



MAINTENANCE INSTRUCTIONS FOR HATCH COVER PULL TEST (A.K.A. DOLLAR BILL TEST)

1. SCOPE

This procedure applies to any round hatch cover with a round hatch coaming. The purpose of this procedure is to ensure there is proper gasket compression between the hatch cover and hatch coaming.

2. TEST EQUIPMENT

3” wide by 6” long by .01” thick Mylar (PET film) pull strip (Salco P/N HCPTS01). The strip is to have a 1/4" diameter hole located as shown in Figure 1. A minimum of six strips are required for testing. A spring type scale (Salco P/N MCM1757T38) or other suitable measuring device with a range from 0 to 10 lbs. is also required.

3. PROCEDURE

- a. No lubrication is to be used during the test and the surfaces of the hatch cover gasket and ring coaming must be clean and dry.
- b. With the hatch cover open, place all six test strips as shown in Figure 2, making sure the holes are facing outward. Spacing between test strips is 45 degrees. Test strips are not required at the hinge or latch location. For 16” carbon black hatch covers, place four test strips as shown in Figure 3.
- c. Close and lock the hatch cover.
- d. Attach the measuring device to the first test strip hole.
- e. Gently remove the test strip by pulling on the measuring device. Observe the force required to remove the test strip and record the value.
- f. Pull out the remaining test strips and record the observed values.

4. ACCEPTANCE CRITERIA

COVER SIZE	COVER STYLE	ACCEPTABLE FORCE
20”	Non-Vented	3 Lbs. To 7 Lbs. -- 3 Lbs. Preferred
20”	Vented	3 Lbs. To 7 Lbs. -- 3 Lbs. Preferred
30”	Non-Vented	3 Lbs. To 7 Lbs. -- 3 Lbs. Preferred
30”	Vented	3 Lbs. To 7 Lbs. -- 3 Lbs. Preferred
16”	Non-Vented	3 Lbs. To 7 Lbs. -- 3 Lbs. Preferred (Locations 1 And 2)
		3 Lbs. Minimum (Locations 3 And 4)

5. CORRECTIVE PROCEDURE

Using the recorded test data, adjust the hatch covers or ring coaming flatness where needed and verify by retesting in accordance with Section 3. Repeat this process until all defects have been corrected.

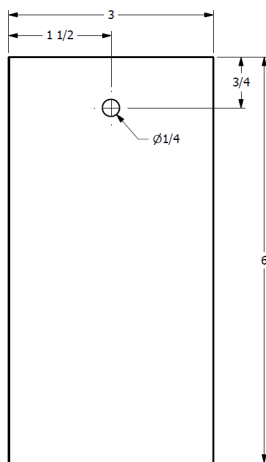


Figure 1. - Test Strip Dimensions

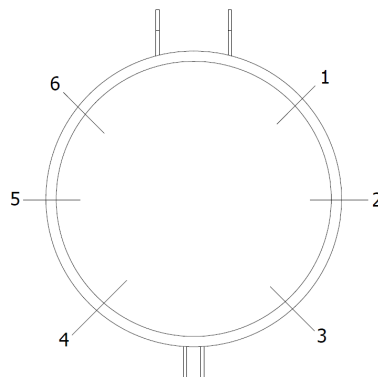


Figure 2. - Test Strip Locations (20” & 30”)

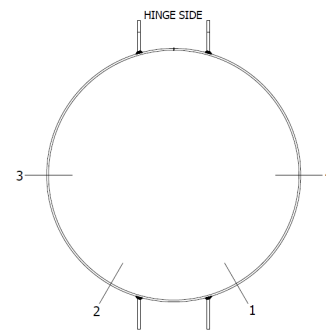


Figure 3. - Test Strip Locations (16”)

