
**Metallic powders — Determination of
green strength by transverse rupture
of rectangular compacts**

*Poudres métalliques — Détermination de la résistance à la rupture
transversale de comprimés rectangulaires à cru*

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Foreword

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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 document 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).

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This document was prepared by Technical Committee ISO/TC 119, *Powder metallurgy*, Subcommittee SC 2, *Sampling and testing methods for powders (including powders for hardmetals)*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/SS M11, *Powder metallurgy*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This third edition cancels and replaces the second edition (ISO 3995:1985), which has been technically revised.

The main changes are as follows:

- allowing automated compacting sequence in [7.4](#);
- adding second compacting pressure option and tighter tolerance in [7.5](#);
- mandatory reporting of lubrication technique and lubrication details in Clause [9](#);
- replacing stearic acid by synthetic wax;
- removing the use of solvent.

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.

Metallic powders — Determination of green strength by transverse rupture of rectangular compacts

1 Scope

This document specifies a method for the determination of green strength by measuring the transverse rupture strength of compacts of rectangular cross-section.

2 Normative references

There are no normative references in this document.

3 Terms and definitions

No terms and definitions are listed in this document.

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

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

4 Principle

Subjection of a compact pressed from metallic powder to a uniformly increasing transverse force under controlled conditions until fracture occurs. Determination of the transverse rupture strength, or green strength as used herein, as the stress, calculated from the flexure formula, required to break the compact as a simple beam supported near the ends and applying the force midway between the fixed centre of supports.

The green strength is determined on compacts either having a particular density or after compaction at a specific compacting pressure.

5 Apparatus

5.1 Die, preferably of cemented carbide or alternatively of tool steel, and two punches for producing rectangular test pieces with dimensions according to [Clause 6](#).

All mating parts shall be fitted and lapped. An example of a design for tooling is shown in [Figure 1](#).

The mounting of the cylinders shall be such as to account for the permitted deviation from parallelism of the top and bottom faces of the test piece.

A diagrammatic arrangement of a typical test fixture is shown in [Figure 2](#).

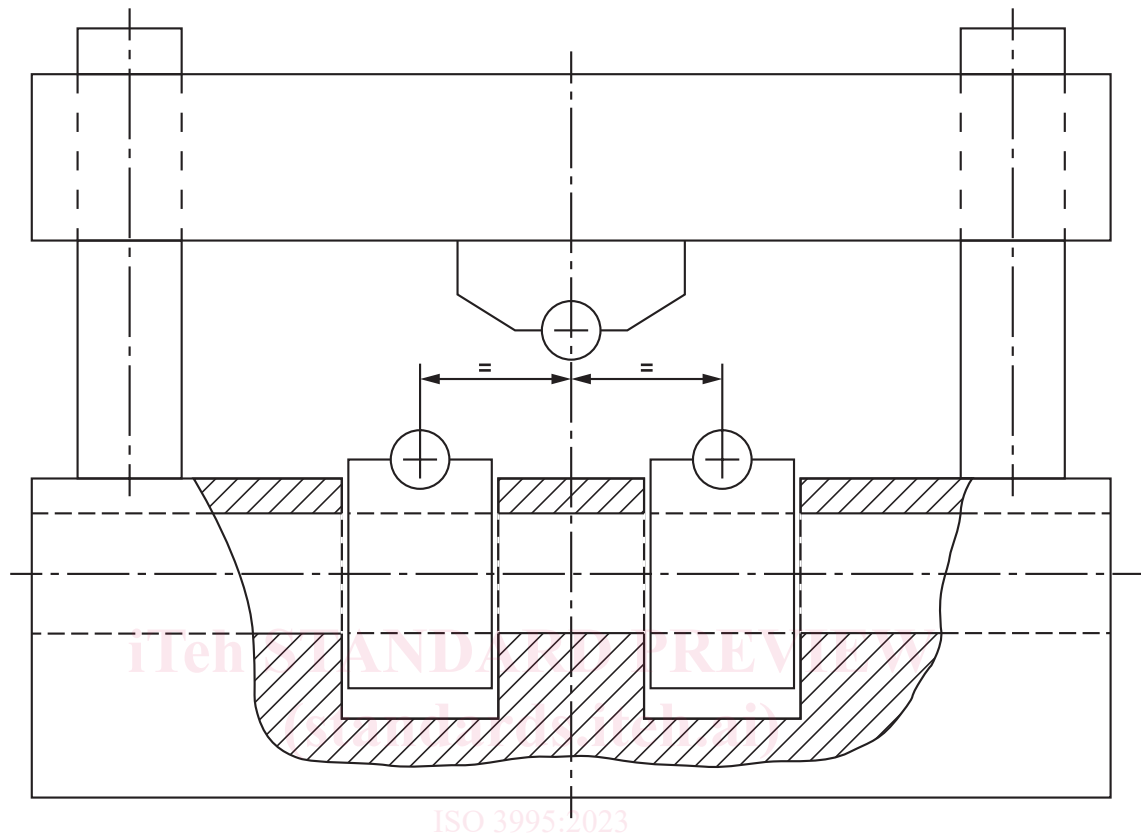


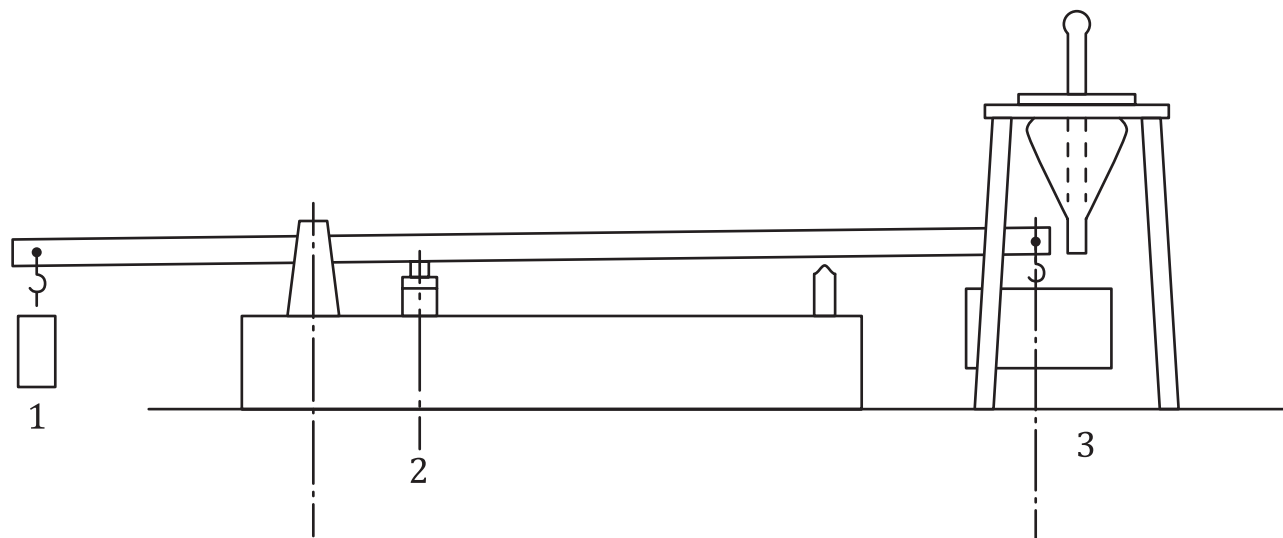
Figure 2 — Diagram of test fixture

5.6 Loading device. Loading devices shall be either of the devices in [5.6.1](#) or [5.6.2](#).

5.6.1 A compression testing machine capable of determining the breaking force with a minimum accuracy of ± 2 N.

5.6.2 A loading beam apparatus to properly locate the test piece and which is capable of applying a breaking force through a lever arrangement. The applied force on the test piece shall be calculated to an accuracy of ± 2 N.

Note The applied force can be exerted by various systems, an example of which is given in [Figure 3](#).

**Key**

- 1 counterbalance
- 2 test fixture
- 3 load

Figure 3 — Example of loading beam apparatus

6 Sampling

The quantity of the test sample shall be chosen to give three test pieces with the dimensions 10 mm to 13 mm wide, at least 30 mm long and 5,5 mm to 6,5 mm thick. The thickness of the test piece shall be uniform within 0,1 mm over the distance between supports. If necessary, preliminary tests should be made in order to establish the quantity of powder which is needed to fulfil this requirement.

7 Procedure

7.1 Cleaning of the die and punches

Wipe the die cavity and the punches with soft and clean paper.

7.2 Powder testing conditions

7.2.1 Powders which do not contain a lubricant can be compacted in the following ways:

- a) in a dry die

Note seizure and excessive die wear may occur, particularly at high compacting pressures;

- b) in a die with lubricated walls (see [7.3.2](#));
- c) after admixing a lubricant (see [7.3.3](#)) and in a dry die.

7.2.2 Powders which contain a lubricant can be compacted the following ways:

- a) in a dry die;
- b) after admixing additional lubricant (see [7.3.3](#)) and in a dry die.

7.3 Lubrication

7.3.1 General

Lubrication shall be either of the methods in [7.3.2](#) or [7.3.3](#) or a combination of them.

7.3.2 Die wall lubrication

Apply to the die walls a mixture or a solution of a lubricant in a volatile liquid, for example 100 g of zinc stearate in 1 000 cm³ of acetone. After any excess liquid has drained away, allow the solution adhering to the walls to evaporate leaving a thin layer of lubricant.

7.3.3 Lubrication of powder

Lubricate the powder to be tested by thoroughly mixing into it a quantity (for example 0,5 % to 1,5 %) of a suitable solid lubricant (for example zinc stearate or synthetic wax).

7.4 Compacting and ejection

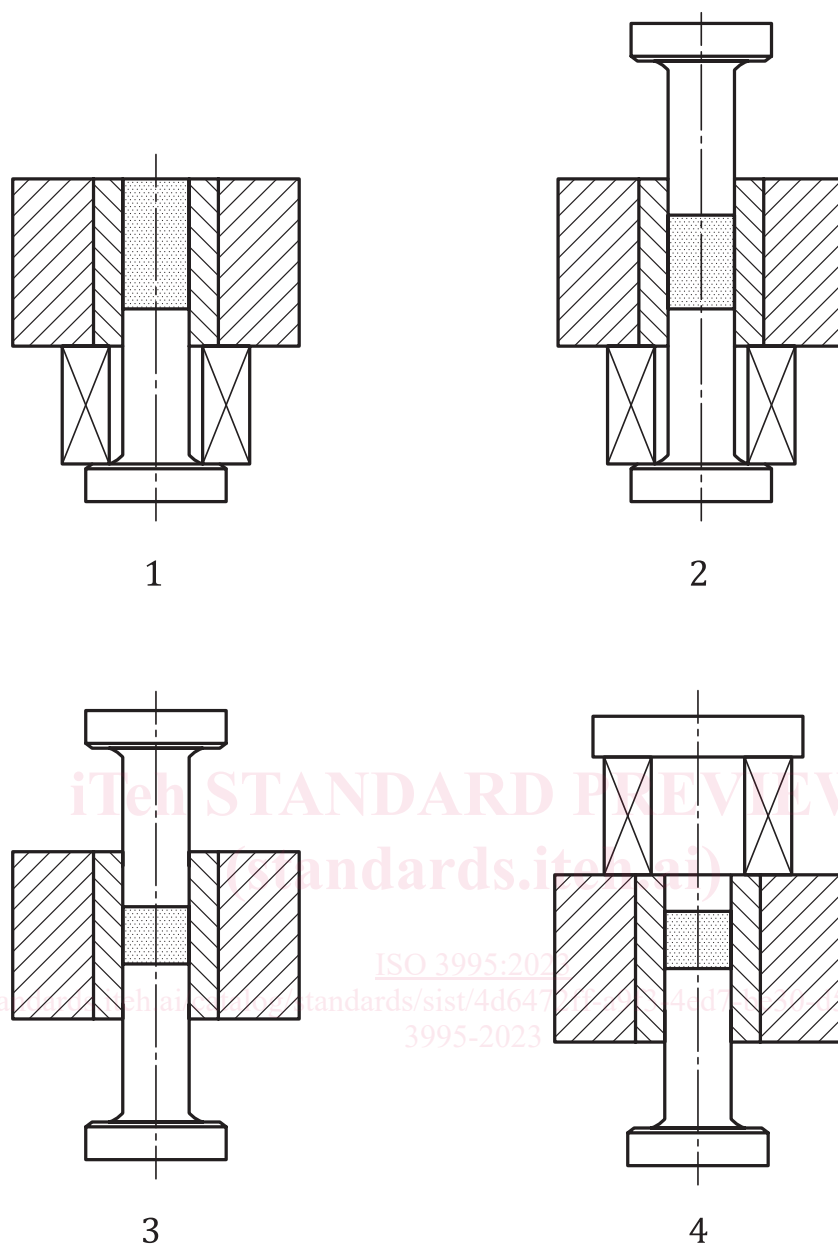
Insert the lower punch into the die cavity. Position the die to the desired filling height by using supporting spacers between the die and the foot of the lower punch. Pour the sample into the die cavity, taking the usual precautions to ensure that the powder is uniformly distributed in the die cavity. Position the upper punch and place the die with the punches between the platens of the press. Apply and release a preliminary force of approximately 20 kN. Remove the spacers supporting the die. If the die is supported by springs, or in some similar way, it is not necessary to apply the preliminary force.

Apply the final force at a constant rate which shall not exceed 50 kN/s.

Eject the compact from the die by means of the lower punch.

The procedure of compacting and ejection is exemplified in [Figure 4](#).

A press tool built into an adaptor where the powder is filled into the tool die by a fill shoe and compaction and ejection is carried out in an automated sequence by the press is also a viable option. With such arrangement the requirement maximum load rate is still valid. The tool arrangement shall enable to compact the specimen uniaxially by means of supporting the die on springs, or alternatively, by controlling the motion of the tool die in relation to the movement of the upper punch.

**Key**

- 1 filling
- 2 pre-compacting
- 3 compacting
- 4 ejection

Figure 4 — Procedure of compacting and ejection

7.5 Compacting pressure

Green strength shall be determined at a given pressure or density following agreement between supplier and customer. In the first case the recommended pressure is 400 N/mm^2 or 600 N/mm^2 . In the second case, when test pieces are pressed to a given density, the maximum deviation between the three test pieces shall not exceed $\pm 0,05 \text{ g/cm}^3$ from target density.