



Designation: C 610 – 99

Standard Specification for Molded Expanded Perlite Block and Pipe Thermal Insulation¹

This standard is issued under the fixed designation C 610; 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 reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

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

1. Scope

1.1 This specification covers molded expanded perlite block, fittings, and pipe thermal insulation intended for use on surfaces with temperatures between 80 to 1200°F (27 to 649°C).

1.2 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.3 When the installation or use of thermal insulation materials, accessories, and systems may pose safety or health problems, the manufacturer shall provide the user appropriate current information regarding any known problems associated with the recommended use of the company's products and shall also recommend protective measures to be employed in their safe utilization. The following safety caveat applies only to the test methods portion of this specification: *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 and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

- C 165 Test Method for Measuring Compressive Properties of Thermal Insulations²
- C 168 Terminology Relating to Thermal Insulating Materials²
- C 177 Test Method for Steady-State Heat Flux Measurements and Thermal Transmission Properties by Means of the Guarded Hot Plate Apparatus²
- C 203 Test Methods for Breaking Load and Flexural Properties of Block-Type Thermal Insulation²
- C 302 Test Method for Density of Preformed Pipe-Covering-Type Thermal Insulation²

- C 303 Test Method for Density of Preformed Block-Type Thermal Insulation²
- C 335 Test Method for Steady-State Heat Transfer Properties of Horizontal Pipe Insulations²
- C 356 Test Method for Linear Shrinkage of Preformed High-Temperature Thermal Insulation Subjected to Soaking Heat²
- C 390 Criteria for Sampling and Acceptance of Preformed Thermal Insulation Lots²
- C 411 Test Method for Hot-Surface Performance of High-Temperature Thermal Insulation²
- C 421 Test Method for Tumbling Friability of Preformed Block-Type Thermal Insulation²
- C 446 Test Method for Breaking Load and Calculated Modulus of Rupture of Preformed Insulation for Pipes²
- C 450 Practice for Prefabrication and Field Fabrication of Thermal Insulating Fitting Covers for NPS Piping, Vessel Lagging, and Dished Head Segments²
- C 518 Test Method for Steady-State Heat Flux Measurements and Thermal Transmission Properties by Means of the Heat Flow Meter Apparatus²
- C 585 Practice for Inner and Outer Diameters of Rigid Thermal Insulation for Nominal Sizes of Pipe and Tubing (NPS System)²
- C 692 Test Method for Evaluating the Influence of Thermal Insulations on the External Stress Corrosion Cracking Tendency of Austenitic Steel²
- C 795 Specification for Thermal Insulation for Use in Contact with Austenitic Stainless Steel²
- C 1045 Practice for Calculating Thermal Transmission from Steady-State Heat Flux Measurements²
- C 1058 Practice for Selecting Temperatures for Evaluating and Reporting Thermal Properties of Thermal Insulation²
- E 84 Test Method for Surface Burning Characteristics of Building Materials³

3. Terminology

3.1 *General*—Terminology C 168 shall be considered as applying to the terms used in this specification.

¹ This specification is under the jurisdiction of ASTM Committee C-16 on Thermal Insulation and is the direct responsibility of Subcommittee C16.20 on Homogeneous Inorganic Thermal Insulations.

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² *Annual Book of ASTM Standards*, Vol 04.06.

³ *Annual Book of ASTM Standards*, Vol 04.07.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *composition*—molded expanded perlite block, fitting, and pipe thermal insulation shall be composed principally of expanded perlite and silicate binders. It may also contain reinforcing fibers.

4. Standard Shapes, Sizes, and Dimensions

4.1 Molded expanded perlite block, fitting, and pipe thermal insulation shall be as follows:

4.1.1 *Block*—Block shall be furnished in lengths of either 36 or 39.37 in. (914 or 1000 mm), widths of 6 in. (152 mm), 12 in. (305 mm), 18 in. (457 mm), or 24 in. (610 mm), and in thickness from 1½ to 6 in. (38 to 152 mm) in increments of ½ in. (13 mm).

4.1.2 *Pipe Insulation*—Molded expanded perlite pipe insulation shall be supplied either as hollow cylindrical shapes split in half lengthwise (in a plane including the cylindrical axis) or as curved segments. The pipe insulation shall be furnished in sections or segments in lengths of either 36 or 39.37 in. (914 or 1000 mm) to fit standard sizes of pipe and tubing, and in nominal thickness from 1 to 4 in. (25 to 102 mm) in ½-in. (13-mm) increments. Inner and outer diameters of multilayer construction may be specified. Inner and outer diameters shall be in accordance with those standard dimensions specified in Practice C 585. Since outside diameter tolerances may be different under individual manufacturing processes, it may be necessary to have pipe insulation furnished in two or more layers nested by the manufacturer. The purchaser shall consult the manufacturer for specific requirements.

4.1.3 *Fittings*—Molded (expanded insulation fittings shall conform to the inner and outer diameters in accordance with those standard dimensions specified in Practice C 585. Mitered fittings shall be in accordance with Practice C 450.

5. Dimensional Tolerances

5.1 *General*—The average tolerances for length, width, and thickness shall comply with the requirements shown in Table 1.

5.2 *Pipe Insulation*—The following additional tolerances apply to perlite pipe insulation supplied as half sections:

5.2.1 *Fit and Closure*—When fitted to the appropriate size pipe, the longitudinal seam of the pipe insulation shall close to within ¼ in. (1.6 mm) along the entire length of the section.

5.2.2 *Concentricity*—The inner bore of the pipe insulation shall be concentric with the outer cylindrical surface. The deviation from concentricity shall not exceed ⅛ in. (3.2 mm) or 5 % of the wall thickness, whichever is greater.

5.2.3 *Half-Section Balance*—The plane formed by the split between half sections shall include the cylindrical axis. Deviation of the split plane from the cylinder axis over the 36 or 39.37-in. (914 or 1000-mm) length shall not exceed ⅛ in. (3.2 mm).

TABLE 1 Dimensional Tolerances

	Block	Pipe
Length	± ⅛ in. (3.2 mm)	± ⅛ in. (3.2 mm)
Width	± ⅛ in. (3.2 mm)	...
Thickness	± ⅛ in. (3.2 mm)	± ⅛ in. (3.2 mm)
Inner Diameter	...	in accordance with Practice C585
Outer Diameter	...	in accordance with Practice C585

6. Workmanship, Finish, and Appearance

6.1 Since some requirements for this material are not easily defined by a numerical value, the insulation shall not have visible defects that will adversely affect its service qualities.

7. Physical Requirements

7.1 The insulation shall conform to the physical requirements in Table 2.

8. Sampling

8.1 The insulation shall be sampled in accordance with Criteria C 390. Specific provision for sampling shall be agreed upon between the purchaser and the supplier.

9. Qualification Requirements

9.1 The following requirements are generally employed for purpose of initial material or product qualification:

- 9.1.1 Flexural strength,
- 9.1.2 Compressive strength,

TABLE 2 Physical Requirements^A

Density, lb/ft ³ (kg/m ³)	min	10.0 (192)
	max	14.0 (224)
Flexural Strength, lb/in. (kPa)	min	45.0 (310)
	pass	
Stress Corrosion Cracking of Austenitic Stainless Steel		
Compressive Strength at 5 % Deformation, lb/in. ² (kPa)	min	60.0 (414)
Weight Loss by Tumbling, % Loss in Weight after 10 minutes	max	70
Moisture Content ^B , % by weight	max	10
Linear Shrinkage, % at 1200°F (649°C) for 24 h, max	length	2
	width	2
	thickness	8
Apparent Thermal Conductivity ^C , Btu-in./h-ft ² -°F (W/m·K), max	Mean Temperature	App. Thermal Conductivity
	200°F (93°C)	0.55 (0.079)
	300°F (149°C)	0.60 (0.086)
	400°F (204°C)	0.66 (0.095)
	500°F (260°C)	0.74 (0.106)
	600°F (316°C)	0.80 (0.111)
	700°F (371°C)	0.88 (0.126)
Water Absorption of Thermal Insulation After Heat Aging and 48 h Water Immersion, moisture gain, % by weight, max	600°F (316°C)	50
Surface Burning Characteristics	Flame Spread, max	0
	Smoke Developed, max	5
Hot-surface Performance	Warpage, in. (mm), max	¼ (6)
	Cracking	No cracks completely through the insulation thickness. Surface cracks on hot face are acceptable

^A Physical property requirements shown are for the materials in the as-manufactured condition. They may or may not represent the values of these properties under certain in-service conditions, depending on the type of installation and the ultimate temperature exposure.

^B Water absorption values shown are for insulation in the as-manufactured condition. Those portions of the insulation exposed to elevated temperatures may not retain their water absorption characteristics.

^C The thermal transmission properties of perlite block and pipe insulation may vary with temperature, temperature gradient, thickness, and shape. Note that the apparent thermal conductivity requirements in the table are based on samples tested under the conditions specified in Test Methods C 177 or C 335. These are comparative values for establishing specification compliance. They may not represent the installed performance of the insulation under use conditions differing substantially from test conditions.