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Standard Specification for Crosslinkable Ethylene Plastics¹

This standard is issued under the fixed designation D2647; 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.

1. Scope*

1.1 This specification covers a general classification system for crosslinkable ethylene plastics compounds (Note 1). The requirements specified herein are not necessarily applicable for use as criteria in determining suitability for the end use of a fabricated product.

NOTE 1—It is to be noted that this specification describes materials that are available commercially in their uncrosslinked form. Therefore, they are crosslinkable compounds despite the fact that measurement of the parameters used for their classification and specification will usually be carried out after curing has been effected.

1.2 Two types of compounds are covered, namely, mechanical types in which mechanical strength properties are of prime importance in applications, and electrical types in which electrical insulating or conducting properties also are of prime importance in applications.

1.3 The parameters used to classify and specify the mechanical types are ultimate elongation, elongation retention after aging, apparent modulus of rigidity, and brittleness temperature.

1.4 The parameters used to classify and specify the electrical types are ultimate elongation, elongation retention after aging, apparent modulus of rigidity, brittleness temperature, dielectric constant, dissipation factor, and volume resistivity.

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

1.6 The following safety hazards caveat pertains only to the test methods portion, Section 7, of this specification: *This specification 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 specification to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

NOTE 2—~~There is no similar or equivalent ISO standard.~~ 2—There is no known ISO equivalent to this standard.

2. Referenced Documents

2.1 ASTM Standards:²

D150 Test Methods for AC Loss Characteristics and Permittivity (Dielectric Constant) of Solid Electrical Insulation

D257 Test Methods for DC Resistance or Conductance of Insulating Materials

D573 Test Method for Rubber Deterioration in an Air Oven

D618 Practice for Conditioning Plastics for Testing

D638 Test Method for Tensile Properties of Plastics

D746 Test Method for Brittleness Temperature of Plastics and Elastomers by Impact

D883 Terminology Relating to Plastics

D991 Test Method for Rubber Property Volume Resistivity Of Electrically Conductive and Antistatic Products

D1043 Test Method for Stiffness Properties of Plastics as a Function of Temperature by Means of a Torsion Test ~~D1898~~

Practice
for Sam-
pling of
Plastics

D2765 Test Methods for Determination of Gel Content and Swell Ratio of Crosslinked Ethylene Plastics

D3892 Practice for Packaging/Packing of Plastics

IEEE/ASTM SI-10 Standard for Use of the International System of Units (SI): (The Modernized Metric System)

¹ This specification is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.15 on Thermoplastic Materials. Current edition approved July-Dec. 1, 2005-2009. Published July-December 2009. Originally approved in 1967. Last previous edition approved in 2005 as D2647 - 05a. DOI: 10.1520/D2647-05A.10.1520/D2647-09.

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.

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

2.2 Military Standard:

MIL-STD-105 Sampling Procedures and Tables for Inspection by Attributes ³(Obsolete 1995)

3. Terminology

3.1 *Definitions*: For definitions of plastics terms used in this specification, see Terminology D883.

3.2 *Abbreviations*: Units, Symbols, and Abbreviations—For units, symbols, and abbreviations used in this specification see IEEE/ASTM SI-10/IEEE/ASTM SI-10.

4. Classification

4.1 *Classification System*—Table 1 and Table 2 provide a classification system for these compounds so that the relations among them can be delineated and those that are commercially available can be readily specified. It is not the intent to indicate that all the combinations of properties possible are represented by commercial products or that they are technically possible at the present state of knowledge.

4.2 *Types*—This specification covers two general types of compounds: *Type I*—Mechanical types (Table 1), and *Type II*—Electrical types (Table 2).

4.3 *Grades*—A grade is designated by first indicating the type (I or II) followed by cell numbers for each property in the order in which they are listed in the tables. Where there is no interest in a property, a “0” is entered in place of a cell number.

5. General Requirements

5.1 The compound shall be in powder, pellet or granular form, as agreed upon between the seller and the purchaser.

5.2 The compound, after crosslinking, shall conform to the requirements given in Table 1 or Table 2, whichever is applicable, for the type and grade specified when tested in accordance with the procedures given in Sections 6, 7, and 8.

6. Sampling

~~6.1 Unless otherwise agreed between the seller and the purchaser, the material shall be sampled in accordance with the general and specific sampling procedures of Practice D1898. Adequate statistical sampling prior to packaging shall be considered an acceptable alternative.~~

6.1 Unless otherwise agreed between the seller and the purchaser, sampling shall be statistically adequate to ensure that the material was manufactured by a process in statistical control and tested in accordance with this specification.

7. Specimen Preparation

7.1 Unless otherwise agreed upon between the seller and the purchaser, the test specimens shall be formed and cured in accordance with the compound manufacturer’s recommendations.

8. Test Methods

8.1 *Conditioning*—Condition the test specimen at $23 \pm 2^\circ\text{C}$ [~~73.4~~($73.4 \pm 3.6^\circ\text{F}$)]~~3.6~~ $^\circ\text{F}$ and $50 \pm 5\%$ ~~10~~ % relative humidity for not less than 40 h prior to test in accordance with Procedure A of Practice D618, for those tests where conditioning is required and in all cases of disagreement.

² Withdrawn.

³ Available from Defense Automation and Production Service, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

TABLE 1 Type I, Mechanical Compound Requirements

Designation Order No.	Property	Cell Limits					
		0	1	2	3	4	5
1	Ultimate elongation, %	unspecified	<25	≥25			
2	Minimum of 75 % retention of elongation after aging at the specified temperature for 168 h, °C [°F]	unspecified	121 [250]	150 [302]			
<u>2</u>	Minimum of 75 % retention of elongation after aging at the specified temperature for 168 h, °C (°F)	unspecified	121 (250)	150 (302)			
3	Apparent modulus of rigidity, MPa [psi]	unspecified	<70 [10 000]	≥70 [10 000]	≥275 [40 000]		
<u>3</u>	Apparent modulus of rigidity, MPa (psi)	unspecified	<70 (10 000)	≥70 (10 000)	≥275 (40 000)		
4	Brittleness temperature, °C [°F]	unspecified	<−75 [−103]	≤−54 [−65]		≤−29 [−20]	
<u>4</u>	Brittleness temperature, °C (°F)	unspecified	<−75 (−103)	≤−54 (−65)		≤−40 (−40)	≤−29 (−20)
5	Percent extract (measure of degree of cross-linking)	unspecified	<10	≥10	≥20		≥30