



~~Designation: B703-05~~ Designation: B703 – 10

# ~~Standard Test Method for Apparent Density of Powders Using Arnold Meter~~ Standard Test Method for Apparent Density of Metal Powders and Related Compounds Using the Arnold Meter<sup>1</sup>

This standard is issued under the fixed designation B703; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

## 1. Scope\*

~~1.1 This test method covers a procedure for determining the apparent density of both free- and non-free-flowing powders, premixes, and blended mixes.~~

~~1.2 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.~~

~~1.1 This test method covers a quantitative laboratory procedure for determining the apparent density of both free-flowing and non-free-flowing metal powders, lubricated metal powder mixtures, and powder compounds.~~

~~1.2 With the exception of the values for mass, volume, and density, for which the use of the gram and the cubic centimetre units is the long-standing industry practice, the values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.~~

~~1.3 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:<sup>2</sup>

B212 [Test Method for Apparent Density of Free-Flowing Metal Powders Using the Hall Flowmeter Funnel](#)

B215 [Practices for Sampling Metal Powders](#)

B243 [Terminology of Powder Metallurgy](#)

B329 [Test Method for Apparent Density of Metal Powders and Compounds Using the Scott Volumeter](#)

~~B417 [Test Method for Apparent Density of Non-Free-Flowing Metal Powders Using the Carney Funnel](#)~~ [Test Method for Apparent Density of Non-Free-Flowing Metal Powders Using the Carney Funnel](#)

E177 [Practice for Use of the Terms Precision and Bias in ASTM Test Methods](#)

E456 [Terminology Relating to Quality and Statistics](#)

E691 [Practice for Conducting an Interlaboratory Study to Determine the Precision of a Test Method](#)

### 2.2 MPIF Standard:<sup>3</sup>

MPIF 48 [Determination of Apparent Density of Metal Powders Using the Arnold Meter](#)

## 3. Terminology

3.1 *Definitions*—Useful definitions of terms for metal powders and powder metallurgy are found in Terminology B243. Additional descriptive PM information is available in the Related Materials section of Volume 02.05 of the *Annual Book of ASTM Standards*.

3.2 *Definitions of Terms Specific to This Standard:*

<sup>1</sup> This test method is under the jurisdiction of ASTM Committee B09 on Metal Powders and Metal Powder Products and is the direct responsibility of Subcommittee B09.02 on Base Metal Powders.

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<sup>2</sup> 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.

<sup>3</sup> The sole source of supply of the Arnold Density Meter complete with bushing known to the committee at this time is Arnold P/M Consulting Services, 648 Cedar Road, St. Marys, PA 15857. If you are aware of alternative suppliers, please provide this information to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend.

<sup>3</sup> This report is available from Metal Powder Industries Federation, 105 College Road East, Princeton, NJ 08540

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

3.2.1 *Arnold Density Meter*—This instrument enables the user to determine the density of any powder or mix, whether or not the powder has flow characteristics. It simulates the action of the feed shoe of the press. The values obtained on metal powders are approximately 0.2 g/cm

3.2.1 *Arnold Apparent Density (AD<sup>A</sup>)*—the mass per unit volume of a powder, expressed in gram per cubic centimetre units, determined in accordance with the procedure in this test method.

3.2.2 *Arnold Meter*—the laboratory instrumentation pictured in Fig. 1, consisting of a steel die block with a precise cavity and a powder delivery cylinder, that is used to determine a quantitative value for Arnold Apparent Density, (AD<sub>A</sub>).

#### 4. Summary of Test Method

4.1 The test method consists of first collecting a 20 cm<sup>3</sup> higher than those obtained with the Hall, Test Method volume of the test powder by slowly sliding a cylindrical sleeve containing the test powder over a precise cavity in a die block.

4.2 The mass of the volume of powder thus collected is determined and the Arnold Apparent Density (AD<sub>A</sub>), is calculated as mass divided by volume and expressed in g/cm<sup>3</sup> units.

#### 5. Significance and Use

5.1 The apparent density is an important measure of a material characteristic of the powder that is useful to the powder producers and powder users in determining quality and lot to lot consistency.

5.2 This test method is applicable to free-flowing and non-free-flowing metal powders, lubricated powder mixtures and metal compounds.

5.3 The apparent density of a lubricated metal powder mixture may be different when a quantity settles after falling into the die cavity during automatic compacting as compared with the value obtained from a measurement taken in the laboratory under controlled test conditions.

5.4 This test method simulates the action of the feed shoe on a powder compacting press and gives an apparent density value that closely approximates the apparent density of the powder in the die cavity after the production filling operation.

5.5 Knowledge of this apparent density value for the final lubricated production powder mixture is very helpful to the powder metallurgy (PM) parts fabricator to set the compression ratios for fixed fill die cavity tooling.

5.6 The values of apparent density obtained on metal powders with this test method are approximately 0.2 g/cm<sup>3</sup> higher than those obtained using the Hall Funnel, Test Method B212; Carney, Test Method, the Carney Funnel, Test Method B417; or Scott, Test Method; or the Scott Volumeter, Test Method B329, instruments.

#### 4. Summary of Test Method

4.1 This test method consists of slowly sliding a bushing partially filled with powder over a hole in a hardened steel block, collecting and weighing the powder, and calculating its apparent density.

#### 5. Significance and Use

5.1 The apparent density is an important measure of a material characteristic inherent in the powder that is useful to the powder producers and end users in determining lot to lot consistency. Knowledge of the apparent density of the final mix as obtained with this test method is very beneficial to the powder metallurgy (P/M) parts fabricator for setting compression ratios for fixed fill die cavities.

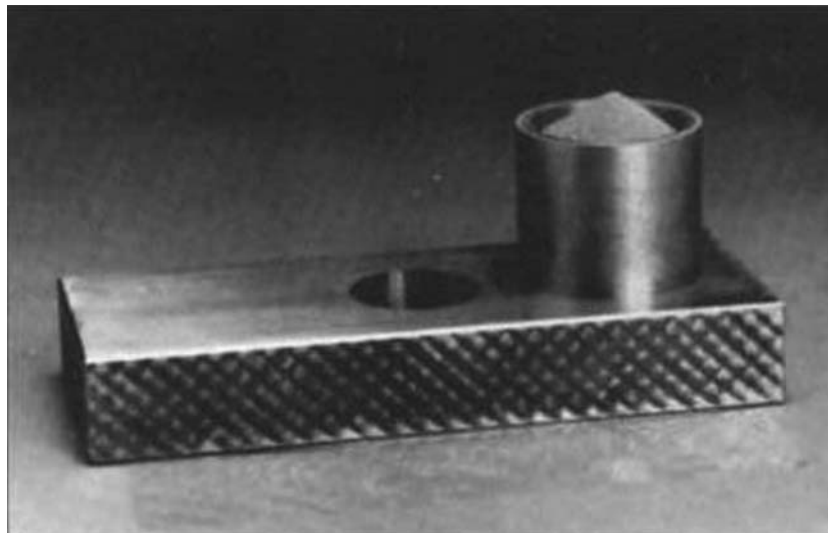


FIG. 1 Arnold Meter

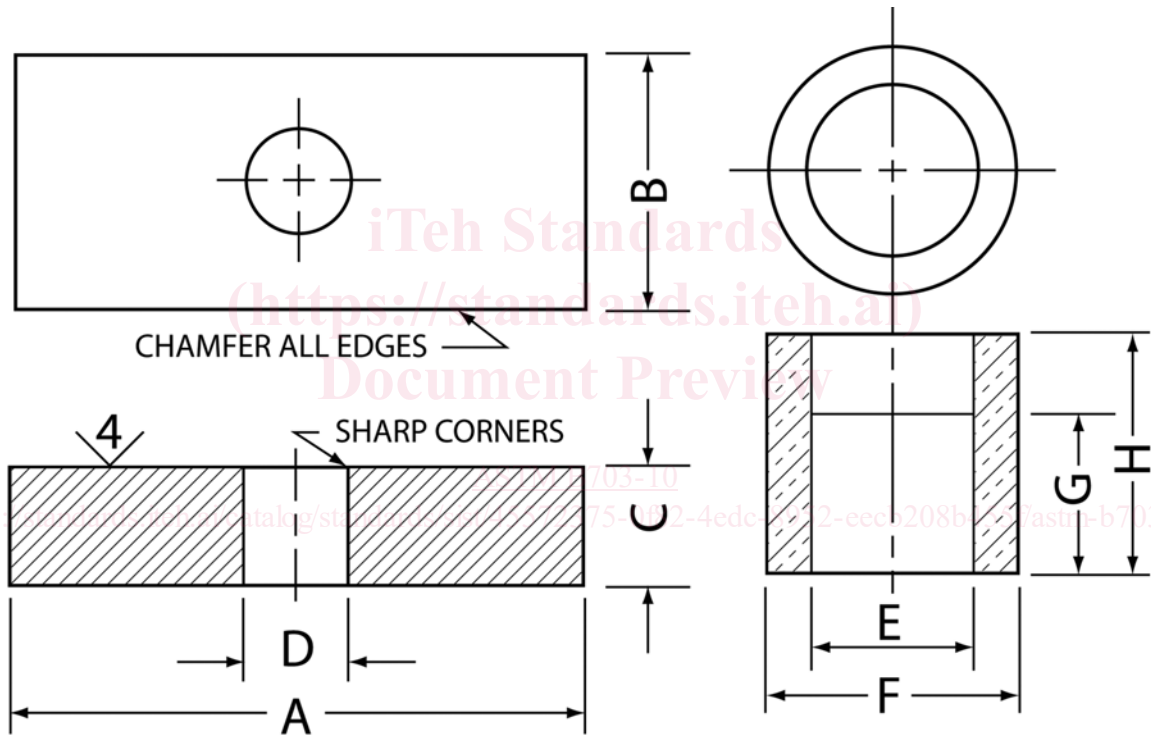
5.2 This test method may be part of a purchase agreement between the powder supplier and P/M parts producer, or it may be an internal quality control test for either party.

5.7 This test method may be part of a purchase agreement between the powder supplier and PM parts producer, or it may be an internal quality control test for either party.

**6. Apparatus**

6.1 *Steel Block*—A hardened, tempered, and demagnetized steel block (60 HRC Min.) having a center hole 31.6640 ± 0.0025 mm (1.2466 ± 0.0001 in.) in diameter and a height of 25.4000 ± 0.0025 mm (1.0000 ± 0.0001 in.) that corresponds to a volume of 20 cm<sup>3</sup>.  
*Steel Die Block*—A hardened, tempered (60 HRC min.), ground and demagnetized tool steel block approximately 6.50 by 2.50 in. (165 by 64 mm) and 1.0000 ± 0.0001 in. (25.400 ± 0.003 mm) in thickness, having a precise centrally located through-hole 1.2466 ± 0.0001 in. (31.664 ± 0.003 mm) in diameter with a volume of 20.0 cm<sup>3</sup> (1.22 in.<sup>3</sup>) (see Fig. 2). The surfaces of the sides of the die block shall be given a roughening treatment to aid in handling during use (see Fig. 1).

<sup>4</sup>The sole source of supply of the Arnold Density Meter complete with bushing known to the committee at this time is Arnold P/M Consulting Services, 648 Cedar Road, St. Marys, PA 15857. An apparatus may be produced according to the drawings, Fig. 2, in this standard. If you are aware of alternative suppliers, please provide this information to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend.



**DIE BLOCK**  
 MATL: TOOL STEEL  
 60 HRC (MIN.)  
 DEMAGNETIZED

**POWDER DELIVERY CYLINDER**  
 MATL: BRASS or BRONZE

Letter	Dimensions	
	Inches	Millimetres
A	6.50	165
B	2.50	64
C	1.0000 ± 0.0001	25.400 ± 0.003
D	1.2466 ± 0.0001	31.664 ± 0.003
E	1.50	38
F	1.75	44
G	1.13	29
H	1.50	38

**FIG. 2 Arnold Apparent Density Meter**