



Designation: D 790 – 02

Standard Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials¹

This standard is issued under the fixed designation D 790; 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 These test methods cover the determination of flexural properties of unreinforced and reinforced plastics, including high-modulus composites and electrical insulating materials in the form of rectangular bars molded directly or cut from sheets, plates, or molded shapes. These test methods are generally applicable to both rigid and semirigid materials. However, flexural strength cannot be determined for those materials that do not break or that do not fail in the outer surface of the test specimen within the 5.0 % strain limit of these test methods. These test methods utilize a three-point loading system applied to a simply supported beam. A four-point loading system method can be found in Test Method D 6272.

1.1.1 *Procedure A*, designed principally for materials that break at comparatively small deflections.

1.1.2 *Procedure B*, designed particularly for those materials that undergo large deflections during testing.

1.1.3 Procedure A shall be used for measurement of flexural properties, particularly flexural modulus, unless the material specification states otherwise. Procedure B may be used for measurement of flexural strength only. Tangent modulus data obtained by Procedure A tends to exhibit lower standard deviations than comparable data obtained by means of Procedure B.

1.2 Comparative tests may be run in accordance with either procedure, provided that the procedure is found satisfactory for the material being tested.

1.3 The values stated in SI units are to be regarded as the standard. The values provided in parentheses are for information only.

1.4 *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.*

NOTE 1—These test methods are not technically equivalent to ISO 178.

2. Referenced Documents

2.1 ASTM Standards:

D 618 Practice for Conditioning Plastics for Testing²

D 638 Test Method for Tensile Properties of Plastics²

D 883 Terminology Relating to Plastics²

D 4000 Classification System for Specifying Plastic Materials³

D 5947 Test Methods for Physical Dimensions of Solid Plastic Specimens⁴

D 6272 Test Method for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials by Four-Point Bending⁴

E 4 Practices for Force Verification of Testing Machines⁵

E 691 Practice for Conducting an Interlaboratory Study to Determine the Precision of a Test Method⁶

3. Terminology

3.1 *Definitions*—Definitions of terms applying to these test methods appear in Terminology D 883 and Annex A1 of Test Method D 638.

4. Summary of Test Method

4.1 A bar of rectangular cross section rests on two supports and is loaded by means of a loading nose midway between the supports (see Fig. 1). A support span-to-depth ratio of 16:1 shall be used unless there is reason to suspect that a larger span-to-depth ratio may be required, as may be the case for certain laminated materials (see Section 7 and Note 8 for guidance).

4.2 The specimen is deflected until rupture occurs in the outer surface of the test specimen or until a maximum strain (see 12.7) of 5.0 % is reached, whichever occurs first.

4.3 Procedure A employs a strain rate of 0.01 mm/mm/min (0.01 in./in./min) and is the preferred procedure for this test method, while Procedure B employs a strain rate of 0.10 mm/mm/min (0.10 in./in./min).

¹ These test methods are under the jurisdiction of ASTM Committee D20 on Plastics and are the direct responsibility of Subcommittee D20.10 on Mechanical Properties.

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² *Annual Book of ASTM Standards*, Vol 08.01.

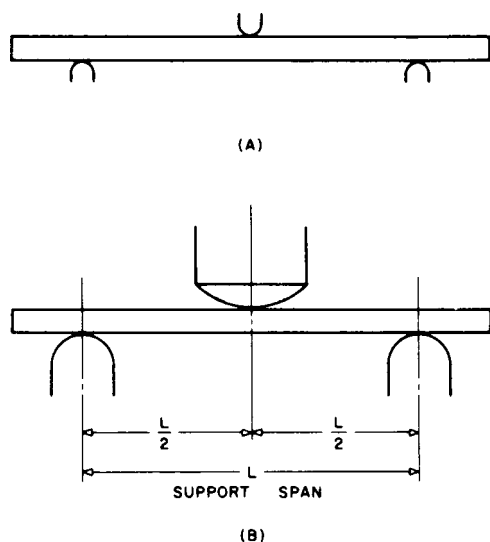
³ *Annual Book of ASTM Standards*, Vol 08.02.

⁴ *Annual Book of ASTM Standards*, Vol 08.03.

⁵ *Annual Book of ASTM Standards*, Vol 03.01.

⁶ *Annual Book of ASTM Standards*, Vol 14.02.

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



NOTE—(a) Minimum radius = 3.2 mm (1/8 in.). (b) Maximum radius supports 1.6 times specimen depth; maximum radius loading nose = 4 times specimen depth.

FIG. 1 Allowable Range of Loading Nose and Support Radii

5. Significance and Use

5.1 Flexural properties as determined by these test methods are especially useful for quality control and specification purposes.

5.2 Materials that do not fail by the maximum strain allowed under these test methods (3-point bend) may be more suited to a 4-point bend test. The basic difference between the two test methods is in the location of the maximum bending moment and maximum axial fiber stresses. The maximum axial fiber stresses occur on a line under the loading nose in 3-point bending and over the area between the loading noses in 4-point bending.

5.3 Flexural properties may vary with specimen depth, temperature, atmospheric conditions, and the difference in rate of straining as specified in Procedures A and B (see also Note 8).

5.4 Before proceeding with these test methods, reference should 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 materials specification shall take precedence over those mentioned in these test methods. If there are no material specifications, then the default conditions apply. Table 1 in Classification System D 4000 lists the ASTM materials standards that currently exist for plastics.

6. Apparatus

6.1 *Testing Machine*— A properly calibrated testing machine that can be operated at constant rates of crosshead motion over the range indicated, and in which the error in the load measuring system shall not exceed $\pm 1\%$ of the maximum load expected to be measured. It shall be equipped with a deflection measuring device. The stiffness of the testing machine shall be such that the total elastic deformation of the system does not exceed 1% of the total deflection of the test specimen during

TABLE 1 Flexural Strength

Material	Mean, 10^3 psi	Values Expressed in Units of % of 10^3 psi			
		V_r^A	V_r^B	r^C	R^D
ABS	9.99	1.59	6.05	4.44	17.2
DAP thermoset	14.3	6.58	6.58	18.6	18.6
Cast acrylic	16.3	1.67	11.3	4.73	32.0
GR polyester	19.5	1.43	2.14	4.05	6.08
GR polycarbonate	21.0	5.16	6.05	14.6	17.1
SMC	26.0	4.76	7.19	13.5	20.4

^A V_r = within-laboratory coefficient of variation for the indicated material. It is obtained by first pooling the within-laboratory standard deviations of the test results from all of the participating laboratories: $S_r = [((s_1)^2 + (s_2)^2 \dots + (s_n)^2)/n]^{1/2}$ then $V_r = (S_r \text{ divided by the overall average for the material}) \times 100$.

^B V_r = between-laboratory reproducibility, expressed as the coefficient of variation: $S_R = (S_r^2 + S_L^2)^{1/2}$ where S_L is the standard deviation of laboratory means. Then: $V_R = (S_R \text{ divided by the overall average for the material}) \times 100$.

^C r = within-laboratory critical interval between two test results = $2.8 \times V_r$.

^D R = between-laboratory critical interval between two test results = $2.8 \times V_R$.

testing, or appropriate corrections shall be made. The load indicating mechanism shall be essentially free from inertial lag at the crosshead rate used. The accuracy of the testing machine shall be verified in accordance with Practices E 4.

6.2 *Loading Noses and Supports*—The loading nose and supports shall have cylindrical surfaces. In order to avoid excessive indentation, or failure due to stress concentration directly under the loading nose, the radii of the loading nose and supports shall be 5.0 ± 0.1 mm (0.197 ± 0.004 in.) unless otherwise specified or agreed upon between the interested clients. When other loading noses and supports are used they must comply with the following requirements: they shall have a minimum radius of 3.2 mm (1/8 in.) for all specimens, and for specimens 3.2 mm or greater in depth, the radius of the supports may be up to 1.6 times the specimen depth. They shall be this large if significant indentation or compressive failure occurs. The arc of the loading nose in contact with the specimen shall be sufficiently large to prevent contact of the specimen with the sides of the nose (see Fig. 1). The maximum radius of the loading nose shall be no more than 4 times the specimen depth.

NOTE 2—Test data have shown that the loading nose and support dimensions can influence the flexural modulus and flexural strength values. The loading nose dimension has the greater influence. Dimensions of the loading nose and supports must be specified in the material specification.

6.3 *Micrometers*— Suitable micrometers for measuring the width and thickness of the test specimen to an incremental discrimination of at least 0.025 mm (0.001 in.) should be used. All width and thickness measurements of rigid and semirigid plastics may be measured with a hand micrometer with ratchet. A suitable instrument for measuring the thickness of nonrigid test specimens shall have: a contact measuring pressure of 25 ± 2.5 kPa (3.6 ± 0.36 psi), a movable circular contact foot 6.35 ± 0.025 mm (0.250 ± 0.001 in.) in diameter and a lower fixed anvil large enough to extend beyond the contact foot in all directions and being parallel to the contact foot within 0.005 mm (0.002 in.) over the entire foot area. Flatness of foot and anvil shall conform to the portion of the Calibration section of Test Methods D 5947.

7. Test Specimens

7.1 The specimens may be cut from sheets, plates, or



molded shapes, or may be molded to the desired finished dimensions. The actual dimensions used in Section 4.2, Calculation, shall be measured in accordance with Test Methods D 5947.

NOTE 3—Any necessary polishing of specimens shall be done only in the lengthwise direction of the specimen.

7.2 Sheet Materials (Except Laminated Thermosetting Materials and Certain Materials Used for Electrical Insulation, Including Vulcanized Fiber and Glass Bonded Mica):

7.2.1 Materials 1.6 mm ($\frac{1}{16}$ in.) or Greater in Thickness—For flatwise tests, the depth of the specimen shall be the thickness of the material. For edgewise tests, the width of the specimen shall be the thickness of the sheet, and the depth shall not exceed the width (see Notes 4 and 5). For all tests, the support span shall be 16 (tolerance ± 1) times the depth of the beam. Specimen width shall not exceed one fourth of the support span for specimens greater than 3.2 mm ($\frac{1}{8}$ in.) in depth. Specimens 3.2 mm or less in depth shall be 12.7 mm ($\frac{1}{2}$ in.) in width. The specimen shall be long enough to allow for overhanging on each end of at least 10 % of the support span, but in no case less than 6.4 mm ($\frac{1}{4}$ in.) on each end. Overhang shall be sufficient to prevent the specimen from slipping through the supports.

NOTE 4—Whenever possible, the original surface of the sheet shall be unaltered. However, where testing machine limitations make it impossible to follow the above criterion on the unaltered sheet, one or both surfaces shall be machined to provide the desired dimensions, and the location of the specimens with reference to the total depth shall be noted. The value obtained on specimens with machined surfaces may differ from those obtained on specimens with original surfaces. Consequently, any specifications for flexural properties on thicker sheets must state whether the original surfaces are to be retained or not. When only one surface was machined, it must be stated whether the machined surface was on the tension or compression side of the beam.

NOTE 5—Edgewise tests are not applicable for sheets that are so thin that specimens meeting these requirements cannot be cut. If specimen depth exceeds the width, buckling may occur.

7.2.2 Materials Less than 1.6 mm ($\frac{1}{16}$ in.) in Thickness—The specimen shall be 50.8 mm (2 in.) long by 12.7 mm ($\frac{1}{2}$ in.) wide, tested flatwise on a 25.4-mm (1-in.) support span.

NOTE 6—Use of the formulas for simple beams cited in these test methods for calculating results presumes that beam width is small in comparison with the support span. Therefore, the formulas do not apply rigorously to these dimensions.

NOTE 7—Where machine sensitivity is such that specimens of these dimensions cannot be measured, wider specimens or shorter support spans, or both, may be used, provided the support span-to-depth ratio is at least 14 to 1. All dimensions must be stated in the report (see also Note 6).

7.3 Laminated Thermosetting Materials and Sheet and Plate Materials Used for Electrical Insulation, Including Vulcanized Fiber and Glass-Bonded Mica—For paper-base and fabric-base grades over 25.4 mm (1 in.) in nominal thickness, the specimens shall be machined on both surfaces to a depth of 25.4 mm. For glass-base and nylon-base grades, specimens over 12.7 mm ($\frac{1}{2}$ in.) in nominal depth shall be machined on both surfaces to a depth of 12.7 mm. The support span-to-depth ratio shall be chosen such that failures occur in the outer fibers of the specimens, due only to the bending moment (see Note 8). Therefore, a ratio larger than 16:1 may

be necessary (32:1 or 40:1 are recommended). When laminated materials exhibit low compressive strength perpendicular to the laminations, they shall be loaded with a large radius loading nose (up to four times the specimen depth to prevent premature damage to the outer fibers).

7.4 Molding Materials (Thermoplastics and Thermosets)—The recommended specimen for molding materials is 127 by 12.7 by 3.2 mm (5 by $\frac{1}{2}$ by $\frac{1}{8}$ in.) tested flatwise on a support span, resulting in a support span-to-depth ratio of 16 (tolerance ± 1). Thicker specimens should be avoided if they exhibit significant shrink marks or bubbles when molded.

7.5 High-Strength Reinforced Composites, Including Highly Orthotropic Laminates—The span-to-depth ratio shall be chosen such that failure occurs in the outer fibers of the specimens and is due only to the bending moment (see Note 8). A span-to-depth ratio larger than 16:1 may be necessary (32:1 or 40:1 are recommended). For some highly anisotropic composites, shear deformation can significantly influence modulus measurements, even at span-to-depth ratios as high as 40:1. Hence, for these materials, an increase in the span-to-depth ratio to 60:1 is recommended to eliminate shear effects when modulus data are required, it should also be noted that the flexural modulus of highly anisotropic laminates is a strong function of ply-stacking sequence and will not necessarily correlate with tensile modulus, which is not stacking-sequence dependent.

NOTE 8—As a general rule, support span-to-depth ratios of 16:1 are satisfactory when the ratio of the tensile strength to shear strength is less than 8 to 1, but the support span-to-depth ratio must be increased for composite laminates having relatively low shear strength in the plane of the laminate and relatively high tensile strength parallel to the support span.

8. Number of Test Specimens

8.1 Test at least five specimens for each sample in the case of isotropic materials or molded specimens.

8.2 For each sample of anisotropic material in sheet form, test at least five specimens for each of the following conditions. Recommended conditions are flatwise and edgewise tests on specimens cut in lengthwise and crosswise directions of the sheet. For the purposes of this test, “lengthwise” designates the principal axis of anisotropy and shall be interpreted to mean the direction of the sheet known to be stronger in flexure. “Crosswise” indicates the sheet direction known to be the weaker in flexure and shall be at 90° to the lengthwise direction.

9. Conditioning

9.1 **Conditioning**—Condition the test specimens at $23 \pm 2^\circ\text{C}$ ($73.4 \pm 3.6^\circ\text{F}$) and $50 \pm 5\%$ relative humidity for not less than 40 h prior to test in accordance with Procedure A of Practice D 618 unless otherwise specified by contract or the relevant ASTM material specification. Reference pre-test conditioning, to settle disagreements, shall apply tolerances of $\pm 1^\circ\text{C}$ (1.8°F) and $\pm 2\%$ relative humidity.

9.2 **Test Conditions**—Conduct the tests at $23 \pm 2^\circ\text{C}$ ($73.4 \pm 3.6^\circ\text{F}$) and $50 \pm 5\%$ relative humidity unless otherwise specified by contract or the relevant ASTM material specification. Reference testing conditions, to settle disagreements,



shall apply tolerances of $\pm 1^\circ\text{C}$ (1.8°F) and $\pm 2\%$ relative humidity.

10. Procedure

10.1 Procedure A:

10.1.1 Use an untested specimen for each measurement. Measure the width and depth of the specimen to the nearest 0.03 mm (0.001 in.) at the center of the support span. For specimens less than 2.54 mm (0.100 in.) in depth, measure the depth to the nearest 0.003 mm (0.0005 in.). These measurements shall be made in accordance with Test Methods D 5947.

10.1.2 Determine the support span to be used as described in Section 7 and set the support span to within 1% of the determined value.

10.1.3 For flexural fixtures that have continuously adjustable spans, measure the span accurately to the nearest 0.1 mm (0.004 in.) for spans less than 63 mm (2.5 in.) and to the nearest 0.3 mm (0.012 in.) for spans greater than or equal to 63 mm (2.5 in.). Use the actual measured span for all calculations. For flexural fixtures that have fixed machined span positions, verify the span distance the same as for adjustable spans at each machined position. This distance becomes the span for that position and is used for calculations applicable to all subsequent tests conducted at that position. See Annex A2 for information on the determination of and setting of the span.

10.1.4 Calculate the rate of crosshead motion as follows and set the machine for the rate of crosshead motion as calculated by Eq 1:

$$R = ZL^2/6d \quad (1)$$

where:

R = rate of crosshead motion, mm (in.)/min,

L = support span, mm (in.),

d = depth of beam, mm (in.), and

Z = rate of straining of the outer fiber, mm/mm/min (in./in./min). Z shall be equal to 0.01.

In no case shall the actual crosshead rate differ from that calculated using Eq 1, by more than $\pm 10\%$.

10.1.5 Align the loading nose and supports so that the axes of the cylindrical surfaces are parallel and the loading nose is midway between the supports. The parallelism of the apparatus may be checked by means of a plate with parallel grooves into which the loading nose and supports will fit when properly aligned (see A2.3). Center the specimen on the supports, with the long axis of the specimen perpendicular to the loading nose and supports.

10.1.6 Apply the load to the specimen at the specified crosshead rate, and take simultaneous load-deflection data. Measure deflection either by a gage under the specimen in contact with it at the center of the support span, the gage being mounted stationary relative to the specimen supports, or by measurement of the motion of the loading nose relative to the supports. Load-deflection curves may be plotted to determine the flexural strength, chord or secant modulus or the tangent modulus of elasticity, and the total work as measured by the area under the load-deflection curve. Perform the necessary toe compensation (see Annex A1) to correct for seating and indentation of the specimen and deflections in the machine.

10.1.7 Terminate the test when the maximum strain in the

outer surface of the test specimen has reached 0.05 mm/mm (in./in.) or at break if break occurs prior to reaching the maximum strain (Notes 9 and 10). The deflection at which this strain will occur may be calculated by letting r equal 0.05 mm/mm (in./in.) in Eq 2:

$$D = rL^2/6d \quad (2)$$

where:

D = midspan deflection, mm (in.),

r = strain, mm/mm (in./in.),

L = support span, mm (in.), and

d = depth of beam, mm (in.).

NOTE 9—For some materials that do not yield or break within the 5% strain limit when tested by Procedure A, the increased strain rate allowed by Procedure B (see 10.2) may induce the specimen to yield or break, or both, within the required 5% strain limit.

NOTE 10—Beyond 5% strain, this test method is not applicable. Some other mechanical property might be more relevant to characterize materials that neither yield nor break by either Procedure A or Procedure B within the 5% strain limit (for example, Test Method D 638 may be considered).

10.2 Procedure B:

10.2.1 Use an untested specimen for each measurement.

10.2.2 Test conditions shall be identical to those described in 10.1, except that the rate of straining of the outer surface of the test specimen shall be 0.10 mm/mm (in./in.)/min.

10.2.3 If no break has occurred in the specimen by the time the maximum strain in the outer surface of the test specimen has reached 0.05 mm/mm (in./in.), discontinue the test (see Note 10).

11. Retests

11.1 Values for properties at rupture shall not be calculated for any specimen that breaks at some obvious, fortuitous flaw, unless such flaws constitute a variable being studied. Retests shall be made for any specimen on which values are not calculated.

12. Calculation

12.1 Toe compensation shall be made in accordance with Annex A1 unless it can be shown that the toe region of the curve is not due to the take-up of slack, seating of the specimen, or other artifact, but rather is an authentic material response.

12.2 *Flexural Stress* (σ_f)—When a homogeneous elastic material is tested in flexure as a simple beam supported at two points and loaded at the midpoint, the maximum stress in the outer surface of the test specimen occurs at the midpoint. This stress may be calculated for any point on the load-deflection curve by means of the following equation (see Notes 11-13):

$$\sigma_f = 3PL/2bd^2 \quad (3)$$

where:

σ = stress in the outer fibers at midpoint, MPa (psi),

P = load at a given point on the load-deflection curve, N (lbf),

L = support span, mm (in.),

b = width of beam tested, mm (in.), and