
**Paper and board — Testing of cores —
Part 9:
Determination of flat crush resistance**

Papier et carton — Essais des mandrins —

Partie 9: Détermination de la résistance à l'écrasement à plat

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Published in Switzerland

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 6, *Paper, board and pulps*.

This third edition cancels and replaces the second edition (ISO 11093-9:2006), of which it constitutes a minor revision.

The changes compared to the previous edition are as follows:

- A note has been added to the scope, stating that if the wall thickness of the core is less than 5 mm, the breaking point is not detectable.

A list of all parts in the ISO 11093 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Paper and board — Testing of cores —

Part 9: Determination of flat crush resistance

1 Scope

This part of ISO 11093 specifies a method for the determination of the maximum flat crush resistance of wound paper and board cores.

NOTE If the wall thickness of the core is less than 5 mm, the breaking point is not detectable.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 7500-1, *Metallic materials — Calibration and verification of static uniaxial testing machines — Part 1: Tension/compression testing machines — Calibration and verification of the force-measuring system*

ISO 11093-1, *Paper and board — Testing of cores — Part 1: Sampling*

ISO 11093-2, *Paper and board — Testing of cores — Part 2: Conditioning of test samples*

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3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

3.1

flat crush resistance

quantity calculated from the load acting at right angles to the axis of the test piece at the first maximum or levelling off of the crushing force of the load deformation curve

Note 1 to entry: The flat crush resistance is expressed in kilonewtons per metre.

4 Principle

The test piece is placed between two pressure plates arranged in parallel, so that its axis is parallel with the plane of the pressure plates and compressed at a constant plate rate until the first maximum, or levelling, of the load has been exceeded.

5 Apparatus

5.1 Compression testing machine, which shall be calibrated and verified to conform to the requirements of ISO 7500-1.

The compression testing machine shall be equipped with flat upper and lower platens held rigidly parallel during testing, permitting movement in a vertical direction only. The speed of the moving platen is the actual rate of travel of the platen while under the load. The force measurement shall have an accuracy of $\pm 1\%$ of the smallest crushing load measured.

The switch-off limit for the crushing force ΔF for a testing machine with an automatic break detection is defined by

- 30 N, or
- 3 % from the true value.

The testing machine shall be able to carry out the test so that the plates remain parallel in a range of 2 %.

5.2 Cutting device for making test pieces, capable of producing a cut at $90^\circ \pm 1^\circ$ to the axis of the core.

The device shall give a clean cut without feathering and shall not cause deformation of the test piece.

To come in line with daily practice and to make the sampling procedure and preparation of test pieces more precise and valid, a circular saw should be used.

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6 Preparation

6.1 Sampling

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Sampling shall be carried out in accordance with ISO 11093-1.

6.2 Number of test pieces

One test piece shall be taken from each specimen, at least 100 mm from the core ends, using the cutting device (see 5.2).

6.3 Size of test piece

Test pieces cut from cores of nominal internal diameter ≤ 300 mm shall be $(100 \pm 1,5)$ mm long at all points.

Test pieces cut from cores of nominal internal diameter > 300 mm shall be $(300 \pm 1,5)$ mm long at all points.

6.4 Conditioning

The test pieces shall be conditioned in accordance with ISO 11093-2.

7 Procedure

Testing shall be carried out in a standard atmosphere identical to that used for conditioning the test pieces (see 6.4).

Place the test piece centrally between the pressure platens, so that its longitudinal axis is parallel to the platens.

Crushing shall be accomplished by evenly moving one platen towards the other, or both platens in opposite directions towards each other, at a constant relative rate between 50 mm/min and 65 mm/min.

Subject the test piece to a load until the first maximum of the flat crush resistance is markedly exceeded, unless otherwise specified (for example, when determining the flat crush resistance for a specified crushing path).

To make results comparable, all calculated results have to be converted to kilonewtons per metre (kN/m), regardless of the nominal internal diameter of the core (see 6.3).

Repeat this procedure for the remaining test pieces.

8 Calculation

8.1 Calculate the flat crush resistance X_1 of a test piece, expressed in kilonewtons per metre (kN/m), with a nominal internal diameter of ≤ 300 mm according to [Formula \(1\)](#):

$$X_1 = \frac{y \times 10}{1000} \quad (1)$$

where y is the measured force, in newtons (N) per $(100 \pm 1,5)$ mm length of the test piece.

8.2 Calculate the flat crush resistance X_2 of a test piece, expressed in kilonewtons per metre (kN/m), with a nominal internal diameter of > 300 mm according to [Formula \(2\)](#):

$$X_2 = \frac{y \times 1000}{300 \times 1000} \quad (2)$$

where y is the measured force, in newtons (N) per $(300 \pm 1,5)$ mm length of the test piece.

9 Test report

The test report shall include the following information:

- a) a reference to this part of ISO 11093, i.e. ISO 11093-9;
- b) type and designation of the cores tested;
- c) date and place of sampling;
- d) date and place of testing, name and signature of tester;
- e) length and number of test pieces tested;
- f) individual values and mean (rounded to 1 %) of the flat crush resistance, in kilonewtons per metre length of core;
- g) any departure from the procedure specified in this part of ISO 11093 and any circumstances that may have affected the results.

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