



Designation: ~~D2659-95 (Reapproved 2005)~~ Designation: D2659 - 11

Standard Test Method for Column Crush Properties of Blown Thermoplastic Containers¹

This standard is issued under the fixed designation D2659; 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 test method covers the determination of mechanical properties of blown thermoplastic containers when loaded under columnar crush conditions at a constant rate of compressive deflection. Any container, whether blown commercially or in the laboratory, may be used as the test specimen.*~~

1.1 This test method covers the determination of mechanical properties of blown thermoplastic containers, whether blown commercially or in the laboratory, loaded under columnar crush conditions at a constant rate of compressive deflection.

NOTE 1—Although this test method was developed specifically for blow-molded containers, the general procedure can also be applied to containers of suitable geometries produced by other means, for example, thermoforming, injection molding, etc.

1.2 The values stated in SI units are to be regarded as the standard.

~~NOTE 2—There is no known ISO equivalent to this 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:*²

D618 Practice for Conditioning Plastics for Testing

D4976 Specification for Polyethylene Plastics Molding and Extrusion Materials

E4 Practices for Force Verification of Testing Machines

E83 Practice for Verification and Classification of Extensometer Systems

3. Terminology

3.1 *Definitions:* <https://standards.iteh.ai/catalog/standards/sist/3d9cd30-692b-4382-9f62-45bbeb203c12/astm-d2659-11>

~~3.1.1 crushing yield load—the first load at which an increase of deflection occurs with no increase in load in a compressive crushing test. It is expressed in units of kilograms (or pounds) of load.~~

NOTE 2—In some cases, usually as a result of design or styling features, or both, of a specific container, multiple values of the crushing yield load may be observed, that is, a small deflection may occur with no increase or with a decrease in the crush load, followed by resumption of the normal crush load change with deflection. This phenomenon cannot be ignored in the evaluation of the column crush properties of a blown thermoplastic container, since it may be a very useful designated failure point for the application under consideration. The load at which this abrupt change occurs may be chosen as a crushing yield load for study. In such a case, the report of results should be accompanied by a proper description of the crushing yield load selected.

3.1.2 *crushing load at failure*—the crushing load applied to a blown thermoplastic container that produces a failure by fracture or parting of the material in any portion of said container. ~~It is expressed in kilograms (or pounds).~~

3.1.3 *deflection at crushing yield load*—the decrease in length of the container specimen produced at the crushing yield load along the center line of testing (axis of crushing, see Fig. 1). ~~It is expressed in millimetres (or inches).~~ (expressed in millimetres (or inches)).

¹ This test method is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.19 on Film and Sheeting. Current edition approved July 15, 2005. Published August 2005. Originally approved in 1967. Last previous edition approved in 2001 as D2659-1995 (2001). DOI: 10.1520/D2659-95R05 on Molded and Extruded Products.

² Current edition approved Sept. 1, 2011. Published September 2011. Originally approved in 1967. Last previous edition approved in 2005 as D2659 - 1995 (2005). DOI: 10.1520/D2659-11.

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.

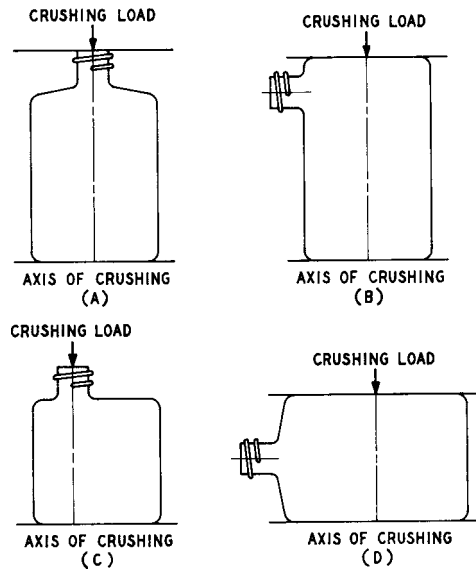


FIG. 1 Typical Crushing Axes

3.1.4 *apparent crushing stiffness*—the ratio of the crushing load to the corresponding deflection at a point on the linear portion of the crushing load deflection curve. It is expressed in newtons per metre (or pounds per inch).

4. Significance and Use

4.1 Column crush tests only provide information about the crushing properties of blown thermoplastic containers when employed under conditions approximating those under which the tests are made.

4.2 The column crush properties include the crushing yield load, deflection at crushing yield load, crushing load at failure, and apparent crushing stiffness. Blown thermoplastic containers made from materials that possess a low order of ductility may fail in crushing by brittle fracture. In such cases, the crushing yield load is equivalent to the crushing load at failure. Blown thermoplastic containers made of ductile materials may not exhibit a crushing load at failure although they will normally provide a crushing yield load value.

4.3 Column crush tests provide a standard method of obtaining data for research and development, applications, design, quality control, acceptance or rejection under specifications, and special purposes. The tests cannot be considered significant for engineering design in applications differing widely from the load - time scale of the standard test. Such applications require additional tests such as impact, creep, and fatigue.

4.4 Before proceeding with this test method, reference should be made to the specification of the material being tested. Any test specimen preparation, conditioning, dimensions, or testing parameters, or combination thereof, covered in the materials specification shall take precedence over those mentioned in this test method. If there are no material specifications, then the default conditions apply.

5. Apparatus

5.1 *Testing Machine*—Any suitable testing machine capable of control of constant-rate-of-crosshead movement and comprising essentially the following:

5.1.1 *Drive Mechanism*—A drive mechanism imparting the crosshead movable member of a uniform, controlled velocity with respect to the fixed member, this velocity to be regulated as specified in Section 9.

5.1.2 *Load Indicator*—A load-indicating mechanism capable of showing the total crushing load carried by the test specimen. The mechanism shall be essentially free from inertia-lag at the specified rate of testing and shall indicate the crushing load with an accuracy of $\pm 1\%$. The accuracy of the testing machine shall be verified at least once a year, in accordance with Practices E4.

5.2 *Extensometer*—A suitable instrument for determining the distance between the two surfaces of load application on the test specimen at any time during the test. It is desirable that this instrument automatically record this distance, or any change in it as a function of the crushing load on the test specimen. The instrument shall be essentially free of inertia-lag at the specified rate of loading and shall conform to the requirements for a Class B-2 extensometer, as defined in Practice E83.

6. Test Specimens

6.1 The specimens for testing shall be the blown thermoplastic container under investigation. The specimens must be free of obvious defects such as rocker bottoms or bent necks, unless such defects constitute a variable to be studied. The surfaces of the container that bear on the fixed and movable members of the testing machine shall be parallel to each other.

NOTE 3—In the event that the bearing surface of the blown thermoplastic container deviates noticeably from the parallel relationship, the

construction and use of a suitable testing jig will be necessary. This jig shall be attached to that crosshead member of the testing machine that contacts the nonparallel surface of the container. ~~Similarly, some blown thermoplastic container designs may cause~~ In the event of slippage on the machine crushing surfaces, surfaces, a nonslip material such as masking tape ~~should~~can be applied to the slipping member of the testing machine.

7. Conditioning

7.1 *Conditioning*—Condition the test specimens at $23 \pm 2^\circ\text{C}$ ($73.4 \pm 3.6^\circ\text{F}$) 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. In cases of disagreement, the tolerances shall be $\pm 1^\circ\text{C}$ ($\pm 1.8^\circ\text{F}$) and $\pm 2\%$ relative humidity.~~

~~7.2, unless otherwise specified by contract or the relevant ASTM material specification. In cases of disagreement, the tolerances shall be $\pm 1^\circ\text{C}$ ($\pm 1.8^\circ\text{F}$) and $\pm 5\%$ relative humidity.~~

7.2 Test Conditions—Conduct tests in the standard laboratory atmosphere of $23 \pm 2^\circ\text{C}$ ($73.4 \pm 3.6^\circ\text{F}$) and $50 \pm 5\%$ ~~10 %~~ relative humidity, unless otherwise specified ~~in by contract or the test methods, relevant ASTM material specification.~~ In cases of disagreement, the tolerances shall be $\pm 1^\circ\text{C}$ ($\pm 1.8^\circ\text{F}$) and $\pm 2\%$ $\pm 5\%$ relative humidity.

~~NOTE 4—Blown 5—~~Alternatively, blown thermoplastic container test specimens that are made of materials known to be insensitive to changes of relative humidity, may~~can~~ be conditioned at the Standard Laboratory Temperature of $23 \pm 2^\circ\text{C}$ ($73.4 \pm 3.6^\circ\text{F}$) for a period of 24 h, unless otherwise specified.

8. Number of Test Specimens

8.1 At least 20 specimens shall be tested for each sample on any given axis of crushing. If more than one axis of crushing is to be studied, at least 20 specimens shall be tested for each axis.

8.2 Specimens that fail at some obvious fortuitous flaw shall be discarded and retests made on additional specimens, unless such flaws constitute a variable to be studied. The data ~~should~~shall be discarded and the number of rejected specimens noted.

9. Speed of Testing

9.1 Speed of testing shall be the relative rate of motion of the fixed and movable members of the testing machine during the test. Rate of motion of the movable member, when the machine is running idle, may~~can~~ be used if it can be shown that the resulting speed of testing is within the limits of variation allowed.

9.2 The speed of testing shall be constant within $\pm 10\%$.

9.3 The speed of testing shall be chosen in the range from 12.5 mm (0.50 in.)/min to 50.0 mm (2.0 in.)/min.

~~NOTE 56—~~Round-robin tests have shown that precision of measurements is less than satisfactory when testing speeds less than 12.5 mm (0.50 in.)/min or more than 50.0 mm (2.0 in.)/min were employed for a limited number of blown thermoplastic container styles and designs. Lower or higher testing speeds ~~may be used~~are acceptable if it can be shown that the precision of the resulting measurements is satisfactory.

~~NOTE 6—A 7—A~~ testing speed of 25.0 ± 2.5 mm (1.0 ± 0.1 in.)/min has been found useful. It is desirable, however, that several speeds of testing be evaluated when a new blown thermoplastic container is to be studied, since different performance behavior may~~can~~ be observed~~affected~~ by different testing speeds.

<https://standards.iteh.ai/catalog/standards/sist/3d9cd30-692b-4382-9f62-45bb203c12/astm-d2659-11>

10. Procedure

~~10.1~~Conduct the tests in the standard laboratory atmosphere of $50 \pm 5\%$ relative humidity and $23 \pm 2^\circ\text{C}$ ($73.4 \pm 3.6^\circ\text{F}$) unless the material used to make the specimen is known to be unaffected by change of relative humidity. In this latter case, the tests may be conducted at the standard laboratory temperature of $23 \pm 2^\circ\text{C}$ ($73.4 \pm 3.6^\circ\text{F}$).

~~10.2~~Determine the weight of the test specimen to the nearest 0.1 g.

~~10.3~~Place the test specimen between the members of the testing machine, taking care to align the axis of crushing with the center line of the movable member of the testing machine and to ensure that the bearing surfaces of the test specimen are parallel to the bearing surfaces of the testing machine fixed and movable members. Provide a vent to allow equalization of air pressure during the crushing test. Adjust the movable member of the testing machine until it just contacts the top of the test specimen.

~~NOTE 7—~~The axis of crushing must be carefully selected so as to provide measurements along the desired blown thermoplastic container center line.

10.1 Determine the weight of the test specimen to the nearest 0.1 g.

10.2 Place the test specimen between the members of the testing machine, taking care to align the axis of crushing with the center line of the movable member of the testing machine and to ensure that the bearing surfaces of the test specimen are parallel to the bearing surfaces of the testing machine fixed and movable members. Ensure adequate venting to allow equalization of air pressure during the crushing test (see Note 8). Adjust the movable member of the testing machine until it just contacts the top of the test specimen.

10.3 Carefully select the axis of crushing so as to provide measurements along the desired blown thermoplastic container center line. Fig. 1 shows typical axes of crushing selections.

~~NOTE 8—~~Round-robin tests have shown that pressure changes within a sealed blown thermoplastic container during column crush tests will change the values obtained. If the seal is not consistent, the accuracy and precision of the measurement will be adversely affected. Furthermore, testing of sealed specimens can result in explosive failure, so that testing is not recommended without proper safeguards. Thus, venting of the specimens is necessary, not only to ensure accuracy and precision of measurements, but, also, as a safety precaution, and to ensure a correct basis for obtaining comparable measurement data. In the case of (a) and (c) in Fig. 1, this may~~can~~ be accomplished by allowing the container opening to remain unsealed and drilling