



**User Manual for the Leakage Test Machine
Under Internal Pressure and Bending**

Operating Instructions for the Leakage Test Machine Under Internal Pressure and Bending

1. Power On: **Turn on the machine using the power button located on the control panel.**
2. Positioning the Movable Component: **If the movable component is not in a nearly vertical position on the left side of the chamber, use the left movement button on the panel to adjust it to a vertical position.**
3. Installing the Bending Fixture: **Install the appropriate bending template corresponding to the pipe size in the designated position inside the chamber.**
4. Placing the Test Sample: **Position the test sample (pipe and fitting assembly) in the designated area at the bottom of the chamber and securely fasten it using the provided screw.**
 - Note: **To apply internal pressure to the sample, the lower end of the sample (near the tested fitting) must be sealed with a hydrostatic pressure test cap. Additionally, the free length of the sample (the distance between the tested fitting and the end-sealing cap) should be 10 times the outer diameter of the pipe.**
5. Applying Bending: **Using the right movement button, move the movable component toward the sample until the pipe is fully bent over the bending template.**
 - Caution: **Avoid applying excessive force, which may cause deformation or crushing of the pipe.**
6. Applying Hydrostatic Pressure: **Connect the lower end of the sample, intended for connection to the hydrostatic pressure generator, to the hose located at the bottom of the chamber. Then, apply the required hydrostatic pressure.**
7. Completing the Test: **After the test duration is complete, return the movable component to its original position (releasing the sample from the bent state) and remove the sample from the machine.**
8. Safety Precaution: **To ensure operational safety, always keep the machine doors closed while performing the test.**

