



Designation: F 19 – 64 (Reapproved 2000)

Standard Test Method for Tension and Vacuum Testing Metallized Ceramic Seals¹

This standard is issued under the fixed designation F 19; 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 procedures for conducting tension and vacuum tests on metal-ceramic seals to determine the bond strength of brazed, metallized ceramics. This test method is not to be considered as an absolute tension test for the ceramic.

1.2 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

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:*

E 4 Practices for Force Verification of Testing Machines²

E 6 Terminology Relating to Methods of Mechanical Testing²

3. Terminology

3.1 *Definitions:*

3.1.1 The definitions of terms relating to tension testing appearing in Definitions E 6, shall apply to the terms used in this test method.

4. Apparatus

4.1 *Testing Machines*—Machines used for tension testing shall conform to the requirements of Methods E 4. Only loads that are within the loading range of the testing machine, as defined in Methods E 4, shall be used for determining tensile strengths.

4.2 *Gripping Devices*—Various types of gripping devices may be used to apply the load to the test specimen. Those shown in Fig. 1 are recommended, but regardless of which

grips are used, care shall be taken that the axis of the test specimen is in alignment with the centerline of the test machine heads.

5. Preparation of Specimens

5.1 Prepare the test specimen by brazing together two pieces of ceramic, shown in Fig. 2, at their respective metallized surfaces, as described in 5.1.1 to 5.1.3:

5.1.1 *Ceramics*—Grind the test surface, A, (Fig. 2) of the two ceramic parts flat to within 0.00025 in. (0.0064 mm) according to good grinding practice using an abrasive passing or finer than a No. 100 (150- μ m) sieve. The ground surface, A, of each part shall be parallel to shoulder C, as shown in Fig. 2, consistent with the best commercial practice. The over-all appearance of each ceramic half of the test specimen shall indicate good commercial practice, and shall be free from obvious defects. In the results of the test, report the method of manufacture of the specimen components, that is, slip cast, hotpressed, hydrostatically molded, etc. Measure and record the test surface area of each ceramic half on a projection comparator, or by other suitable means. Dye check the two ceramic parts and inspect them for flaws (Note 1). Reject all parts showing flaws considered conducive to abnormal failures of either ceramic part.

NOTE 1—A suggested dye check procedure is described in the Appendix.

5.1.2 *Metallized Coating*—Metallize the specimen halves under identical conditions, that is, temperature, atmosphere, etc. The type of metallizing used is optional, or as mutually agreed upon between producer and consumer. Apply the metallizing coating only to the test surface A, Fig. 2, on the specimen. The method of metallizing is optional, that is, silk screen, brush, spray, roller, etc., but should be reported.

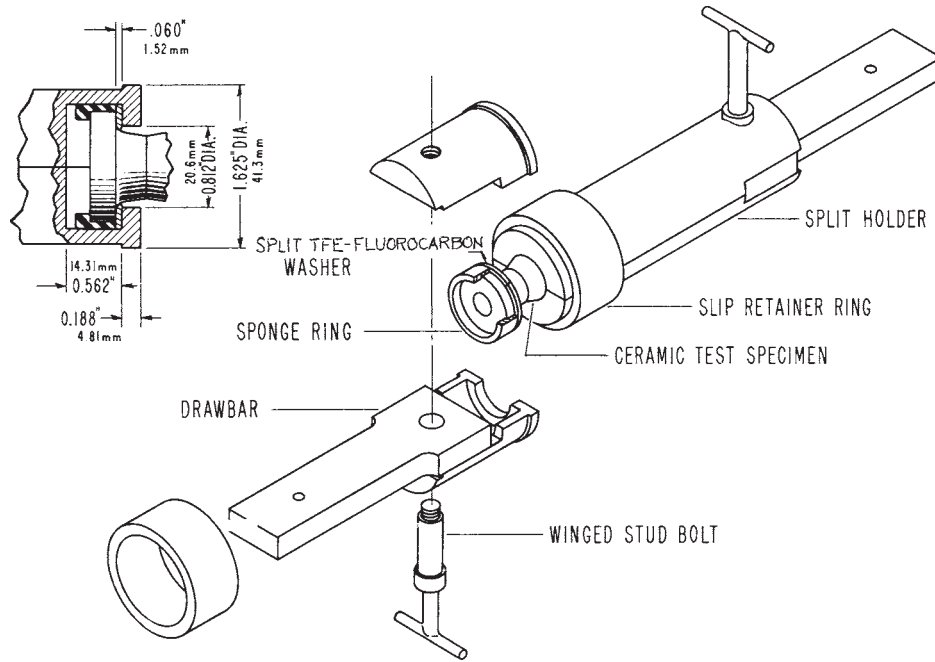
NOTE 2—A typical metallizing procedure is described in the Appendix.

5.1.3 *Assembling the Test Specimen*—Place the two mating parts in a suitable jig to achieve axial alignment of the mated ceramic halves and alignment of the metallized surfaces. Accurate alignment, which is essential to attain uniform test results, may be accomplished by jiggling with a rod of refractory material, such as ceramic or carbon (Fig. 3). Pass the rod through the assembly and then braze the specimen in a vertical position. In the test results, report the brazing material

¹ This test method is under the jurisdiction of ASTM Committee F1 on Electronics and is the direct responsibility of Subcommittee F01.03 on Metallic Materials.

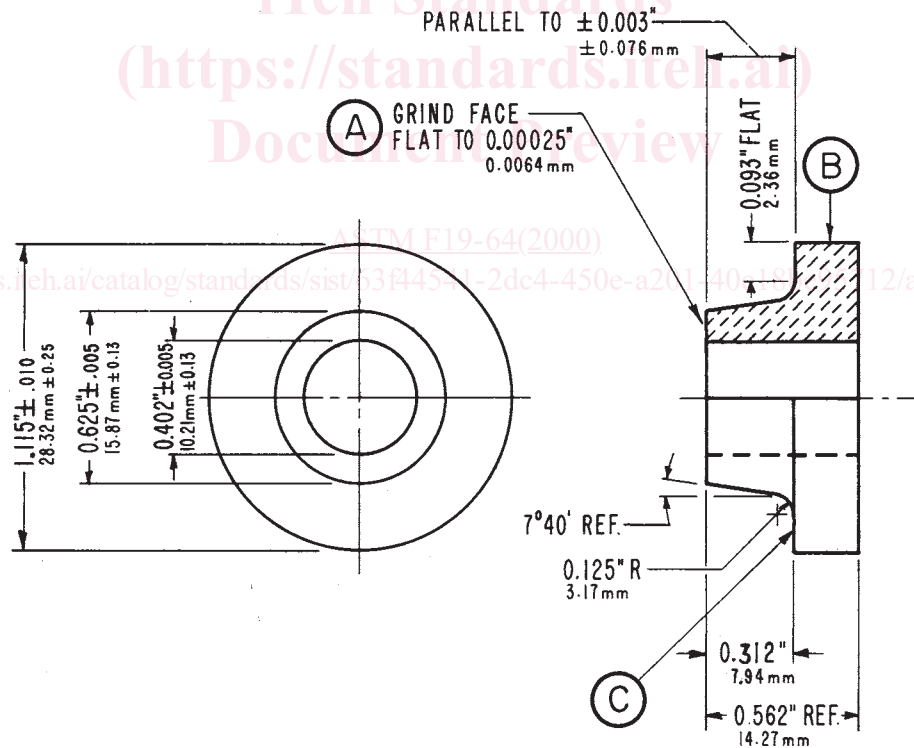
Current edition approved June 15, 1964. Published August 1964. Originally published as F 19 – 61 T. Last previous edition F 19 – 61 T.

² *Annual Book of ASTM Standards*, Vol 03.01.



NOTE 1—Tolerance on all dimensions shown, ± 0.016 in. (0.41 mm).

FIG. 1 Self Aligning Grip for Tension Test



- A—Seal surface area to be metalized.
- B—Surface inscribed with date as to ceramic batch and firing temperature.
- C—Gripping shoulder.

FIG. 2 Ceramic Half of Tension Test Specimen

used; such as copper-silver eutectic, copper-gold alloy, 35 to 65 %, etc. Use sufficient material to produce an even fillet at

the joint. Load the assembly to produce pressure on the seal during the brazing operation and report the weight of the load.