

IN-HOUSE PROCEDURE # _____

PROCEDURE FOR VERIFYING LIQUID LIMIT DEVICES

Item:

Liquid Limit Device

Purpose:

This method provides instructions for checking the critical dimensions and physical condition of a manually or mechanically operated liquid limit device.

Inspection Equipment Required:

1. Caliper readable to 0.001 in. (0.1 mm) or better
2. Straight-edge
3. Timer (*for mechanically operated devices*)

Tolerance:

Equipment shall meet the dimensional tolerances specified in the applicable test method.

Procedure:

1. Measure the inside radius of the brass cup.
2. Measure the thickness of the front rim of the cup.
3. Place a straight-edge on top of the cup. At the deepest point, measure the cup depth perpendicular to the cup, from the cup to the bottom of the straight-edge.
4. Measure the height of the back rim of the cup to the top of the base.
5. Measure the length, width, and thickness of the base.
6. *Devices with Counters Only* - Zero counter. Start machine and count the number of shocks. Stop shocks and compare counter value to actual shock count.
7. *Mechanically Operated Only* - Check the shock rate with a timer. Zero counter (if equipped). Start machine and simultaneously begin timing for a period of 30 seconds. Count the number of shocks. Determine the number of shocks per second.
8. Inspect the liquid limit device. Check the points of contact on bottom of cup and top of base. Check side to side play for pin wear. Check the cup grooving area for excessive wear. Check the cup set screws for tightness.