



Designation: D 4991 – 94 (Reapproved 1999)

Standard Test Method for Leakage Testing of Empty Rigid Containers by Vacuum Method¹

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1. Scope

1.1 This test method covers the testing of empty containers for resistance to leakage under differential pressure conditions such as those which can occur during air transport. It is suitable for testing rigid containers intended for the transportation of some hazardous liquids in accordance with the United Nations Recommendations On The Transport Of Dangerous Goods (UN TDG) and the International Civil Aviation Organization Technical Instructions For The Safe Transport Of Dangerous Goods By Air (ICAO TIs).

1.2 *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:*²

D 996 Terminology of Packaging and Distribution Environments

D 3078 Test Method for Determination of Leaks in Flexible Packaging by Bubble Emission

2.2 *United Nations Document:*

ST/SG/AC.10/1 Recommendations On The Transport Of Dangerous Goods³

2.3 *International Civil Aviation Organization:*

DOC 9284-AN/905 Technical Instructions For The Safe Transport Of Dangerous Goods By Air⁴

3. Terminology

3.1 *Definitions:* Terms and definitions used in this test method may be found in Terminology **D 996**.

¹ This test method is under the jurisdiction of ASTM Committee D10 on Packaging and is the direct responsibility of Subcommittee D10.23 on Storage Test Methods.

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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 United Nations Sales Section, United Nations, New York, NY 10017.

⁴ Available from Intereg Group, Inc., 5724 N. Pulaski Rd., Chicago, IL 60646.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *rigid container*—a container sufficiently rigid that under a positive pressure of 100-kPa gage the volumetric expansion does not exceed 0.5 %, such as a glass bottle.

4. Summary of Test Method

4.1 An empty rigid container to be tested is pressurized by immersion in an ethylene glycol-water solution in a transparent test chamber and subjected to a gradually increasing partial vacuum. The container is observed for signs of leakage, as evidenced by escaping air bubbles during depressurization or fluid in the container after re-pressurization.

5. Significance and Use

5.1 Containers may be pressurized in accordance with this test method without modification to the closure or to the body of the container. This test method may be used for testing rigid containers intended for the transportation of some liquids by air in accordance with the ICAO TIs or in accordance with the UN TDG.

5.2 This test method establishes the point at which leakage commences, with a limit of approximately 95-kPa (13.8-psi) differential. See Test Method **D 3078** for flexible packages.

5.3 This test method may not be suitable for some packages, such as packages with paper cap seals, where the test fluid may rapidly deteriorate the packaging.

6. Apparatus

6.1 *Transparent Vessel*, large enough to permit the test specimen(s) to be immersed in the test fluid with a minimum headspace of 20 %, capable of withstanding at least 1½-atm pressure differential, fitted with a flat vacuum-tight cover is required.

6.2 *Vacuum Gage, Inlet Tube from a Source of Vacuum, and Outlet Tube to the Atmosphere*, shall be sealed into the cover. The inlet and outlet tubes shall be equipped with handoperated valves. The vacuum gage shall be laboratory quality with a full-scale range from 0 to 100 kPa (0 to 14.5 psi) with minimum graduations no greater than 2 kPa (0.3 psi) and accuracy to within 1 %. A suitable moisture trap, to prevent back-flow of liquid, should be fitted between the vacuum gage and the source of vacuum.