



Designation: **D1622/D1622M – 14 D1622 – 20**

Standard Test Method for Apparent Density of Rigid Cellular Plastics¹

This standard is issued under the fixed designation ~~D1622/D1622M~~; D1622; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope*

1.1 This test method covers the density of a cellular plastic. Density can be evaluated as the apparent overall density (includes forming skins) or by apparent core density (forming skins removed).

1.2 The values stated in ~~either SI units or inch-pound units~~ are to be regarded ~~separately~~ as standard. The values stated given in each system are not necessarily exact equivalents; therefore, to ensure conformance with the standard, each system shall be used independently of the other, and values from the two systems shall not be combined parentheses are mathematical conversions to inch-pound units that are provided for information only and are not considered standard.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate ~~safety~~ safety, health, and health environmental practices and determine the applicability of regulatory limitations prior to use.*

NOTE 1—This test method is equivalent to ISO 845.

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[D618 Practice for Conditioning Plastics for Testing](#)

[D883 Terminology Relating to Plastics](#)

[E456 Terminology Relating to Quality and Statistics](#)

[E691 Practice for Conducting an Interlaboratory Study to Determine the Precision of a Test Method](#)

[E2935 Practice for Conducting Equivalence Testing in Laboratory Applications](#)

2.2 *ISO Standard:*

[ISO 845 Cellular Plastics and Rubbers—Determination of Apparent \(Bulk\) Density](#)

3. Terminology

3.1 Terms used in this standard are defined in accordance with Terminology [D883](#) For definitions of terms associated with plastic materials, see, unless otherwise specified. For terms relating to precision and bias and associated issues, the terms used in this standard are defined in accordance with Terminology [D883](#) [E456](#).

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *apparent core density (of a cellular plastic)—plastic, n*—the weight in air per unit volume of a sample, after all forming skins formed during the manufacturing process have been removed.

¹ This test method is under the jurisdiction of ASTM Committee [D20](#) on Plastics and is the direct responsibility of Subcommittee [D20.22](#) on Cellular Materials - Plastics and Elastomers.

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² For referenced ASTM standards, visit the ASTM website, [www.astm.org](#), or contact ASTM Customer Service at [service@astm.org](#). For Annual Book of ASTM Standards volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, [http://www.ansi.org](#).

*A Summary of Changes section appears at the end of this standard

3.2.2 *apparent overall density (of a cellular plastic)—plastic*, *n*—the weight in air per unit volume of a sample, including all forming skins—skins formed during the manufacturing process.

4. Significance and Use

4.1 If the material to be tested includes forming skins, the apparent overall density, or the apparent core density, or both, shall be determined. If the material does not have forming skins, the term overall density is not applicable.

4.2 This test method is also applicable to spray foam materials.

4.3 Before proceeding with this test method, reference shall be made to the specification of the material being tested. Any test specimen preparation, conditioning, dimensions, or testing parameters, or combination thereof, covered in the relevant ASTM materials specification shall take precedence over those mentioned in this test method. If there are no relevant ASTM material specifications, then the default conditions in this method apply.

4.4 When density or apparent density is used in reference to a cellular plastic, without further qualification, it shall be interpreted as follows:

4.4.1 *density*—shall be interpreted as being the *apparent overall density* if the material is to be used with forming skins intact.

4.4.2 *density*—shall be interpreted as the *apparent core density* if the forming skins have been, or will be, removed before the material is used.

5. Apparatus

5.1 *Analytical Balance or Scale*, capable of weighing the specimens to the nearest $\pm 0.1\%$.

5.2 *Micrometer Dial Gauge, Caliper, or Steel Rule*, suitable for measuring dimensions of the specimen to $\pm 0.1\%$.

5.3 *Dual Component Spray Equipment*, designed to meter the materials.

6. Test Specimen

6.1 The specimen shall be of a shape whose volume can be readily calculated, and not less than 16.4 cm^3 ~~{1-0(1.0 in.³)-in}~~ in volume.

6.2 If the sample is a single object whose weight and volume can be measured accurately, using the total weight and total volume to determine the sample density is acceptable. In this case, the test specimen is the entire sample.

6.3 When testing spray foam materials, specimens shall be prepared as follows:

6.3.1 Test specimens shall be taken from finished foam samples that have been sprayed from compounds in accordance with 6.3.2.

6.3.2 Spray the sample compounds at room ~~temperature (between~~temperature, between 20 to 24°C), 24°C (68 to 75°F), unless alternative conditions are otherwise agreed upon by the contractual parties. Spray equipment shall be adjusted to the best spray pattern and optimum performance. Spray apply a minimum 1.27-cm ~~{0.5-in.}(0.5-in.)~~ layer of foam to a primed plywood base or other suitable substrate approximately 0.95-cm by 63.5-cm by 63.5-cm ~~{0.375-in.}(0.375-in. by 25-in. by 25-in.)~~. After a minimum of 5 minutes, spray apply a second layer at least 3.8 cm ~~{1.5 in.}(1.5 in.)~~ in thickness.

6.3.3 Cut an approximate 2.54-cm ~~{1-in.}(1-in.)~~ thick specimen from the second layer. For calculation of core density, remove the bottom layer and the top skin. For calculation of the apparent overall density, cut a specimen that includes the forming skin.

6.4 If separate test specimens are cut from the sample, a minimum of three shall be used. The specimens shall be taken from locations distributed throughout the sample.

6.5 When apparent overall density is determined using specimens cut from a larger sample, the ratio of forming skin area to total volume shall be the same for the test specimens as for the sample.

7. Conditioning

7.1 *Conditioning*—Condition the test specimens at $23 \pm 2^\circ\text{C}$ ($73.4 \pm 3.6^\circ\text{F}$) and $50 \pm 10\%$ relative humidity for not less than 40 h prior to test in accordance with Procedure A of Practice D618, unless otherwise specified by the contract or relevant material specifications. In cases of disagreement, the tolerances shall be $\pm 1^\circ\text{C}$ ($\pm 1.8^\circ\text{F}$) and $\pm 5\%$ relative humidity.

7.2 *Test Conditions*—Conduct tests in the standard laboratory atmosphere of $23 \pm 2^\circ\text{C}$ ($73.4 \pm 3.6^\circ\text{F}$) and $50 \pm 10\%$ relative humidity, unless otherwise specified ~~in this specification or~~ by the contract or relevant material specification. In cases of disagreement, the tolerances shall be $\pm 1^\circ\text{C}$ ($\pm 1.8^\circ\text{F}$) and $\pm 5\%$ relative humidity.

8. Number of Specimens

8.1 A minimum of three specimens shall be tested, unless the entire sample is measured as a single specimen (see Section 6).

9. Procedure

9.1 Weigh the test specimen on a balance or scale to a precision of $\pm 0.1\%$.

9.2 Measure ~~specimens~~ specimen dimensions with a caliper or a dial-type gauge having a foot with a minimum area of 6.5 cm² [~~1 in.²]~~. Hold the pressure of the ~~dial gauge~~ foot to 2.7 ± 0.7 kPa [~~0.4(0.4 ± 0.1 psi);psi~~], unless such pressure indents the specimen. In these cases, the pressure shall be reduced accordingly. When a sliding caliper gauge is used, the proper setting shall be that point at which the measuring faces of the gauge contact the surfaces of the specimen without compressing them. Do not use a steel rule for dimensions less than 25 mm [~~1 in.](1 in.)~~. Measure all dimensions to a precision of ±0.1 %. In general, three measurements shall be made of each dimension. It is acceptable to use a lesser number when the following conditions apply:

Measurements per Dimension	Maximum Allowed Cross-Sectional Area Perpendicular to Measured Dimension	Maximum Allowed Length of Longest Perpendicular Dimension
1	25 cm ² (4 in. ²)	10 cm (4 in.)
2	100 cm ² (16 in. ²)	30 cm (12 in.)
≥	25 cm ² (4 in. ²)	10 cm (4 in.)
≥	100 cm ² (16 in. ²)	30 cm (12 in.)

10. Calculation

10.1 Calculate the density to three significant figures as follows:

$$D = W_s/V$$

where:

D = density of specimen, kg/m³,
 W_s = weight of specimen, kg, and
 V = volume of specimen, m³.

D = density of specimen, kg/m³ (lb/ft³),
 W_s = weight of specimen, kg (lb), and
 V = volume of specimen, m³ (ft³).

NOTE 2—To obtain density in g/cm³, divide D by 1000. To obtain density in lb/ft³, divide D by 16.

10.2 See **Appendix X1** for a density calculation that corrects for the buoyant effect of air.

NOTE 3—The air buoyancy effect will vary with time and depends on the open-cell content of the foam. Highly open-celled materials are essentially air-filled and will not exhibit the buoyant effects of air. However, freshly produced closed-cell materials are essentially air-void and will exhibit maximum buoyant effects of air. An additional 1.22 kg/m³ [0.076(0.076 lb/ft³)] would be added to the density of an air-void specimen if the correction is used.

10.3 Calculate the standard deviation (estimated) as follows and report it to two significant figures:

$$s = \sqrt{\frac{\sum X^2 - n\bar{X}^2}{n-1}} \text{ or } s = [(\sum X^2 - n\bar{X}^2)/(n-1)]^{1/2}$$

where:

s = estimated standard deviation,
 X = value of a single observation,
 n = number of observations, and
 \bar{X} = arithmetic mean of the set of observations.

11. Report

11.1 Report the following information:

- 11.1.1 Complete description of material tested, including type, source, code numbers, form, etc.,
- 11.1.2 Conditioning procedure used, if different from that specified in Section 7,
- 11.1.3 Number of specimens tested, if different from that specified in Section 8,
- 11.1.4 Density, average value, and standard deviation, and
- 11.1.5 Date of test.

11.2 Unless otherwise stated, the density is assumed to be the density calculated as defined in 10.1.

12. Precision and Bias⁴

12.1 *Precision:*

⁴ Supporting data have been filed at ASTM International Headquarters and may be obtained by requesting Research Report RR:D20-1105.

12.1.1 **Tables 1 and 2** are based on a round-robin conducted in 1982 in accordance with Practice E691, involving four materials tested by five laboratories. For each material, all the samples were prepared at one source, but the individual specimens were prepared at the laboratories that tested them. Each test result was tested four different materials. Every “test result” represents an average of five individual determinations. Each laboratory was asked to submit one test result, from a single operator, for each material. Practice E691 average of five individual determinations. Each laboratory obtained one test result for each material. The details are given in ASTM Research Report No. RR:D20-1105.

12.1.2 **Concept of I_r and I_R —Warning**—The following explanations of I_r and I_R (12.1.2–12.1.5) are only intended to present a meaningful way of considering the approximate precision of this test method. Do not rigorously apply the data in **Tables 1 and 2** to the shall not be rigorously applied to acceptance or rejection of material, as those data are specific to the round-robin interlaboratory study and are not necessarily representative of other lots, conditions, materials, or laboratories. Users of this test method shall apply the principles outlined in Practice E691 to generate data specific to their laboratory and materials, or between specific laboratories. The principles of 12.1.2–12.1.5 would then be valid for such data.

If S_r and S_R have been calculated from a large enough body of data, and for test results that were averages (medians/other function) from testing five specimens:

12.1.3 **Repeatability (I_r)**—In comparing two test results for the same material, obtained by the same operator using the same equipment on the same day, those test results are judged as not equivalent if they differ by more than the I_r for that material and condition.

12.1.4 **Reproducibility (I_R)**—In comparing two test results for the same material, obtained by different operators using different equipment on different days, those test results are judged as not equivalent if they differ by more than the I_R value for that material and condition. (This applies between different laboratories or between different equipment within the same laboratory.)

12.1.5 Any judgment made in accordance with 12.1.3 and 12.1.4 would have an approximate 95 % (0.95) probability of being correct.

12.2 The precision has not been determined for the test method specific to spray foam materials.

12.3 **Bias**—Bias is systematic error that contributes to the difference between a test result and a true (or reference) value. There are no recognized standards on which to base an estimate of bias for this test method.

13. Keywords

13.1 apparent core density; apparent density; apparent overall density; density; rigid cellular plastics; spray foam

TABLE 1 Within-Laboratory and Between-Laboratory Estimate of Precision Based on Round-Robin Testing Data for D1622 – 83

Material	Nominal Density	Average	Values, kg/m ³			
			S_r^A	S_R^B	I_r^C	I_R^D
M1	38	37.51	0.42	0.56	1.18	1.58
M2	50	49.63	0.30	0.46	0.86	1.31
M3	24	28.03	0.14	0.66	0.40	1.88
M4	21	20.79	0.59	1.11	1.68	3.14

^A S_r is the within-laboratory standard deviation of the average.

^B S_R is the between-laboratories standard deviation of the average.

^C $I_r = 2.83S_r$.

^D $I_R = 2.83S_R$.