



Standard Specifications for Flexible Cellular Materials—Latex Foam¹

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

1. Scope*

1.1 These specifications,² including test methods, apply to flexible cellular rubber products known as latex foam rubbers but do not apply to sponge and expanded rubbers. The base material used in their manufacture shall be natural rubber, reclaimed rubber, synthetic rubber, alone or in combination.

1.2 In case of conflict between the provisions of these general specifications and those of detailed specifications or test methods for a particular product, the latter shall take precedence. Reference to methods for testing cellular rubber products should specifically state the particular test or tests desired.

1.3 The values stated in SI units are to be regarded as the standard. The values 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—There is no known ISO equivalent to this standard.

2. Referenced Documents

2.1 ASTM Standards:³

- D395 Test Methods for Rubber Property—Compression Set
- D454 Test Method for Rubber Deterioration by Heat and Air Pressure
- D572 Test Method for Rubber—Deterioration by Heat and Oxygen

¹ These specifications are under the jurisdiction of ASTM Committee D20 on Plastics and are the direct responsibility of Subcommittee D20.22 on Cellular Materials - Plastics and Elastomers.

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² These specifications together with Specification D1056 replace the former Tentative Methods of Testing Cellular Rubber Products (D552 – 46a T) and the Tentative Specifications for Cellular Rubber Products (D798 – 46a T), which were accordingly discontinued in 1949.

³ 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.

D573 Test Method for Rubber—Deterioration in an Air Oven

D1056 Specification for Flexible Cellular Materials—Sponge or Expanded Rubber

D3182 Practice for Rubber—Materials, Equipment, and Procedures for Mixing Standard Compounds and Preparing Standard Vulcanized Sheets

D3183 Practice for Rubber—Preparation of Pieces for Test Purposes from Products

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *flexible cellular rubber*—a cellular organic polymeric material that will not rupture within 60 s when a specimen 200 by 25 by 25 mm is bent around a 25-mm diameter mandrel at a uniform rate to produce 1 lap in 5 s in the form of a helix at a temperature between 18 and 29°C.

3.1.2 *rubber*—the term rubber is used to include both natural and synthetic types.

3.1.3 *skin*—the smooth surface of the latex foam rubber product, formed by contact with the mold or cover plates, is defined as a natural skin.

4. Materials and Manufacture

4.1 *Latex Foam Rubbers*—The structure of latex foam rubbers consists of a network of open or interconnecting cells. Latex foam rubbers are made from rubber latices or liquid rubbers. They are manufactured in sheet, strip, molded, or specific shapes. Latex foam rubbers shall have a vulcanized cellular structure with a porous surface. The cells shall be interconnecting and of a uniform character. Latex foam rubbers shall be either cored or solid. Size, shape, and distribution of coring shall be at the producer's option but subject to the approval of the purchaser.

5. Grades of Latex Foam Rubbers

5.1 Latex foam rubbers shall have their grade numbers designated by two letters which identify the kind of latex foam rubber as follows:

RC—Latex foam rubbers, cored, and

RU—Latex foam rubbers, uncured.

Digits following the letters are used to indicate the degree of

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

firmness, the softer grades being identified with the lower numbers and the firmer grades with the higher numbers (see Table 1).

5.2 *Suffix Letters* shall be added singly or in combination after any grade number to indicate additional requirements beyond those specified in Table 1 as basic requirements. The significance of the approved suffix letters is as follows:

SIGNIFICANCE OF SUFFIX LETTERS

| |
|---|
| Suffix Letters |
| C—Weather Resistance ^A |
| D—Load Deflection ^A |
| E—Oil Resistance ^A Note that there are no requirements for oil resistance in these specifications. |
| F1—Low-Temperature Brittleness at -40°C (-40°F) Required with values as specified in Table 1 |
| F2—Low-Temperature Brittleness at -55°C (-67°F) ^A |
| G—Tear Resistance ^A |
| H—Flex Resistance Test required with values specified in Table 1 |
| J—Abrasion Resistance ^A |
| K—Adhesion Resistance ^A |
| L—Water Resistance ^A |
| M—Flammability Resistance ^A |
| P—Non-Staining ^A |
| R—Resilience ^A |
| Z—Special Requirements ^A |

^A Test method and values to be arranged between the purchaser and the supplier.

NOTE 2—Example: Grade RC 20 F1H denotes soft, cored latex foam rubber made from natural, reclaim synthetic, or a blend with a load deflection value of 89 ± 18 N (20 ± 4 lbf) and requiring in addition to the basic tests a low-temperature test at -40°C (-40°F) and a flexing test.

6. Physical Properties

6.1 The various grades of latex foam rubber shall conform to the requirements as to physical properties prescribed in Table 1, together with any additional requirements indicated.

6.2 When subjected to the static fatigue test the latex foam specimen shall show no cracking at the folded edge.

7. Tolerances on Dimensions

7.1 Tolerances on dimensions of latex foam rubber products are given in Table 2 and Table 3.

8. Workmanship, Finish, and Appearance

8.1 Latex foam rubbers furnished under these specifications shall be manufactured from natural rubber, synthetic rubber, together with added compounding ingredients of such nature and quality that the finished product complies with the specification requirements. In permitting choice in use of those materials by the producer, it is not intended to imply that the different rubber materials are equivalent in respect to all physical properties. Any special characteristics other than those prescribed in these specifications which are desired for specific applications shall be specified in the products specifications, as they can influence the choice of the type of rubber materials or other ingredients used. All materials and workmanship shall be in accordance with good commercial practice, and the resulting cellular rubber shall be free of defects affecting serviceability.

8.2 Due to manufacturing conditions, material may have to be altered or repaired. This repaired or altered material will be acceptable under these specifications provided the material used in such repairs or alterations shall be the same composition and quality as the original product and provided such alterations do not affect the serviceability, size, and shape beyond tolerances as provided herein.

8.3 Unless otherwise specified, the color of latex foam rubbers shall be optional with the manufacturer.

TABLE 1 Physical Requirements of Latex Foam Rubbers

| Grade Number | Basic Requirements | | | | Requirements Added by Suffix Letters | | | |
|------------------------------|---|--------|---|---|--------------------------------------|---|--------------------------------------|----|
| | Indentation Value on 325 cm ² (50 in. ²), 25 % Deflection (Limits) | | Air Oven Aged 22 h at 100°C (212°F) Change from Original Load-Deflection or Indentation Value (Limits), % | Constant Deflection Compression Set 22 h at 70°C (158°F), 50 % Deflection, max, % | | Suffix F | Suffix H | |
| | N | lbf | | C _h ^A | C _d ^A | Low Temperature Test, Change from Original Deflection, max, % | Flexing Test Compression Set, max, % | |
| | | | | | | C _h ^A | C _d ^A | |
| Latex Foam Rubbers (Cored) | | | | | | | | |
| RC 5 | 22±13 | 5±3 | ±20 | 10 | 20 | 75 | 5 | 10 |
| RC 10 | 44±13 | 10±3 | ±20 | 10 | 20 | 75 | 5 | 10 |
| RC 15 | 67±18 | 15±4 | ±20 | 10 | 20 | 75 | 5 | 10 |
| RC 20 | 89±18 | 20±4 | ±20 | 10 | 20 | 75 | 5 | 10 |
| RC 25 | 111±22 | 25±5 | ±20 | 10 | 20 | 75 | 5 | 10 |
| RC 30 | 133±27 | 30±6 | ±20 | 10 | 20 | 75 | 5 | 10 |
| RC 40 | 178±31 | 40±7 | ±20 | 10 | 20 | 75 | 5 | 10 |
| RC 50 | 222±36 | 50±8 | ±20 | 10 | 20 | 75 | 5 | 10 |
| RC 60 | 267±40 | 60±9 | ±20 | 10 | 20 | 75 | 5 | 10 |
| RC 70 | 311±53 | 70±12 | ±20 | 10 | 20 | 75 | 5 | 10 |
| RC 90 | 400±62 | 90±14 | ±20 | 10 | 20 | 75 | 5 | 10 |
| Latex Foam Rubbers (Uncored) | | | | | | | | |
| RU 11 | 49±18 | 11±4 | ±20 | 10 | 20 | 75 | 5 | 10 |
| RU 20 | 89±22 | 20±5 | ±20 | 10 | 20 | 75 | 5 | 10 |
| RU 35 | 156±44 | 35±10 | ±20 | 10 | 20 | 75 | 5 | 10 |
| RU 55 | 245±44 | 55±10 | ±20 | 10 | 20 | 75 | 5 | 10 |
| RU 80 | 356±67 | 80±15 | ±20 | 10 | 20 | 75 | 5 | 10 |
| RU 150 | 667±245 | 150±55 | ±20 | 10 | 20 | 75 | 5 | 10 |

^A As defined in Section 19.

TABLE 2 Tolerances on Dimensions of Latex Foam Rubber Products for General Applications

| Dimension | Tolerance | | Dimension | Tolerance | |
|--------------------------|-----------|----|-------------------------|-----------|------|
| | + | - | | + | - |
| Thickness, mm | | | Thickness, in. | | |
| Cored | | | | | |
| 0 to 76, incl | 3 | 2 | 0 to 3, incl | 1/8 | 1/16 |
| 76 to 127, incl | 5 | 3 | 3 to 5, incl | 3/16 | 1/8 |
| 127 and over | 6 | 5 | 5 and over | 1/4 | 3/16 |
| Uncored | | | | | |
| Up to and including 12.7 | 2 | 2 | Up to and including 1/2 | 1/16 | 1/16 |
| From 12.7 to 25.4, incl | 3 | 2 | From 1/2 to 1, incl | 1/8 | 1/16 |
| Over 25.4 | 3 | 5 | Over 1 | 1/8 | 3/16 |
| Length and Width, mm | | | Length and Width, in. | | |
| Cored | | | | | |
| 0 to 152, incl | 5 | 2 | 0 to 6, incl | 3/16 | 1/16 |
| 152 to 305, incl | 10 | 3 | 6 to 12, incl | 1/2 | 1/8 |
| 305 to 610, incl | 13 | 6 | 12 to 24, incl | 1/2 | 1/4 |
| 610 to 914, incl | 16 | 10 | 24 to 36, incl | 5/8 | 3/8 |
| 914 to 1219, incl | 19 | 13 | 36 to 48, incl | 3/4 | 1/2 |
| 1219 to 1524, incl | 22 | 16 | 48 to 60, incl | 7/8 | 5/8 |
| 1524 to 1829, incl | 25 | 19 | 60 to 72, incl | 1 | 3/4 |
| 1829 and over | 29 | 22 | 72 and over | 1 1/8 | 7/8 |
| Uncored | | | | | |
| 0 to 152, incl | 8 | 2 | 0 to 6, incl | 5/16 | 1/16 |
| 152 to 305, incl | 13 | 3 | 6 to 12, incl | 1/2 | 1/8 |
| 305 to 610, incl | 18 | 6 | 12 to 24, incl | 11/16 | 1/4 |
| 610 to 914, incl | 22 | 10 | 24 to 36, incl | 7/8 | 3/8 |
| 914 to 1219, incl | 29 | 13 | 36 to 48, incl | 1 1/16 | 1/2 |
| 1219 to 1524, incl | 35 | 16 | 48 to 60, incl | 1 1/4 | 5/8 |
| 1524 to 1829, incl | 38 | 19 | 60 to 72, incl | 1 3/8 | 3/4 |
| 1829 and over | 41 | 22 | 72 and over | 1 1/2 | 7/8 |

TABLE 3 Tolerances for Special Applications of Latex Foam Rubbers, Such as Automotive Topper Pads, Spring Coverings, etc.

| Dimension | Tolerance | | Dimension | Tolerance | |
|--------------------------|-----------|----|-------------------------|-----------|------|
| | + | - | | + | - |
| Thickness, mm | | | Thickness, in. | | |
| Cored | | | | | |
| 0 to 76, incl | 5 | 2 | 0 to 3, incl | 3/16 | 1/16 |
| 76 to 127, incl | 6 | 3 | 3 to 5, incl | 1/4 | 1/8 |
| 127 and over | 8 | 5 | 5 and over | 5/16 | 3/16 |
| Uncored | | | | | |
| Up to and including 12.7 | 2 | 2 | Up to and including 1/2 | 1/16 | 1/16 |
| From 12.7 to 25.4, incl | 3 | 2 | From 1/2 to 1, incl | 1/8 | 1/16 |
| Over 25.4 | 3 | 3 | Over 1 | 1/8 | 1/8 |
| Length and Width, mm | | | Length and Width, in. | | |
| Cored and Uncored | | | | | |
| 0 to 152, incl | 8 | 2 | 0 to 6, incl | 5/16 | 1/16 |
| 152 to 305, incl | 13 | 3 | 6 to 12, incl | 1/2 | 1/8 |
| 305 to 610, incl | 18 | 6 | 12 to 24, incl | 11/16 | 1/4 |
| 610 to 914, incl | 22 | 10 | 24 to 36, incl | 7/8 | 3/8 |
| 914 to 1219, incl | 29 | 13 | 36 to 48, incl | 1 1/8 | 1/2 |
| 1219 to 1524, incl | 35 | 16 | 48 to 60, incl | 1 3/8 | 5/8 |
| 1524 to 1829, incl | 38 | 19 | 60 to 72, incl | 1 1/2 | 3/4 |
| 1829 and over | 41 | 22 | 72 and over | 1 5/8 | 7/8 |

9. Sampling

9.1 When possible, the completed manufactured product shall be used for the tests specified. Representative samples of the lot being examined shall be selected at random as required.

9.2 When it is necessary or advisable to obtain test specimens from the article, as in those cases where the entire sample is not required or adaptable for testing, the method of cutting and the exact position from which specimens are to be taken shall be specified. The apparent density and the state of cure can vary in different parts of the finished product, more especially if the article is of complicated shape or of varying thickness. These factors affect the physical properties of the

specimens. Also, the apparent density is affected by the number of cut surfaces as opposed to the number of skin-covered surfaces on the test specimen.

9.3 When the finished product does not lend itself to testing or to the taking of test specimens because of complicated shape or other reasons, the manufacturer and the purchaser shall agree on the preparation of a suitable test specimen. When differences due to the difficulty in obtaining suitable test specimens from the finished part arise, the manufacturer and the purchaser shall agree on acceptable deviations. This can be done by comparing results of standard test specimens and those obtained on actual parts.