



Designation: D3453 – 07

Standard Specification for Flexible Cellular Materials—Urethane for Furniture and Automotive Cushioning, Bedding, and Similar Applications¹

This standard is issued under the fixed designation D3453; 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 flexible cellular urethane materials intended for such uses as inserts for furniture cushions, mattresses, and similar applications.

1.2 This specification provides material and dimensional requirements and methods of tests for specific properties of load bearing, compression set, humid age resistance, pounding fatigue resistance, support factor and resilience.

1.3 This specification includes references to government regulations for burning characteristics of flexible cellular material used in specified applications.

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

1.5 *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—There is no equivalent ISO standard.

2. Referenced Documents

2.1 ASTM Standards:²

D3574 Test Methods for Flexible Cellular Materials—Slab, Bonded, and Molded Urethane Foams

D3675 Test Method for Surface Flammability of Flexible Cellular Materials Using a Radiant Heat Energy Source

¹ This specification 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.

2.2 Other Documents:

16CFR1632 (Previously DoC FF4-72), Standard for the Flammability of Mattresses³

MVSS 302 DoT Motor Vehicle Safety Standard³

DOT Federal Aviation Regulation (FAR), Part 25.853, Paragraph (b), and Appendix F³

Simplified Practice Recommendations R2-62 Bedding Products and Components (Mattresses, Springs, Bedsteads, and Cots)⁴

3. Classification

3.1 This specification covers eight grades of flexible cellular material that may be selected for use in accordance with load bearing and general physical properties, **Table 1**; four grades based on pounding-fatigue properties, **Table 2**; three grades based on cushioning performance properties, **Table 3**.

4. Basis of Purchase

4.1 Any product represented as complying with this specification shall meet all the requirements listed herein for its particular classification.

5. Burning Characteristics

5.1 **Table 4** lists applicable government regulations on burning characteristics of material used in specified applications.

6. Dimensions

6.1 For Use as Mattress Inserts:

6.1.1 *Sizes*—The standard thickness and tolerance are specified in **Table 5**. These sizes have been adopted for mattress inserts to coordinate the insert with mattress ticking and other bed constructions. The other dimensions are specified in **Table 7A** of Simplified Practice Recommendations R2-62.

6.1.2 *For Use as Furniture Cushion Inserts*—The allowable tolerances on dimensions of furniture cushion inserts shall be as shown in **Table 6**.

³ Available from the Superintendent of Documents, U. S. Government Printing Office, Washington, DC 20402.

⁴ Available from the Clearing House for Federal Scientific and Technical Information, 5285 Port Royal Rd., Springfield, VA 22151.

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

TABLE 1 Specific Physical Properties of Flexible Cellular Material

Grade Number		25 % Indentation Force Deflection (IFD) Values, ^A N (lbf)	Compression (comp) Set ^B After 90 % Deflection, % max	Moisture Resistance	
N	lbf			Compression Force Deflection Loss, % max	Compression Set ^B After Deflection, % max
245	55	245 ± 18 (55 ± 4)	15	20	20
196	44	196 ± 18 (44 ± 4)	15	20	20
151	34	151 ± 14 (34 ± 3)	15	20	20
120	27	120 ± 14 (27 ± 3)	15	20	20
93	21	93 ± 14 (21 ± 3)	15	20	20
67	15	67 ± 14 (15 ± 3)	20	20	25
40	9	40 ± 14 (9 ± 3)	25	—	30
22	5	22 ± 14 (5 ± 3)	30	—	35
Test method sections ^C		B1	D	J1,C	J1,D
Specimen size, ^D mm (in.)		380 × 380 × 100 (15 × 15 × 4)	50 × 50 × 25 (2 × 2 × 1)	50 × 50 × 25 (2 × 2 × 1)	50 × 50 × 25 (2 × 2 × 1)

^A Tolerances have been established to provide for grade designations. Closer tolerances, when desirable for specific applications, may be agreed upon between the purchaser and the seller.

^B To be expressed as a percent of the original thickness.

^C See Section 7 for an explanation of the test methods referenced.

^D See 9.3 when indicated specimen sizes are not available.

TABLE 2 Pounding Fatigue Performance Grades

Grade	Description	Applications	40 % IFD ^A % Loss, max
AP	Heavy-duty use	transportation seating	20
BP	Normal-duty use	cushions, mattresses	30
CP	Light-duty use	arm rests, seat backs	35
DP	Unclassified	miscellaneous padding	40

^A See Test Methods D3574, Test I₃, Procedure B (80 000 cycles).

TABLE 3 Cushioning Performance Grades^A

Grade Number	Description	Support Factor ^B	Resilience ^C
NS	Normal Support	1.8 min	—
HS	High Support	2.3 min	—
HS-HR	High Support- High Resilience	2.4 min	55 % min

^A Grades also subject to specific physical properties in Table 1.

^B 65 % / 25 % IFD; See Test Methods D3574, Section 21 and Appendix X3.1.

^C Ball Rebound; see Test Methods D3574, Sections 68–72.

7. Test Methods

7.1 The physical tests shall be in accordance with Test Methods D3574.

8. Physical Requirements

8.1 The material shall conform to the requirements for physical properties prescribed in Tables 1-3.

9. Inspection

9.1 Inspection of the material shall be agreed upon in writing by the purchaser and the seller as part of the purchase contract.

9.2 Testing for conformance to requirements shall be done in accordance with the appropriate sections of Test Methods D3574. The specific test methods in this reference to be used

for each test shall be as listed in Tables 1-3, except as specified in 9.3. Burning tests in the reference are listed in Table 4.

9.3 If a specimen 380 by 380 by 100 mm (15 by 15 by 4 in.) cannot be obtained, an appropriate size, as well as its corresponding indentation force deflection (IFD) value, shall be agreed upon between the purchaser and the seller. In those cases where foams having thicknesses of 100 mm (4 in.) are not available, the following reduced IFD values are suggested:

Thickness	25 % IFD	65 % IFD	
75 mm (3 in.)	88 %	88 %	of 100 mm (4 in.) IFD value
50 mm (2 in.)	78 %	76 %	of 100 mm (4 in.) IFD value
25 mm (1 in.)	68 %	62 %	of 100 mm (4 in.) IFD value

In all cases, the IFD tolerances specified in Table 1 shall apply. For example, a 50-mm (2-in.) thick Grade 120-N (12 kg/27-lb) foam will have a 25 % IFD value of 94 ± 14 N (21.0 ± 3.0 lbf) = 80 to 108 N (18.0 to 24.0 lbf).

9.3.1 If an IFD specimen cannot be obtained, an approximation from the 50 % CFD in accordance with Test Methods D3574 to a 100-mm (4-in.) IFD can be made using the following equation:

$$IFD = CFD \times (A + B)$$

	25 %	IFD Deflection 40 %	65 %
A	1.397	2.382	5.32
B	82.31	93.84	87.92

This conversion may be useful in the carpet cushion, packaging, and other specialties.

10. Retest and Rejection

10.1 If any failure occurs, the materials may be retested to establish conformity in accordance with agreement between the purchaser and the seller.

11. Packaging, Marking, and Labeling

11.1 Packaging—The material shall be packed in standard commercial containers, so constructed as to ensure acceptance by common or other carriers for safe transportation at the