



Designation: F 1574 – 95

Standard Test Method for Compressive Strength of Gaskets at Elevated Temperatures¹

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1. Scope

1.1 This test method covers the determination of compressive strength characteristics (crush-extrusion resistance) of gasket materials at elevated temperature.

1.2 *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:*

F 104 Classification System for Nonmetallic Gasket Materials²

3. Summary of the Test Method

3.1 Specimens cut from gasket material are subjected to various stresses perpendicular to the flat surface of the specimens for a specified time at 149°C (300°F). Dimensional changes to the thickness and in the plane of the specimen while under stress and after the stress has been removed are determined. A graphical display of percent deformation plotted against the applied stress will enable determination of a compressive yield stress point beyond which the material will no longer decrease in thickness without also extruding in the planar dimensions. This condition is also revealed by physical measurements of the change in size of the specimens in the planar dimensions. Tests may be performed at various temperatures, as agreed upon between the producer and the user, to determine the relationship between temperature and compressive behavior.

4. Significance and Use

4.1 The compressive strength or crush-extrusion resistance of a gasket material is a major factor with regard to the selection of a given material for use in a particular sealing application. The significance of the test method is based, in

part, on the assumption that a material, once it has been crushed or extruded, will no longer function as effectively as a seal. This assumption can only be used as a guide, however, since exact yield or failure points are difficult to define for gasket materials (which are usually viscoelastic in nature). Two or more materials can be compared to determine differences in their resistance to compressive stress. A sample of material can be compared to an established standard or previously determined characteristics on original lots of the same material, for quality assurance purposes. See 6.2 for discussion of specimen area and geometry effects.

5. Apparatus

5.1 *Testing Machine*³, for applying a known value of compressive stresses to specimens. The machine should be capable of applying a stress of up to 517 MPa (75 000 psi) (tolerance of $\pm 5\%$), depending on the indent resistance of the steel platens and the means of reading the applied load.

5.2 *Hardened Steel Platens, Two* (Rockwell of C35 to 40 or equivalent), circular shape, larger than the specimen diameter. A suitable size is a diameter of approximately 101 mm (4 in.). The surface finish shall be RMS 0.25 to 0.50 μm (10 to 20 μm). Fig. 1 shows a suitable arrangement of steel platens and test specimen.

5.3 *Device for Applying Heat to Platens* sufficient to achieve a desired temperature at interface with gasket material specimens. An example of this device is also shown in Fig. 1, where a resistance heater surrounds the hardened platens. In some cases, the loading device itself may be heated, such as with a hot press. Any means is acceptable. The recommended elevated temperature is $149 \pm 5^\circ\text{C}$ ($300 \pm 9^\circ\text{F}$). Other temperatures may be employed as desired, or as agreed upon between the producer and the user.

5.4 *Temperature Measuring Device* for use at interface, such as a thermocouple assembly and a means for recording the voltage.

5.5 *Dies*—Cutting dies for specimens of desired size and shape. The inside faces of the dies shall be polished and be perpendicular to the plane formed by the cutting edges for a

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² *Annual Book of ASTM Standards*, Vol 09.02.

³ Examples of such equipment include Baldwin-Southwark, Instron, Tinius-Olsen, MTS, or any type of pressing device which has been properly calibrated to apply a known force.

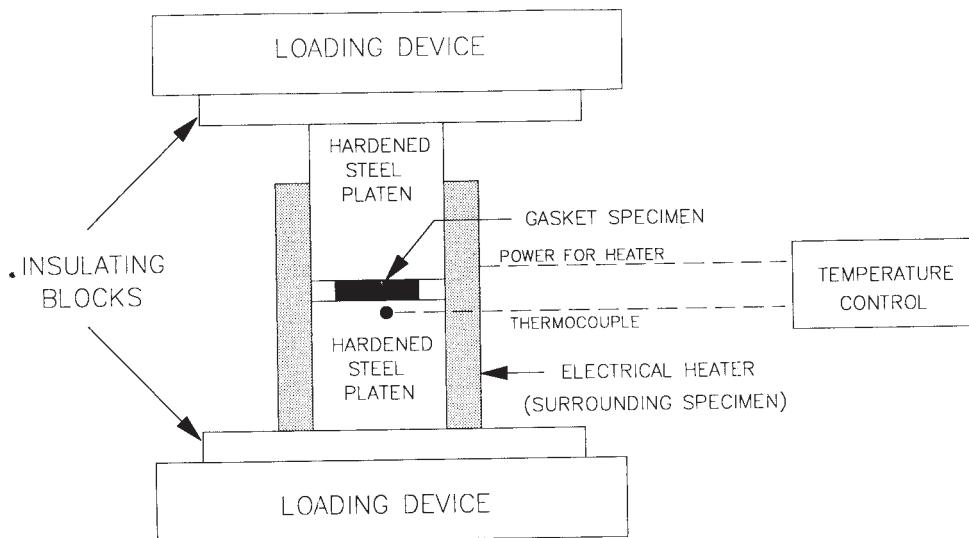


FIG. 1 Device for Testing Gasket for Compressive Strength at Elevated Temperature

depth sufficient to prevent any bevel on the edge. The die shall be sharp and free of nicks in order to prevent ragged edges on the specimen. The bore and outside diameter shall be concentric.

5.6 *Lead Pellets, Solder Plugs, or Similar Soft Metallic Particles*, approximately 1.6 mm [0.063 in.] in diameter.

5.7 *Micrometer*, for specimen thickness measurements in accordance with Classification F 104.

5.8 *Micrometer*, for measuring metallic particle thickness.

5.9 *Vernier Calipers* or other suitable device for linear dimensional measurements in the plane of the specimens, capable of reading to the nearest 0.025 mm (0.001 in.) or less.

6. Test Specimens

6.1 The gasket shall be die cut in the shape of an annulus, which may be considered indicative of an area of a gasket. The area shall be sufficiently small as to allow an applied stress of up to 517 MPa (75 000 psi) ($\pm 5\%$). Three specimens should be prepared for each applied stress at which the material is to be evaluated.

6.2 The recommended annular specimen size is 23.8 ± 0.5 -mm (0.937 ± 0.02 -in.) outside diameter by 12.7 ± 0.5 -mm (0.500 ± 0.02 -in.) inside diameter. This size will therefore have an annular width of approximately 5.5 mm (0.219 in.), where the annular width is the difference between the outer and inner radius. The area will be approximately 323 mm^2 (0.5 in.^2). If, because of loading capacity or agreement between the producer and the user, a specimen of different area is tested, it is recommended that the annulus width be kept constant at 5.5 mm (0.219 in.) so as not to introduce additional variation to the test. If comparisons between two or more laboratories are to be made, the specimen area and annulus width should be the same.

6.3 The recommended test specimen thickness may vary depending on the type of testing machine employed, type of material being evaluated, and the application to which the results are directed. The exact dependence of the test results on specimen thickness is not being addressed in this test method,

other than to acknowledge it will most likely influence the results and should therefore be a part of the report in accordance with Section 10. See Table 3 in Classification F 104 for recommended thicknesses for different types of materials.

7. Conditioning

7.1 Condition the cut specimens in accordance with the appropriate procedure in Classification F 104 with respect to the type of gasket material for which the specimens are cut.

8. Procedure

8.1 Prepare the testing machine by arranging the steel platens to accommodate the test specimens. Verify that the temperature at the platen interface equals $149 \pm 5^\circ\text{C}$ ($300 \pm 9^\circ\text{F}$), required for the test.

8.2 Determine applied stresses at which the gasket material will be evaluated. It should be representative of typical operating conditions for gaskets made of the material, and additional higher and lower stress conditions when a full range evaluation of the material is desired. Several different stresses should be selected to cover the entire range.

8.3 Measure and record the original thicknesses of each specimen, in accordance with the method described in Classification F 104 for the particular type of material. Each sample should also be weighed to the nearest 0.001 g. The density should then be calculated and recorded. The density of all samples used should be within 1 % of each other.

8.4 Measure the initial annulus width of the test specimen at four locations 90° apart, taking the average, and record this as the initial annulus width. For materials of the same composition, and cut with the same die, the measurement on one or two specimens can be considered representative of all specimens prior to testing. The annulus width can best be determined with a set of vernier calipers which can be used to measure the difference between the outer and inner radii.

8.5 Open the testing device and place a test specimen on the center of the lower platen. Place four lead pellets or solder plugs (approximately 1.6 mm (0.063 in.) in diameter) on the