



Designation: ~~D5630~~—~~06~~ D5630 – 13

Standard Test Method for Ash Content in Plastics¹

This standard is issued under the fixed designation D5630; 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 was developed to determine the inorganic content of plastics by destructive ashing procedures. Ash levels of 0.01 % or above are covered by this test method.

1.2 These ashing procedures are used only to quantify the residual solids in the polymer and can not be used to identify the individual chemical components of the ash, qualitatively.

1.3 This test method is limited to those materials (including glass) that are stable to 900°C. Test Method ~~D2584~~ is recommended for unknown samples, and in instances where fusion of the inorganic portions may be of concern.

1.4 Fluorinated polymers and polymers containing halogenated components have not been included in these procedures.

1.5 Two procedures for determining the inorganic residue in plastics are listed as follows:

1.5.1 *Procedure A, Muffle-Furnace Technique*— For 5 – 50 gram samples. Samples are flamed over a burner prior to being ashed in a muffle furnace.

1.5.2 *Procedure B, Rapid-Ash Muffle-Furnace Technique*— For ~~5~~—~~50~~ 2–10 gram samples. Samples are ignited and ashed in a muffle furnace.

NOTE 1—For more efficient ashing, the plastic sample should be in the form of powder or pellet.

NOTE 2—This test method provides consistent results of filler content for a specific filler in a specific resin. However, this method may not provide the absolute filler content in all cases. This includes polymers filled with CaCO₃, nano clays, and Carbon Black.

NOTE 3—Procedure B is similar equivalent to ISO 3451/1-1981(E)-3451/1-(E), Method A.

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

1.7 *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. See Section 9 for specific precautionary statements.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[D883 Terminology Relating to Plastics](#)

[D1600 Terminology for Abbreviated Terms Relating to Plastics](#)

[D2584 Test Method for Ignition Loss of Cured Reinforced Resins](#)

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

2.2 *ISO Standard:*

[ISO 3451/1-1981\(E\)3451/1-\(E\) Plastics—Determination of Ash—Part 1, Ash—Part 1: General Methods, 5.3-Method A—Direct Calcination](#)³

3. Terminology

3.1 *Definitions*—For definitions of plastics terms, see Terminologies [D883](#) and [D1600](#). There are no terms in this test method that require new or other than dictionary definitions.

¹ This test method is under the jurisdiction of ASTM Committee [D20](#) on Plastics and is the direct responsibility of Subcommittee [D20.70](#) on Analytical Methods. Current edition approved ~~Sept. 1, 2006~~ April 1, 2013. Published ~~October 2006~~ April 2013. Originally approved in 1994. Last previous edition approved in ~~2004~~2006 as ~~D5630-01~~D5630 - 06. DOI: ~~10.1520/D5630-06~~10.1520/D5630-13.

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.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

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

4. Summary of Test Method

4.1 This test method is based on a loss in weight of a plastic sample when combusted to oxidize all organic matter.

5. Significance and Use

5.1 Inorganic residues from plastics ashing may be antiblock, fillers, reinforcements, catalyst residues, colorants, etc. The quantitative amounts of each are important variables of the manufacturing process.

6. Interferences

- 6.1 A flame height of over 2.5 cm from the burner is likely to cause a loss of fine particles.
- 6.2 Large sample sizes (**Note 5**) could result in the evolution of pyrolysis products that could affect the ash recovery.
- 6.3 Furnace doors must be in the closed position during the ignition period to prevent too-rapid oxidation and combustion of the sample (**Note 7**).
- 6.4 Ensure that all crucibles are cooled to ambient temperature before weighing.

7. Apparatus

7.1 *Balance*—A balance having the capability to weigh the sample to the nearest 0.0001 g. The balance ~~should~~shall be checked periodically to ensure accuracy.

7.2 *Crucibles*—~~Porcelain~~ Porcelain, platinum, or quartz-fiber, of sufficient ~~size~~size and inert to the material being tested. The quartz-fiber crucible is only used in Procedure B.

NOTE 3—~~Coors porcelain crucibles, or CEM quartz-fiber crucibles No. 303040,⁴ or equivalents, may be used.~~

7.3 *Muffle Furnace*—Electric-resistance-heated or microwave-heated furnace, capable of maintaining a temperature of $900 \pm 25^\circ\text{C}$.

NOTE 4—If an electric muffle furnace is used, it should be positioned in a well-ventilated hood. If a microwave furnace is used, it should be positioned within or adjacent to the hood and the exhaust tube vented into the hood ~~to~~or to the atmosphere through duct work to prevent breathing of the byproducts of the combustion. A microwave furnace ~~should~~be capable of providing an air flow of $2.8 \text{ m}^3/\text{min}$ to be moved through the microwave ~~cavity~~cavity is recommended.

7.4 *Cooling Assembly*—A nichrome triangle is positioned over a polypropylene funnel connected to a dry compressed-air source, or equivalent. See **Fig. 1**, Procedure B. Calibrate the air flow with a wet test meter or bubblemeter to yield a flow rate of approximately 30 L/min.

7.5 *Burner*.

7.6 *Desiccator*.

8. Reagents and Materials

8.1 *Desiccant*—Materials suitable for use in the desiccator may be chosen from the following:

- 8.1.1 *Anhydrous Calcium Sulfate.*
- 8.1.2 *Silica Gel.*

9. Safety Precautions

- 9.1 Always wear safety glasses when working in the laboratory.
- 9.2 Exercise all normal safety precautions when working with open flames and high temperatures. Use insulated gloves and long crucible tongs when transferring crucibles.
- 9.3 Always work with an appropriately vented muffle furnace or under a fume hood when ashing. Irritant fumes are given off by the polymer during ashing.

10. Sampling, Test Specimens, and Test Units

10.1 For hygroscopic materials such as nylons, etc., dry sample specimens to constant weight before testing.

11. Preparation and Apparatus

11.1 *Crucible Preparation*—Clean the porcelain or platinum crucibles with tap water and an abrasive detergent. Ensure that any baked-in residue is removed from the crucibles completely. Quartz-fiber crucibles are disposable items and do not require cleaning.

11.2 Fire (condition) the clean crucibles in a muffle furnace at the set operating temperature for 5 min to burn off any residue in the crucibles.

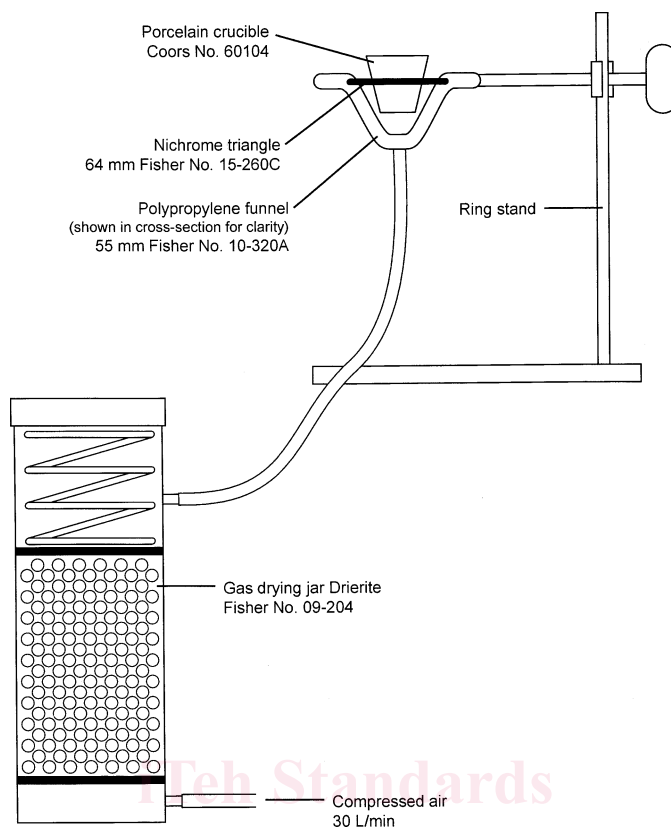


FIG. 1 Cooling Assembly

11.3 After firing (conditioning) the crucibles, place them in a desiccator to cool for 20 to 30 min (porcelain or platinum crucibles) or 2 min (quartz-fiber crucibles). Handle the crucibles with tongs only.

12. Calibration and Standardization

12.1 Calibrate the analytical balances in accordance with the manufacturer's procedure.

13. Procedure A—Muffle Furnace Technique

13.1 *Sample Type*—Determine the type of polymer and anticipated amount of inorganics in the polymer to be ashed. Determine the ashing temperature, ashing time, and sample size required to perform the ash analysis in accordance with **Table A1.1**.

13.2 *Preashing Procedure*—Weigh a clean, dry porcelain or platinum crucible to the nearest 0.0001 g. Record the resulting value as W_1 .

13.2.1 Weigh approximately the amount of material in accordance with **Table A1.1** into the preweighed crucible. Record the resulting value as W_2 .

13.2.2 Place the crucible on a burner. (The diameter of the flame equals approximately 2.5 cm, and the height of the flame equals just enough to touch the wire gauze holding the crucible.) Ensure that the material does not overflow the crucible. When the flash point of the polymer is attained (which is approximately 600°C for most plastics), the polymer begins to burn. To prevent the loss of fine particles, ensure that the flame intensity appearing from the crucible is low and that the flame height is not over 2.5 cm. Continue flaming until there are no visible flames appearing in the crucible.

13.3 *Muffle Furnace*—Using tongs, remove the crucible from the burner, and place it in the muffle furnace (electric or microwave) set at the desired temperature in accordance with **Table A1.1**.

13.4 After the prescribed duration in the muffle furnace (as specified in **Table A1.1**), using tongs, remove the crucible from the muffle furnace and place it in a desiccator until cool.

13.5 Weigh the cooled crucible and record the resulting value as W_3 .

13.6 After recording the data, place the crucible into the muffle furnace at the recommended temperature. Remove the sample after 30 min and cool in a desiccator. Weigh the cooled crucible and record the weight. If the current weight varies more than 2 mg, continue ashing the sample at the recommended temperature until constant weight is reached.

13.7 Calculate the ash content of the sample in accordance with **Eq 1**.