



Designation: F147 – 87 (Reapproved 2017)

Standard Test Method for Flexibility of Non-Metallic Gasket Materials¹

This standard is issued under the fixed designation F147; 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.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 This test method covers the determination of the flexibility of non-metallic gasket materials. It is designed for testing specimens cut from sheet goods or from the gasket in the finished form, as supplied for commercial use. Materials normally classified as rubber compounds are excluded since they are covered in Classification **D2000**.

1.2 The values stated in SI 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.*

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

D2000 Classification System for Rubber Products in Automotive Applications

F104 Classification System for Nonmetallic Gasket Materials

F146 Test Methods for Fluid Resistance of Gasket Materials

3. Summary of Test Method

3.1 A specimen of the material is bent 180° around a mandrel of appropriate size relative to its thickness. Materials

¹ This test method is under the jurisdiction of ASTM Committee **F03** on Gaskets and is the direct responsibility of Subcommittee **F03.20** on Mechanical Test Methods.

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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.

will be tested both with and across grain on material with grain orientation. An elevated-temperature exposure conditioning is used to simulate shelf life. A low-temperature exposure conditioning is used to simulate handling at low-temperature environments. Tests may also be conducted after immersion in various fluids in accordance with Test Methods **F146**.

4. Significance and Use

4.1 This test method is designed to measure the ability of non-metallic gasket materials to withstand handling, as would be encountered before and during installation of cut gaskets.

5. Apparatus

5.1 *Steel Die*, 12.7 by 154.4 mm (0.5 by 6 in.).

5.2 *Circulating-Hot-Air Oven*, maintained at $100 \pm 1^\circ\text{C}$ ($212 \pm 2^\circ\text{F}$).

5.3 *Cold Box*, capable of maintaining $-40 \pm 1^\circ\text{C}$ ($-40 \pm 2^\circ\text{F}$).

5.4 *Mandrels*, a series with diameters ranging from 4.8 to 101.6 mm ($\frac{3}{16}$ to 4 in.).

6. Test Specimens

6.1 The specimens shall be cleanly die-cut to provide sharp edges, free of tears, nicks, or abraded particles. The minimum thickness for asbestos (Type 1) and synthetic (Type 7) fiber containing materials shall be 0.4 mm (0.016 in.) and a maximum thickness of 6.3 mm (0.250 in.). The minimum thickness for cork (Type 2) composition shall be 3.2 mm (0.125 in.) and 1.6 mm (0.062 in.) for cork-rubber materials, with a maximum thickness of 4.8 mm (0.186 in.). The minimum thickness for cellulose (Type 3) gasket materials shall be 0.127 mm (0.005 in.) and the maximum thickness shall be 1.6 mm (0.062 in.). The minimum thickness for flexible graphite (Type 5) shall be 0.127 mm (0.005 in.) and a maximum of 0.8 mm (0.031 in.).

7. Conditioning

7.1 Condition specimens in accordance with Classification System **F104**.