating surface and close the door, hatch or scuttle by normal procedure.

3.7.2 When the door, hatch or scuttle is opened, the chalk from the each knife edge or mating surface must have been transferred to the gasket.

3.7.3 The chalk imprint must be in the center 3/5 of the width of the gasket with 100 percent continuous contact of knife edge to gasket. The chalk imprint for each structural closure with no knife edge must have 100 percent continuous contact of mating surface to gasket.

3.7.4 Submit one legible copy, in approved transferrable media, reporting the results of the test listing the requirements of 3.7 through 3.7.3 to the SUPERVISOR.

3.8 Repaired areas requiring a structural boundary test must remain uninsulated and unpainted until completion of successful inspection and test.

4. NOTES:

4.1 Associated tank piping is defined as, "An assembly of pipe, tubing, valves, fittings, and related components forming a whole or a part of a system which starts or terminates in subject area, thus being common to and associated with same."