



Designation: ~~E1012-05~~ Designation: E1012 - 12

# Standard Practice for Verification of Testing Frame and Specimen Alignment Under Tensile and Compressive Axial Force Application<sup>1</sup>

This standard is issued under the fixed designation E1012; 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 Included in this practice are methods covering the determination of the amount of bending that occurs during the application of tensile and compressive forces to notched and unnotched test specimens in the elastic range and to plastic strains less than 0.002. These methods are particularly applicable to the force application rates normally used for tension testing, creep testing, and uniaxial fatigue testing.\*~~

1.1 Included in this practice are methods covering the determination of the amount of bending that occurs during the application of tensile and compressive forces to notched and unnotched test specimens during routine testing in the elastic range. These methods are particularly applicable to the force levels normally used for tension testing, creep testing, and uniaxial fatigue testing. The principal objective of this practice is to assess the amount of bending exerted upon a test specimen by the ordinary components assembled into a materials testing machine, during routine tests.

## 2. Referenced Documents

### 2.1 ASTM Standards:<sup>2</sup>

E6 Terminology Relating to Methods of Mechanical Testing

E8 Test Methods for Tension Testing of Metallic Materials

E9 Test Methods of Compression Testing of Metallic Materials at Room Temperature

E21 Test Methods for Elevated Temperature Tension Tests of Metallic Materials

E83 Practice for Verification and Classification of Extensometer Systems

E251 Test Methods for Performance Characteristics of Metallic Bonded Resistance Strain Gauges

E466 Practice for Conducting Force Controlled Constant Amplitude Axial Fatigue Tests of Metallic Materials

E606 Practice for Strain-Controlled Fatigue Testing

E1237 Guide for Installing Bonded Resistance Strain Gages

### 2.2 Other Documents:

VAMAS Guide 42 A Procedure for the Measurement of Machine Alignment in Axial Testing

## 3. Terminology

### 3.1 Definitions of Terms Common to Mechanical Testing:

3.1.1 For definitions of terms used in this practice that are common to mechanical testing of materials, see Terminology E6.

3.1.2 ~~notched section~~—the section perpendicular to the longitudinal axis of symmetry of the specimen where the cross-sectional area is intentionally at a minimum value in order to serve as a stress raiser. ~~alignment,  $n$~~ —the condition of a testing machine that influences the introduction of bending moments into a specimen (or alignment transducer) during the application of tensile or compressive forces.

3.1.3 ~~nominal percent bending in notched specimens~~—the percent bending in a hypothetical (unnotched) specimen of uniform cross section—equal to the minimum cross section of the notched specimen, the eccentricity of the applied force in the hypothetical, and the notched specimens being the same. (See 11.1.5.) (This definition is not intended to define strain at the root of the notch.) ~~eccentricity [L],  $n$~~ —the distance between the line of action of the applied force and the axis of symmetry of the specimen in a plane perpendicular to the longitudinal axis of the specimen.

3.1.4 ~~reduced section~~—the specimen length between the fillets. ~~reduced section [L],  $n$~~ —section in the central portion of the specimen which has a cross section smaller than the gripped ends.

<sup>1</sup> This practice is under the jurisdiction of ASTM Committee E28 on Mechanical Testing and is the direct responsibility of Subcommittee E28.01 on Calibration of Mechanical Testing Machines and Apparatus.

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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.

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

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *alignment*—the condition of a testing machine and fixturing (including the test specimen) which can introduce bending moments into a specimen during the application of tensile or compressive forces. *axial strain, a, n*—the average of the longitudinal strains measured by strain gages at the surface on opposite sides of the longitudinal axis of symmetry of the alignment transducer by multiple strain-sensing devices located at the same longitudinal position.

3.2.1.1 *Discussion*—This is the overall state of alignment comprising machine and specimen components.

3.2.2 *apparatus*—the components of the machine and fixturing to be used for testing. This includes all components that will be used repeatedly for multiple tests.

3.2.2.1 *Discussion*—While the strain-gaged specimen is not used for subsequent specimen testing it is included as part of the apparatus.

3.2.3 *axial strain*—the average of the longitudinal strains measured at the surface on opposite sides of the longitudinal axis of symmetry of the specimen by multiple strain-sensing devices located at the same longitudinal position as the reduced section.

3.2.3.1 *Discussion*—This definition is only applicable to this standard. The term is used in other contexts elsewhere in mechanical testing.

3.2.4 *bending strain*

3.2.2 *bending strain, b, n*—the difference between the strain at the surface and the axial strain (see Fig. 1). **†**

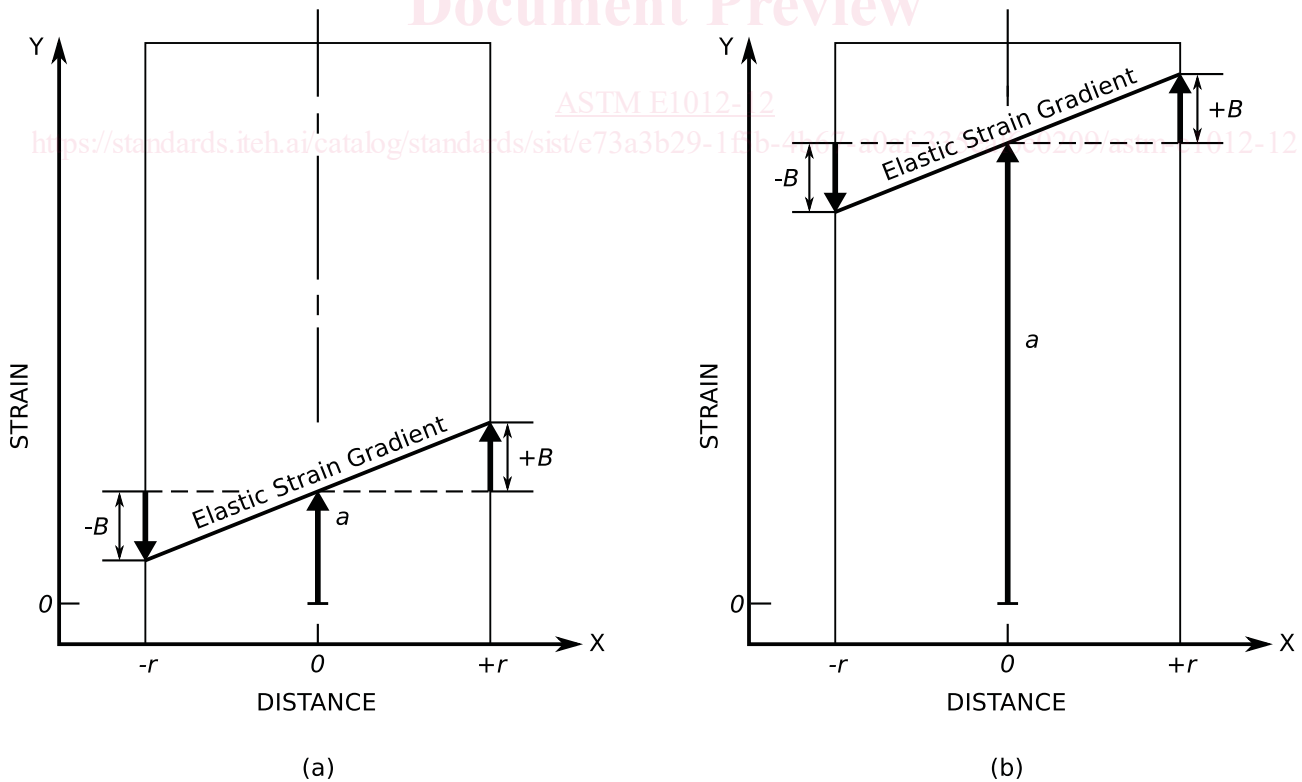
3.2.2.1 *Discussion*—in general, the bending strain varies from point to point around and along the reduced section of the specimen. Bending strain is calculated as shown in Section **††10**.

3.2.3 *component (also known as force application component), n*—any of the parts used in the attachment of the load cell or grips to the testing frame, as well as any part, including the grips used in the application of force to the strain-gaged alignment transducer or the test specimen.

3.2.4 *grips, n*—that part of the force application components that directly attach to the strain-gage alignment transducer or the test specimen.

3.2.5 *eccentricity*—the distance between the line of action of the applied force and the axis of symmetry of the specimen in a plane perpendicular to the longitudinal axis of the specimen. *microstrain, n*—strain expressed in micro-units per unit, such as micrometers/meter or microinches/in.

3.2.6 *machine alignment*—the condition of the testing machine and all rigid parts of the load train which can introduce bending moments into a specimen during subsequent force application. *notched section [L], n*—the section perpendicular to the longitudinal



NOTE—A bending strain,  $\pm B$ , is superimposed on the axial strain,  $a$ , for low-axial strain (or stress) in (a) and high-axial strain (or stress) in (b). For the same bending strain  $\pm B$ , a high-percent bending is indicated in (a) and a low-percent bending is indicated in (b).

FIG. 1 Schematic Representations of Bending Strains (or Stresses) That May Accompany Uniaxial Loading

axis of symmetry of the specimen where the cross-sectional area is intentionally at a minimum value in order to serve as a stress raiser.

3.2.7 *maximum bending strain*—the largest value of bending strain at the position along the length of the reduced section of a straight unnotched specimen at which bending is measured. (For notched specimens, see 4.9.) percent bending, PB, (also known as percent bending strain), *n*—the ratio of the bending strain to the axial strain expressed as a percentage.

3.2.8 *percent bending*—the bending strain times 100 divided by the axial strain. strain-gaged alignment transducer, *n*—the transducer used to determine the state of bending and the percent bending of a testing frame.

3.2.9 *rated force*—a force at which the alignment is being measured. Type 1 alignment, *n*—the condition of a testing machine typically used for static or quasi-static testing including the non-rigid components and the positioning of the specimen within the grips which can introduce bending moments into the strain-gaged alignment transducer or test specimen during force application.

3.2.10 *specimen alignment*—the condition of the test specimen including the non-rigid parts of the fixturing and the positioning of the specimen within the grips which can introduce bending moments into the specimen during subsequent force application. Type 2 alignment, *n*—the condition of a testing machine typically used for dynamic testing and all rigid parts of the load train which can introduce bending moments into the strain-gaged alignment transducer or test specimen force application.

#### 4. Significance and Use

4.1 It has been shown that bending stresses that inadvertently occur due to misalignment between the applied force and the specimen axes during the application of tensile and compressive forces can affect the test results. In recognition of this effect, some test methods include a statement limiting the misalignment that is permitted. The purpose of this practice is to provide a reference for test methods and practices that require the application of tensile or compressive forces under conditions where alignment is important. The objective is to implement the use of common terminology and methods for verification of alignment of test machines, associated fixtures and test specimens.

4.2 Unless otherwise specified, axiality requirements and verifications should be *optional* when testing is performed for acceptance of materials for minimum strength and ductility requirements. This is because any effects especially from excessive bending, would be expected to reduce strength and ductility properties and give conservative results. There may be no benefit from improved axiality when testing high ductility materials to determine conformance with minimum properties. Whether or not to improve axiality should be a matter of negotiation between the material producer and the user.

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4.2 Alignment verification intervals when required are specified in the methods or practices that require the alignment verification. Certain types of testing can provide an indication of the current alignment condition of a testing frame with each specimen tested. If a test method requires alignment verification, the frequency of the alignment verification should capture all the considerations i.e. time interval, changes to the testing frame and when applicable, current indicators of the alignment condition through test results.

4.3 Whether or not to improve axiality should be a matter of negotiation between the material producer and the user.

#### 5. Verification of Alignment

5.1 For ease of reference in other practices, test methods, and product specifications, the most commonly used methods for verifying alignment are listed in Section 6.

5.2 A numerical requirement for alignment should specify the force, specimen dimensions, and temperature at which the measurement is to be made. An alternate method employed when strain levels are of particular importance may be used as described in Practice E466. When this method is used, the numerical requirement should specify the strain levels, specimen dimensions and temperature at which the measurement is to be made.

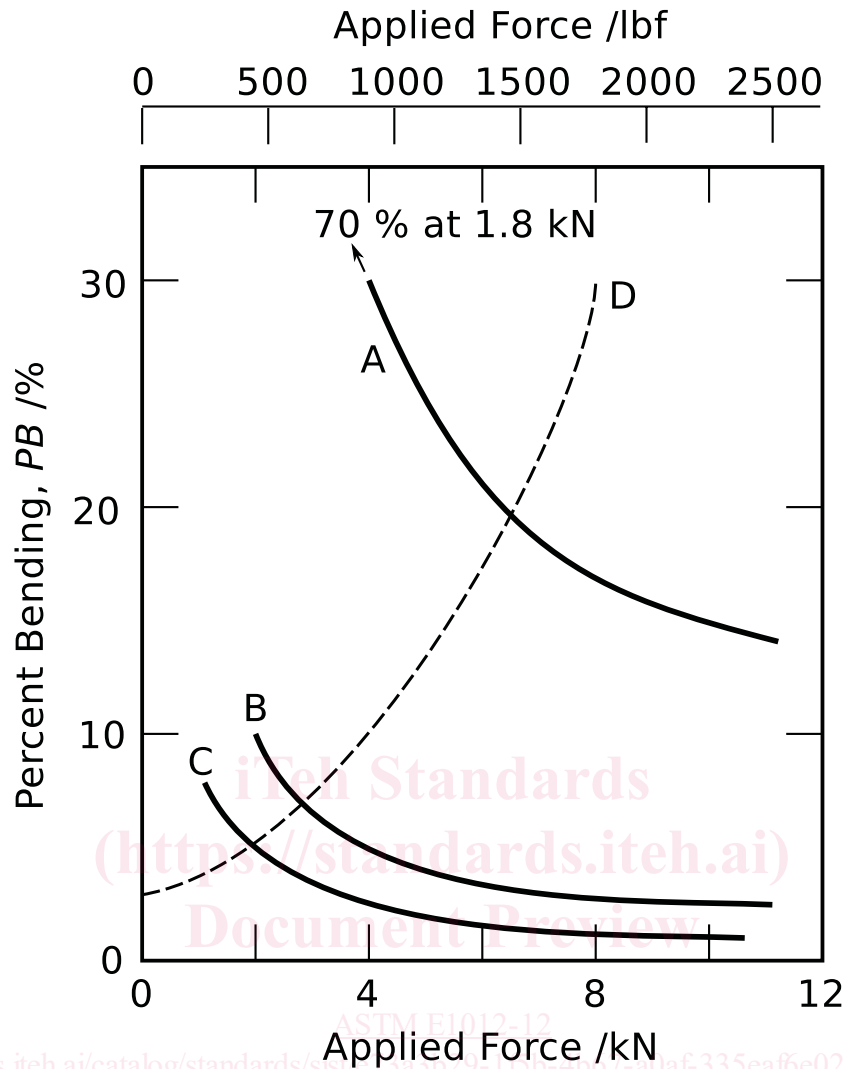
5.2.1 The force at which the bending strain is specified may be stated in terms of a yield strength or other nominal specimen stress.

5.1 A numerical requirement for alignment should specify the force, strain-gaged alignment transducer dimensions, and temperature at which the measurement is to be made. Alternate methods employed when strain levels are of particular importance may be used as described in Practices E466 or E606. When these methods are used, the numerical requirement should specify the strain levels, strain-gaged alignment transducer dimensions and temperature at which the measurement is to be made.

NOTE 1—For a misaligned load train, the percent bending usually decreases with increasing applied force. (See Curves A, B, and C in Fig. 2.) However, in some severe instances, percent bending may increase with increasing applied force. (See Curve D in Fig. 2.)

5.3 Alignment requirements and results can refer to either an overall test machine capability or to a specific test. This distinction should be noted in the results.

5.3.1 Verifications of overall test machine capability should be made using a specimen and apparatus made to a similar design and of similar materials as those that will be used during testing, except that any specimen notches may be eliminated. The same



NOTE 1—Curve A: Machine 1, threaded grip ends (11)

NOTE 2—Curve B: Machine 2, buttonhead grip ends (11)

NOTE 3—Curve C: Machine 3, grips with universal couplings (7)

NOTE 4—Curve D: schematic representation of a possible response from a concentrically misaligned load train (16)

**FIG. 2 Effects of Applied Force on Percent Bending for Different Testing Machines and Gripping Methods**

specimen may be used for successive verifications. The materials and design should be such that only elastic strains occur at the rated force. In cases where the expected test specimen material is not yet known, use good engineering judgement to select a specimen made of a commonly used material for verification.

5.2 For a verification of alignment to be reported in compliance with the current revision of E1012 a strain-gaged alignment transducer shall be used. This applies to both Type 1 and Type 2 levels of alignment verification.

5.2.1 This standard defines two types of classified testing machine alignment per the classification criteria. The type of alignment shall be noted on the report.

5.2.2 When performing an alignment of a testing machine for the first time or if normally fixed components have been adjusted or repaired, a mechanical alignment of the testing machine should be performed. For tensile and fatigue equipment, this step can be accomplished by means of a dial indicator for concentricity alignment adjustment and with precision shims or feeler gauges with the components brought together for angularity alignment adjustment. For creep and stress-rupture machines incorporating lever arms, this step may be accomplished by means of precision shims or feeler gauges, and/or double knife-edge couplings, and/or suitable components below the lower crosshead of the testing machine. Severe damage may occur to a strain-gaged alignment transducer if this step is omitted. A Mechanical Alignment is a preliminary step, but is not a substitute for a verification of alignment using a strain-gaged alignment transducer.

5.3 *Testing Machine Alignment Type 1*—A general alignment verification of the defined load train components. It is understood that some parts of the testing machine (i.e. the crosshead, actuator or grip faces) may be moved or exchanged in normal day to day testing. This alignment verification should be conducted for the various changes to the system (i.e. adjusting the crosshead and

actuator position) to demonstrate reproducibility between changing conditions. Whenever possible the alignment verification should be conducted with the testing system components at a physical position that would simulate the position in which a test specimen would be installed. The strain-gaged alignment transducer geometry and material shall be adequately referenced in the verification report.

NOTE2—To avoid damage to the verification specimen, the sum of the axial strain and the maximum bending strain should not exceed the elastic limit.

5.3.2 Verifications of specific specimens that are to become test specimens following the alignment procedure shall be made on the specimen to be tested just prior to or during the testing without removing the specimen from the testing machine or making any other adjustments that would affect alignment during the period between verification and testing. These type of verifications provide the best measure of the true bending strain in a specific test specimen. 2—Type 1 typically refers to static test equipment, such as tensile, stress rupture, or creep machines.

NOTE3—Maintaining a small force on the specimen between verification and testing may be necessary to retain alignment on test machines with non rigid fixturing.

**6. Methods of Verification of Alignment**

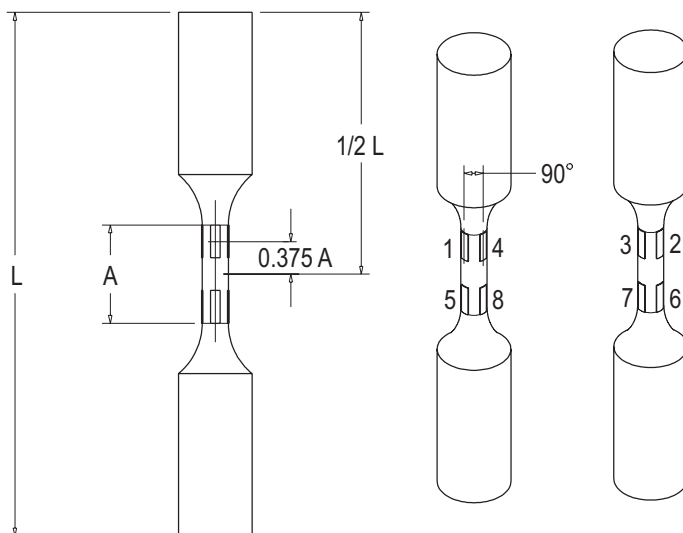
6.1 Use this method for verification of machine alignment and for measurement of specimen alignment on a particular test or at specified test conditions.

6.1.1 *Machine Alignment*—This part of the method describes the initial alignment of the rigid parts of the fixturing. Machine alignment is initially established when first installing a test machine and when setting up a particular type of rigid fixturing configuration on a testing machine. While it may not change appreciably over time, catastrophic failures in the load train (fixturing or test specimen) or wear may establish the need to measure and readjust the machine alignment. The machine alignment should be performed any time a change in the rigid fixturing is required. Machine alignment is often viewed as a “coarse” alignment.

6.1.2 *Specimen Alignment*—This part of the method describes the positioning and subsequent alignment of the specimen and all the non-rigid fixturing in the load train. It requires the use of either a strain gaged specimen of specific geometry or a mechanical alignment fixture that uses other types of displacement gages to measure the strain applied to the specimen. The strain-gaged specimen is discussed in Section 8. The mechanical alignment fixture is described in Section 7. A description of the type of alignment measuring configuration (that is, strain gaged specimen or mechanical alignment fixture) should be included in the report. Strain gaged specimens usually provide better resolution of strain readings, particularly at low levels, than do alignment fixtures so they are more commonly used for this method of measurement. Specimen alignment is often viewed as a “fine” alignment.

**7. Apparatus**

7.1 When multiple strain sensors are used as in 6.1.2, specimen size limitations may dictate the use of electrical resistance strain gages rather than extensometers or alignment fixtures employing mechanical linkages. Strain sensors, such as mechanical, optical, or electrical extensometers, as well as wire resistance or foil strain gages, can provide useful displacement data. The sensitivity of displacement measurement required by an applicable standard or specification depends on the amount of bending permitted.



Cylindrical 90° Spacing  
Figure A

**FIG. 3 A Locations of Strain Sensors on (A) Cylindrical, (B) Thick rectangular and (C) Thin Rectangular Strain-Gaged Alignment transducers (Numbers Indicate Positions of Strain Sensors)**



7.2 For verification using an alignment fixture as in 6.1.2, a single extensometer of the nonaveraging type may be used by rotating it to various positions around the perimeter during successive force applications and repeating the measurements as described in 10.5. In general, repeated force applications to strain levels approaching yielding are not good laboratory practice because they may affect the subsequently measured results by deforming or fatiguing the specimen. 3—For creep and stress rupture machines, the lever arm should be in a level position when performing alignment verification.

5.3.1 For some material testing, it is not possible or feasible to use all parts of the force application components when verifying alignment. In such cases alternative components may be used. The use of alternative components shall be adequately referenced in the verification report.

5.4 *Testing Machine Alignment Type 2*—Grip-to-grip alignment verification, where the testing machine mechanical configuration is fixed and will not be changed or adjusted during the testing period. However, when testing some specimen geometries, it may be necessary to move the actuator or crosshead to install the strain-gaged alignment transducer and/or test specimens. This should be avoided if possible, but if it is necessary, care should be taken to reposition the actuator and or crosshead in the position used during the alignment. Any removable components specific to the test specimen should be assembled within the aligned grip set and a strain-gaged alignment transducer used for verification of compliance to E1012.

5.4.1 Precision machined grip housings with hydraulic or pneumatically actuated wedge inserts are commonly used in laboratory testing. These devices are specifically designed to allow for interchangeability of wedge inserts without adversely affecting the alignment of the loading train. For testing systems using these gripping configurations, grip wedge inserts may be replaced with smooth wedge inserts to assess the alignment of the testing machine under a Type 2 alignment assessment.

NOTE 4—Repositioning the extensometer around the specimen does not usually give highly precise and reproducible results, but nevertheless is a technique which is useful for detecting large amounts of bending.

7.3 Mechanical fixturing for measurement of strain on a specimen can be an effective way to measure and allow for in-situ adjustments to improve alignment on a test specimen. Fixtures that attach to the specimen shoulders and measure displacements at four equally spaced positions around the circumference of a cylindrical specimen have been effectively used for this purpose. Displacement measurement devices need to have sufficient resolution to detect very small differences in displacements around the specimen. If this method is used these displacements must be converted to strain before applying the bending calculations. Strain should be calculated using an effective gage length as described in ASTM E21. 4—Type 2 typically refers to dynamic test equipment, such as fatigue testing machines.

NOTE 5—When multiple extensometers are used, the strain may be determined by arithmetically averaging outputs. Electrical outputs are thought to be more accurate and reproducible than mechanical outputs.

7.4 *Additional Machine and Fixturing Considerations* 5—Type 2 alignment requires as many of the adjustable components of the testing machine as possible to be positioned in the final verified position. This could include adjustable reaction components (i.e. crosshead) and actuators, which may otherwise be free to rotate about the loading axis.

5.5 Strain-gaged alignment transducers shall be manufactured per Section 7 of this standard. The strain-gaged alignment transducer is to be manufactured per section 7.4 as closely as possible, except that any notches may be eliminated. The same strain-gaged alignment transducer may be used for successive verifications. The materials and design should be such that only elastic strains occur at the applied forces.

5.5.1 Strain-gaged alignment transducers shall be used for both Type 1 and Type 2 Testing Machine Alignment.

## **6. Apparatus**

6.1 This standard requires the use of a strain-gaged alignment transducer. In some cases it may be helpful to make an assessment using extensometers or alignment components employing mechanical linkages (see Appendix X2), however these types of strain sensors do not meet the reporting requirements in Section 11.

6.2 In general, repeated force applications to strain levels approaching yielding are not good laboratory practice because they may affect the subsequently measured results by deforming or fatiguing the strain-gaged alignment transducer.

6.3 *Additional Testing Machine and Force Application Component Considerations:*

7.4.1 Poorly made components and multiple interfaces in a load train can cause major difficulty in attempting to align a test system. All components in the load train should be machined within modern machine shop practices with attention paid to perpendicularity, concentricity, flatness and surface finish. The number of components should be kept to a minimum.

7.4.2 Situations can arise where acceptable alignment cannot be achieved for a given machine, fixturing and specimen. In these cases, redesign and fabrication of any of the components may be needed to achieve acceptable alignment.

## **8. Test Specimen**

8.1 This practice refers to cylindrical specimens, thick rectangular specimens, and thin rectangular specimens. The actual specimen geometry is dictated by the test standard to be used. These specimens are usually hourglass shaped with a reduced gage section, although other specimens such as those used for compression testing are acceptable.

8.2 This practice is valid for metallic and nonmetallic test specimens.

8.3 Quality of machining of test specimens is critical. Important features include straightness, concentricity, flatness, and surface finish. In particular, specimens used for compression testing may be of the type that uses two parallel plates to apply compression

to the ends of the specimen. In these cases, the parallelism of the specimen ends is extremely important as described in ASTM Method E9.

8.4 The design of a strain-gaged specimen should follow the same guidelines as design of standard test specimens. For static (tensile, compressive and creep) testing, specimens conforming to Test Methods

6.3.1 Poorly made components and multiple interfaces in a load train can cause major difficulty in attempting to align a test system. All components in the load train should be machined within precision machining practices with attention paid to perpendicularity, concentricity, flatness and surface finish. The number of components should be kept to a minimum.

6.3.2 Situations can arise where acceptable alignment cannot be achieved for a given testing machine, set of force application components and strain-gaged alignment transducer. In these cases, redesign and fabrication of any of the components may be needed to achieve acceptable alignment.

## **7. Strain-Gaged Alignment Transducer**

7.1 This practice refers to cylindrical strain-gaged alignment transducers, thick rectangular strain-gaged alignment transducers, and thin rectangular strain-gaged alignment transducers. The actual strain-gaged alignment transducer geometry is dictated by the test standard to be used. These strain-gaged alignment transducers are usually dog-bone shaped with a reduced gauge section, although other strain-gaged alignment transducers such as those used for compression testing are acceptable.

NOTE 6—Since fabricating a strain-gaged alignment transducer can be a time consuming and expensive process it is best to have this step planned out well in advance of needing the strain-gaged alignment transducer.

NOTE 7—For notched specimens, it is acceptable to use a strain-gaged alignment transducer that simulates the anticipated test specimen without the notch.

7.2 This practice is valid for metallic and nonmetallic testing.

7.3 Quality of machining of alignment transducers is critical. Important features include straightness, concentricity, flatness, and surface finish. In particular, strain-gaged alignment transducers used for compression testing may be of the type that uses two parallel plates to apply compression to the ends of the strain-gaged alignment transducer. In these cases, the parallelism of the strain-gaged alignment transducer ends is extremely important as described in Test Methods E9.

7.4 The design of a strain-gaged alignment transducer should follow the same guidelines as design of standard test specimens. For static (tensile, compressive and creep) testing, strain-gaged alignment transducers conforming to test specimens shown in Test Methods E8 are appropriate. For fatigue testing applications, specimens conforming to ASTM E606 are appropriate. The strain-gaged specimen should be as close dimensionally to the expected test specimens as possible so that the same grips and fixturing to be used during testing will be used during alignment. The material used for the strain-gaged specimen should be as close as possible to expected test specimen materials. If the expected test material is not known, it is acceptable to use a specimen of a common material that has similar elastic properties to expected test materials. The alignment specimen should be carefully inspected and the dimensions recorded prior to application of the strain gages.

8.5 Strain Gages should be selected that have known standardized performance characteristics as described in Test Methods E251. Strain gage manufacturers provide detailed information about the strain gages available. Gages with gage lengths of approximately 10% of the reduced section of the specimen or less should be selected. The gages should be as small as practical to avoid any strain averaging effects with adjacent gages. Temperature compensated gages that are all of the same type and from the same batch should be used.

8.6 Strain gages should be installed according to procedures outlined in Guide E1237. A commonly accepted method is to make precision shallow longitudinal marks by scribing where the strain gages are to be applied. The gages are then applied with the scribe marks as the longitudinal axis. This can also be used to mark the transverse axis. This method has the added benefit that the gage placements can be inspected at any time after the installation. Note that surface preparation is often required for mounting strain gages that can have an influence on subsequent mechanical properties. For this reason, the strain gaged specimen should not be expected to supply standard mechanical properties as a normal test specimen would.

8.7 Strain gages are to be arranged in at least two sets of four with each set mounted on one of two strain measurement planes. For cylindrical specimens, the gages are equally spaced at 90 degrees to one another around the circumference of the specimen. For thick rectangular specimens (that is, those with width to thickness ratios of less than three), gages are to be mounted in the center of each of the four faces. For thin rectangular specimens (that is, those with width to thickness ratios of three or larger), the gages are to be mounted on the two larger faces in pairs of back to back sensors that are equidistant from the specimen center line. Strain gage placement is shown in are appropriate. For fatigue testing applications, strain-gaged alignment transducers conforming to test specimens shown in Practice E606 are appropriate. The strain-gaged alignment transducer should be as close dimensionally to the expected test specimens as possible so that the same force application components to be used during testing will be used during alignment. The material used for the strain-gaged alignment transducer should be as close as possible to expected test specimen materials. If the expected test material is not known, it is acceptable to use a strain-gaged alignment transducer of a common material that has similar elastic properties to expected test materials. The alignment transducer should be carefully inspected and the dimensions recorded prior to application of the strain gages.

NOTE 8—It is common laboratory practice to employ an alternate material for the strain-gaged alignment transducer in order to be able to use the strain-gaged alignment transducer for a number of repeated alignment verifications. The alternate material used should be such that the strain-gaged

alignment transducer maintains its elastic properties through the loading range of interest encountered in the alignment verification (i.e. the strain-gaged alignment transducer remains below its proportional limit). A common upper strain limit for these strain-gaged alignment transducers is 3000 microstrain maximum.

7.5 Strain Gages should be selected that have known standardized performance characteristics as described in Test Methods E251. Strain gage manufacturers provide detailed information about the strain gages available. Gages with gauge lengths of approximately 10 % of the reduced section of the alignment transducer or less should be selected. The gages should be as small as practical to avoid any strain averaging effects with adjacent gages. Temperature compensated gages that are all of the same type and from the same batch (same gage factor, transverse sensitivity and temperature coefficient) should be used.

7.6 Strain gages should be installed according to procedures in Guide E1237. A commonly used method for marking the intended strain gage locations on the alignment transducer is to precisely scribe shallow longitudinal marks and transverse marks where the strain gages are to be applied. The gages are then aligned with the scribe marks when bonding. The gage placements can be inspected after installation.

7.6.1 Surface preparation for strain gage bonding can influence mechanical properties. The strain-gaged alignment transducer should not be expected to exhibit the same mechanical properties as a standard test specimen would.

7.7 Configuration of Strain-Gaged Alignment Transducers:

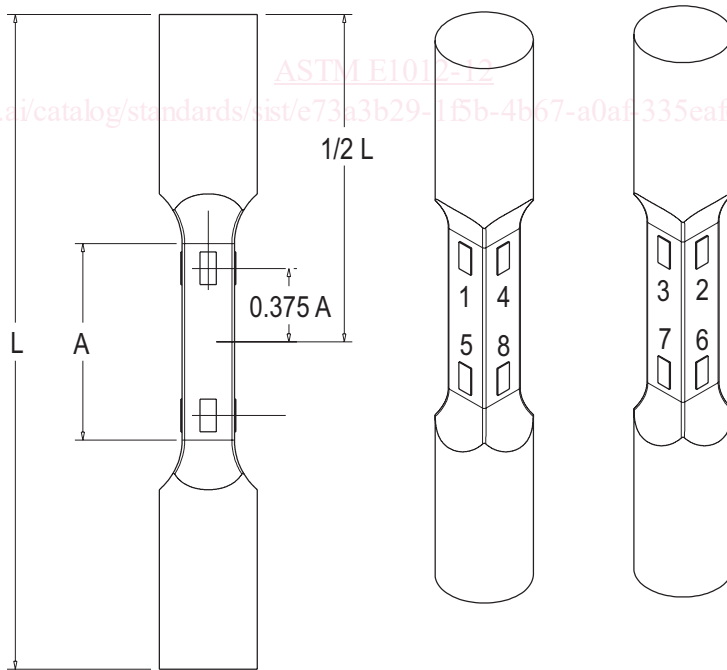
NOTE 9—External specifications and requirements may dictate specific configuration for number of gages and gage spacings.

7.7.1 The cross section of a strain-gaged alignment transducer may be cylindrical, thick rectangular (those with width to thickness ratio of less than three) or thin rectangular (those with width to thickness ratio of three or larger). Strain-gaged alignment transducers should have a minimum of two sets of four gages, but in some cases may have two sets of three gages. A third set of strain gages may be added to provide additional information. A single set of gages is acceptable in some cases. Fig. 3 for rectangular specimens. The sets of gages are to be spaced at a distance of  $0.75 \times$  the reduced section length with each set positioned equidistant from the longitudinal center of the specimen. shows the configurations of these strain-gaged alignment transducers.

7.7.2 Requirements for Cylindrical Strain-Gaged Alignment Transducers:

7.7.2.1 For strain-gaged alignment transducers with reduced section length 12 mm (0.5 in) or greater two sets of four gages are acceptable. An additional set of gages at the center of the reduced section A, is also acceptable and can provide additional information. For strain-gaged alignment transducers with reduced section length, A, less than 12 mm (0.5 in), a single set of strain gages in the center of the length of the reduced section is acceptable.

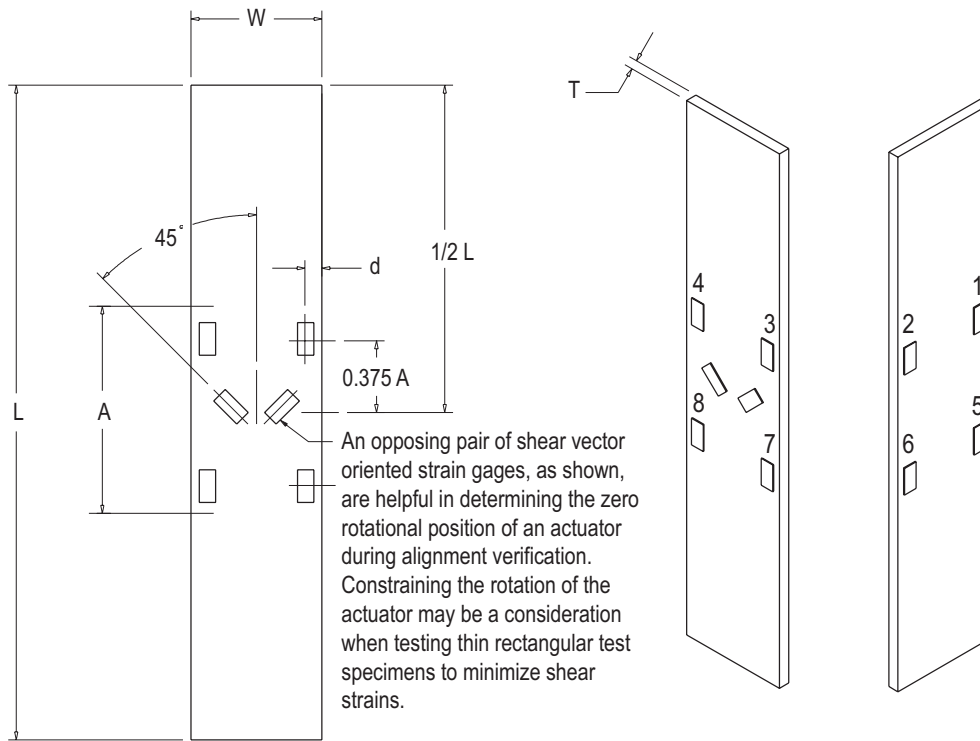
7.7.2.2 Cylindrical strain-gaged alignment transducers may have sets of either three gages or four gages. Four-gage configurations shall have gages equally spaced at 90 degrees around the circumference of the strain-gaged alignment transducer.



Thick Rectangular  
Figure B

FIG. 3 B Locations of Strain Sensors on (A) Cylindrical, (B) Thick rectangular and (C) Thin Rectangular Strain-Gaged Alignment transducers (Numbers Indicate Positions of Strain Sensors) (continued)





Thin Rectangular  
Figure C

**FIG. 3 C Locations of Strain Sensors on (A) Cylindrical, (B) Thick rectangular and (C) Thin Rectangular Strain-Gaged Alignment transducers (Numbers Indicate Positions of Strain Sensors) (continued)**

Three-gage configurations shall have gages equally spaced at 120 degrees around the circumference of the strain-gaged alignment transducer.

NOTE 6—While the maximum bending strain is usually best measured using gages placed near the ends of the reduced section, a third set of gages located at the geometric center of the reduced specimen may also be used. 10—With three-gage, 120 degree spaced configurations it can be more difficult to detect a malfunctioning gage.

7.7.2.3 In a two set strain-gaged alignment transducer the gages shall be placed equidistant from longitudinal center at a distance  $A_3 = 0.375 A$ . In a three gage set strain-gaged alignment transducer one set of gages shall be placed at the longitudinal center of the alignment transducer and the other two shall be placed at a distance  $A_3 = 0.375 A$  from the longitudinal center of the alignment transducer. In a one gage set strain-gaged alignment transducer, the gages shall be placed on the longitudinal center of the alignment transducer.

7.7.3 Requirements for Thick Rectangular Strain-Gaged Alignment Transducers:

7.7.3.1 For strain-gaged alignment transducers with reduced section length 12 mm (0.5 in) or greater two sets of four gages are acceptable. An additional set of gages at the center of the reduced section A, is also acceptable and can provide additional information. For strain-gaged alignment transducers with reduced section length, A, less than 12 mm (0.5 in), a single set of strain gages in the center of the length of the reduced section is acceptable. Thick rectangular strain-gaged alignment transducers shall have gages equally positioned on all four faces of the strain-gaged alignment transducer.

7.7.3.2 In a two gage set strain-gaged alignment transducer the gages shall be placed equidistant from longitudinal center at a distance  $A_3 = 0.375 A$ . In a three gage set strain-gaged alignment transducer one set of gages shall be placed at the longitudinal center of the alignment transducer and the other two shall be placed at a distance  $A_3 = 0.375 A$  from the longitudinal center of the alignment transducer. In a one gage set strain-gaged alignment transducer, the gages shall be placed on the longitudinal center of the alignment transducer.

NOTE 7—For thick rectangular specimens, the differences in adjacent dimensions of the gage section can lead to differences in the sensitivities of gages on these surfaces. This in turn can lead to difficulties in making adjustments to bring a test setup into good alignment. 11—For thick rectangular strain-gaged alignment transducers, the differences in adjacent dimensions of the gage section can lead to differences in the sensitivities of gages on these surfaces. This in turn can lead to difficulties in making adjustments to bring a test setup into good alignment.

7.7.4 Requirements for Thin Rectangular Strain-Gaged Alignment Transducers:

7.7.4.1 For strain-gaged alignment transducers with reduced section length 12 mm (0.5 in.) or greater two sets of four gages

are acceptable. An additional set of gages at the center of the reduced section  $A$ , is also acceptable and can provide additional information. For strain-gaged alignment transducers with reduced section length,  $A$ , less than 12 mm (0.5 in.), a single set of strain gages in the center of the length of the reduced section is acceptable.

7.7.4.2 Thin rectangular strain-gaged alignment transducers shall have sets of 4 gages equally spaced on the two wide faces of the strain-gaged alignment transducer. Gages shall be in the same position on both faces of the strain-gaged alignment transducer. In a two gage set strain-gage alignment transducer the gages shall be placed equidistant from longitudinal center at a distance  $A_3 = 0.375 A$ . In a three gage set strain-gaged alignment transducer one set of gages shall be placed at the longitudinal center of the alignment transducer and the other two shall be placed at a distance  $A_3 = 0.375 A$  from the longitudinal center of the alignment transducer. In a one gage set strain-gaged alignment transducer, the gages shall be placed on the longitudinal center of the strain-gaged alignment transducer.

NOTE8—Arrays of three gages at 120 degree spacing on cylindrical specimens are acceptable if there is a compelling reason to use this configuration. Caution should be taken with this configuration as adjustments to the test machine and fixturing become more complicated and less intuitive. In addition, it is more difficult to detect a malfunctioning gage. 12—An opposing pair of shear vector oriented strain gages, as shown in Fig. 3C, are helpful in determining the zero rotational position of an actuator during alignment verification. Constraining the rotation of the actuator may be a consideration when testing thin rectangular test specimens to minimize shear strains.

## **8. Calibration and Standardization**

8.1 All conditioning electronics and data acquisition devices used for the determination of testing system alignment shall be calibrated where applicable. The calibration results shall be traceable to the National Institute of Standards and Technology (NIST) or another recognized National Metrology Institute. Overall system expected performance should be no more than 1/3rd the Expected Class Accuracy from Table 1.

NOTE9—Geometry and dimensions of test specimens taken from different product forms are described in the Test Specimen section of Test Methods E8. 13—Where the 100 microstrain fixed limit criteria is invoked, the system would have to measure strain to at least + 33 microstrain.

8.1.1 Calibration of strain-gaged alignment transducers is not required by this standard. Traceable national standards do not generally exist for such calibrations. However, great care should be taken in the manufacture of strain-gage alignment transducers used for the determination of alignment. With the exception of cases where the strain-gaged alignment transducer is bent, the sources of measurement error due to individual gage misalignment and differences in gage sensitivity can be minimized by acquiring rotational and repeatability data runs.

8.2 Strain gages should conform to the requirements of Test Methods E251.

## **9. Calibration and Standardization**

9.1 All conditioning electronics and data acquisition devices used for the determination of testing system alignment shall be calibrated where applicable. The calibration results shall be traceable to the National Institute of Standards and Technology (NIST) or another recognized National Metrology Institute.

9.1.1 Calibration of strain gaged specimens is very difficult and is not required by this standard. However, great care should be taken in the manufacture of strain gage specimens used for the determination of alignment. With the exception of cases where the gaged specimen is bent, the sources of measurement error due to individual gage misalignment and differences in gage sensitivity can be minimized by acquiring rotational and repeatability data runs.

9.2 Extensometers should be verified in accordance with Practice E83. Typically extensometers that meet the ASTM classification B-2 are adequate for most determinations of alignment.

9.3 Strain gages should conform to the requirements of Test Methods E251.

## **10. Procedure**

10.1 Temperature variations during the verification test should be within the limits specified in the methods or practices which require the alignment verification.

10.2 Machine Alignment—This section describes the initial alignment of the rigid parts of the fixturing. Machine alignment is usually established when setting up a particular type of rigid fixturing configuration on a testing machine. While it often does not change appreciably over time, shock from catastrophic failure in the load train (within the fixturing or test specimen) or wear may establish the need to measure and readjust the machine alignment. Before continuing with subsequent fine alignment activities, one should always be sure that the machine alignment is acceptable.

10.2.1 Inspect all tooling for the ability of the force bearing surfaces to properly mate with one another and with the alignment specimen and subsequent test specimens. This includes but is not limited to concentricity, perpendicularity and parallelism measurements. Other measurements may be needed for specific types of grips and tooling. Re-machine specific parts of the fixturing if necessary.

10.2.2 Assemble the rigid portion of the fixturing, and inspect the position of the tooling on one end of the specimen attachment point with respect to the position of the tooling on the other end of the opposite specimen attachment point. This is often done with a dial indicator setup that allows the user to establish both linear (concentric or parallel) and angular differences between the centerlines of the tooling on each end of the specimen attachment points. Procedure