



Standard Specification for Lock-Strip Gaskets¹

This standard is issued under the fixed designation C 542; 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 Department of Defense.

1. Scope

1.1 This specification defines the required properties of lock-strip gaskets where resistance to sunlight, weathering, flame, oxidation, permanent deformation under load, and diminution of gripping pressure are prime essentials.

NOTE 1—The requirement of flame propagation may be waived by the architect or professional engineer when doing so does not conflict with local codes or ordinances.

1.2 This specification applies only to the “locking” compression type of gasket, sometimes referred to as the “zipper” type.

NOTE 2—Structural integrity and weather-tightness of the wall requires the sound design and installation of the entire system of which the gasket is only one component.

1.3 The values stated in inch-pound units are to be regarded as the standard.

1.4 *Test Method C 1166, as referenced in this specification, should be used to measure and describe the properties of materials, products, or assemblies in response to heat and flame under controlled laboratory conditions and should not be used to describe or appraise the fire hazard or fire risk of materials, products, or assemblies under actual fire conditions. However, results of this test may be used as elements of a fire risk assessment which takes into account all of the factors which are pertinent to an assessment of the fire hazard of a particular end use.*

1.5 The following precautionary caveat pertains only to the test method portion, Section 8, of this specification: *This standard does not purport to address 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:

C 717 Terminology of Building Seals and Sealants²

¹ This specification is under the jurisdiction of ASTM Committee C-24 on Building Seals and Sealants and is the direct responsibility of Subcommittee C24.73 on Compression Seal and Lock-Strip Gaskets.

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² *Annual Book of ASTM Standards*, Vol 04.07.

C 1166 Test Method for Flame Propagation of Dense and Cellular Elastomeric Gaskets and Accessories²

D 15 Methods of Compound and Sample Preparation for Physical Testing of Rubber Products³

D 395 Test Methods for Rubber Property—Compression Set⁴

D 412 Test Methods for Vulcanized Rubber and Thermoplastic Rubbers and Thermoplastic Elastomers—Tension⁴

D 573 Test Method for Rubber—Deterioration in an Air Oven⁴

D 624 Test Method for Tear Strength of Conventional Vulcanized Rubber and Thermoplastic Elastomers⁴

D 746 Test Method for Brittleness Temperature of Plastics and Elastomers by Impact⁵

D 1149 Test Method for Rubber Deterioration—Surface Ozone Cracking in a Chamber⁴

D 1566 Terminology Relating to Rubber⁴

D 2240 Test Method for Rubber Property—Durometer Hardness⁴

2.2 Other Standard:

Rubber Handbook, Specifications for Rubber Products⁶

3. Terminology

3.1 Definitions:

3.1.1 For the definition of the term elastomer, and other definitions of terms used in this specification, see Terminology C 717.

3.1.2 *hardness*—the resistance to indentation (Terminology D 1566).

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *bite*—the width by which the flanges of a lock-strip gasket overlap the edges of supported or supporting material.

3.2.2 *clamping pressure*—the pressure exerted by the lip of the lock-strip gasket on material installed in the channel, when the lock-strip is in place.

3.2.3 *durometer*—(1) an instrument for measuring the hardness of rubber-like materials. (2) a term used to identify the relative hardness of rubber-like materials, for example “low

³ Discontinued; see 1975 *Annual Book of ASTM Standards*, Part 37. Replaced by Practice D 3182, Test Methods D 3190, and Test Methods D 3192.

⁴ *Annual Book of ASTM Standards*, Vol 09.01.

⁵ *Annual Book of ASTM Standards*, Vol 08.01.

⁶ Available from Rubber Manufacturers Association, 444 Madison Ave., New York, NY.

durometer” (relatively soft) or “high durometer” (relatively hard).

3.2.4 *edge clearance*—the distance between the bottom of a channel of a lock-strip gasket and the edge of material installed in the channel.

3.2.5 *elongation*—increase in length (expressed as a percentage of the original length).

3.2.6 *filler strip*—see *lock-strip*, the preferred term.

3.2.7 *flange*—that part of a lock-strip gasket which extends to form one side of a channel (see Fig. 1 and Fig. 2).

3.2.8 *gasket*—any preformed deformable device designed to be placed between two adjoining parts to prevent the passage of liquid or gas between the parts.

3.2.9 *gasket, lock-strip*—a gasket in which the sealing pressure is produced internally by forcing a keyed lock-strip into a groove (referred to as the lock-strip cavity) in one face of the gasket.

3.2.9.1 *H-type*—two channel recesses, of equal or unequal sizes, one on either side of a central web (see Fig. 1).

3.2.9.2 *reglet-type*—a channel recess on the inner edge and a tongue, or spline, on the outer edge, the latter being designed for insertion in a reglet (see Fig. 2).

3.2.10 *gasket, structural*—see *gasket, lock-strip*, the preferred term.

3.2.11 *gasket, zipper*—see *gasket, lock-strip*, the preferred term.

3.2.12 *H-gasket*—see *gasket, lock-strip, H-type*.

3.2.13 *hinge*—the minimum thickness of gasket material between the channel recess and the lock-strip cavity; the plane at which bonding occurs when the flange is bent open to receive or release installed material.

3.2.14 *ladder gasket*—a lock-strip gasket in the form of a subdivided frame having one or more integrally formed intermediate cross members.

3.2.15 *lip*—the inner face of the tip of a flange on a lock-strip gasket (see Fig. 1 and Fig. 2).

3.2.16 *lip pressure*—the pressure exerted by the lip of a lock-strip gasket on material installed in the channel, when the lock-strip is in place.

3.2.17 *lip seal pressure*—the lip pressure required to effect a seal against the passage of water and air.

3.2.18 *lock-strip or locking strip*—the strip which is designed to be inserted in the lock-strip cavity to force the lips against material placed in the channel.

3.2.19 *lock-strip cavity*—the groove in the face of a lock-strip gasket, designed to receive and retain the lock-strip.

3.2.20 *reglet*—a groove or recess formed in material such as concrete or masonry to receive the spline, or tongue, of a reglet-type lock-strip gasket.

3.2.21 *reglet gasket*—see *gasket, lock-strip, reglet type*.

3.2.22 *setting block*—a short length of suitable material placed in the gasket channel to maintain proper edge clearance.

3.2.23 *spline or tongue*—that part of a reglet-type lock-strip gasket which is designed to be installed in a reglet in supporting material.

3.2.24 *web*—that part of an H-type lock-strip gasket which extends between the flanges, forming two channels.

4. Materials and Manufacture

4.1 All materials and workmanship shall be in accordance with good commercial practice.

4.2 Gaskets shall be manufactured from an ozone-resistant compound and shall not be dependent for ozone resistance on surface protection which can be removed by abrasion, detergents, or other means.

4.3 Gaskets shall be free of porosity, surface defects, and dimensional irregularities, particularly in the sealing area.

4.4 Unless otherwise specified, the material shall be black.

4.5 Lubricants used in installation, shall be as recommended by the gasket manufacturer.

5. Physical Properties

5.1 The physical properties of the gasket shall conform to the requirements specified in Table 1.

6. Dimensions and Permissible Variations

6.1 Minimum thickness of material between the locking strip cavity and the panel or rail channel shall be 0.10 in. (2.5 mm).

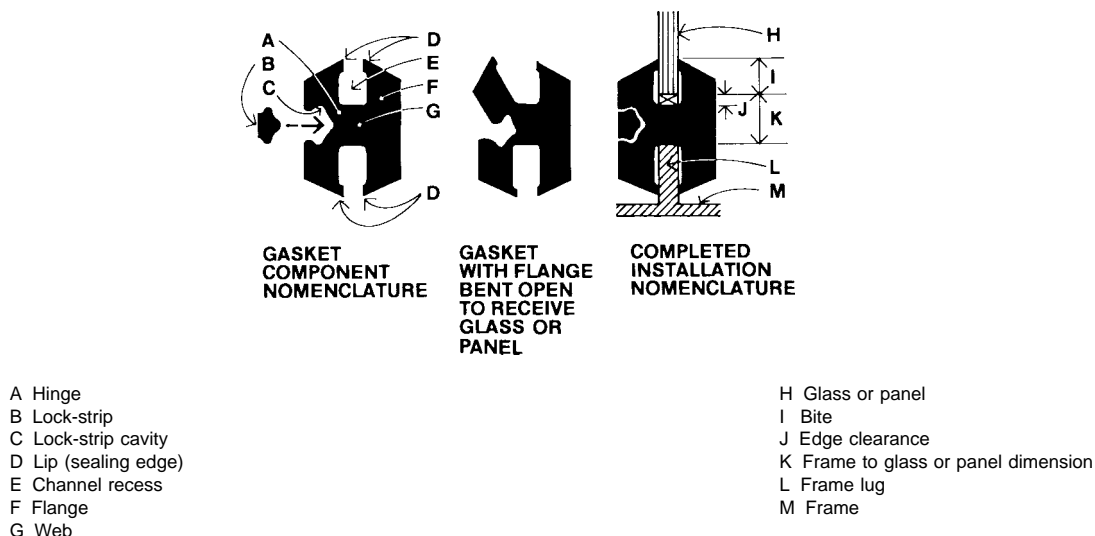
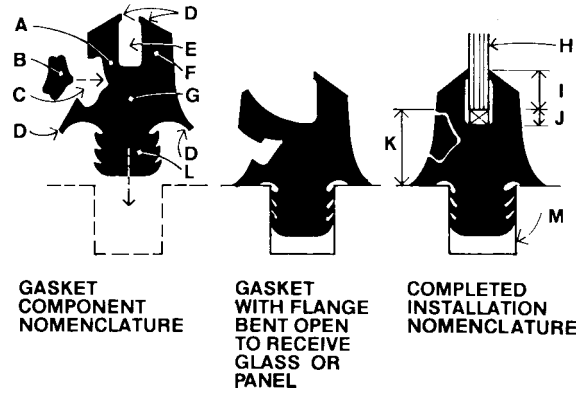


FIG. 1 Basic H-Type Gasket, Its Functional Principles and Nomenclature



- A Hinge
- B Lock-strip
- C Lock-strip cavity
- D Lip (sealing edge)
- E Channel recess
- F Flange
- G Web

- H Glass or panel
- I Bite
- J Edge clearance
- K Frame to glass or panel dimension
- L Spline
- M Reglet

FIG. 2 Reglet Type Gasket, Its Functional Principles and Nomenclature

TABLE 1 Physical Requirements and Test Methods for Gaskets

Property	Requirements	Test Method
Tensile strength, min ^A	2000 psi (14 MPa)	D 412
Elongation at rupture, min, %	175	D 412
Tear resistance, min	120 lbf/linear in. (214 N/linear cm)	D 624 (Die C)
Hardness, durometer A ^A	75 ± 5	D 2240
Compression set, max, %, 22 h at 212°F (100°C)	35	D 395 (Method B)
Brittleness temperature, min	-40°F (-40°C)	D 746
Ozone resistance, 100 mPa ozone
100 h at 40°C (104°F), 20 % elongation	no cracks @ 7× magnification	D 1149 (Specimen A)
Heat aging, 70 h at 212°F (100°C)		D 573
Change in hardness, max	0 to + 10 Durometer points	
Loss in tensile strength, max, %	15	
Loss in elongation, max, %	40	
Flame propagation ^B	100 mm (4 in.), max.	C 1166
Lip pressure ^C		
Extruded section, min	4 lbf/linear in. (7 N/linear cm)	as specified (see 8.9)
Corners, min	4 lbf/linear in. (7 N/linear cm)	

^AIf a separate stock is used for the locking strip, it may have a hardness of 80 ± 5 durometer points, and a minimum tensile strength of 1800 psi (12.5 MPa). In all other respects, it must meet these specifications.

^BThis requirement may be waived (see Note 1).

^CIn the case of molded corners with integral sealing devices, the requirement for corner lip pressure may be lowered by the architect or professional engineer.

6.2 All cross-sectioned dimensions shall have an RMA Class 2 tolerance, as specified in Table 2 unless otherwise agreed by the purchaser and seller.

7. Sampling

7.1 When proof of conformance with this specification is

required, the samples shall be taken from the finished product whenever possible.

7.2 When the thickness or shape of the finished product makes sampling, as specified in Section 7, impossible, the manufacturer shall, upon request of the purchaser at the time of

TABLE 2 Cross-Sectional Tolerances Lock-Strip Gaskets
RMA Class 2, Schedule I, Commercial^A

Dimension, in.	Tolerance, plus or minus	Dimension, in.	Dimension, mm	Tolerance, plus or minus
Over 0 to 0.10 incl	0.013	0 to 3/32	Over 0 to 2.5 incl	0.32
Over 0.10 to 0.16 incl	0.016	3/32 to 5/32	Over 2.5 to 4.0 incl	0.40
Over 0.16 to 0.25 incl	0.020	5/32 to 1/4	Over 4.0 to 6.3 incl	0.50
Over 0.25 to 0.40 incl	0.025	1/4 to 13/32	Over 6.3 to 10.0 incl	0.63
Over 0.40 to 0.63 incl	0.032	13/32 to 5/8	Over 10.0 to 16.0 incl	0.80
Over 0.63 to 1.00 incl	0.040	5/8 to 1	Over 16.0 to 25.0 incl	1.00
Over 1.00 to 1.60 incl	0.050	1 to 1 1/8	Over 25.0 to 40.0 incl	1.25
Over 1.60 to 2.50 incl	0.063	1 1/8 to 2 1/2	Over 40.0 to 63.0 incl	1.60

^ARubber Handbook, Specifications for Rubber Products, Table 12.

ordering, furnish a sufficient number of test slabs or blocks prepared in accordance with Methods D 15 for the proper performance of the required tests. The slabs or blocks shall be prepared from the compound of the same source production lot used in the gasket.

8. Test Methods

8.1 *Tensile Strength and Elongation*—Test in accordance with Test Methods D 412. Determine percentage change in tensile strength and elongation after oven aging for 70 h at 212 ± 2°F (100 ± 1°C).

8.2 *Tear Resistance*—Test in accordance with Test Method D 624 using Die C.

8.3 *Hardness*—Test in accordance with Test Method D 2240, using a Type A durometer. If size or shape of the specimen precludes testing of the finished surface, make measurements on a squarely cut end or on a flat sliced or buffed surface. Determine change in hardness after oven aging for 70 h at 212 ± 2°F (100 ± 1°C).

8.4 *Compression Set*—Test in accordance with Test Methods D 395, Method B. Hold the sample under test for 22 h at 212 ± 2°F (100 ± 1°C). Buffed specimen, taken from material 1/16 in. (1.5 mm) minimum thickness may be superimposed to a total thickness of 1/2 in. (13.0 mm).

8.5 *Brittleness Temperature*—Test in accordance with Test Method D 746.

8.6 *Ozone Resistance*—Test in accordance with Test Method D 1149 (Specimen A). Use an ozone concentration of 100 mPa, an exposure time of 40 ± 2°C (104 ± 3.6°F), and a specimen elongation of 20 %.

8.7 *Heat Aging*—Test the effects of heat aging in accordance with Test Method D 573.

8.8 *Flame Propagation*—Test Method C 1166.

8.8.1 This test is designed to differentiate the flame propagation characteristics of candidate materials used in lock-strip gaskets. It is a small-scale test which enables the specifier to exercise engineering prudence in the selection of materials. It should not be used to predict the performance of the tested material in an actual fire situation. It should not be used to predict fuel contribution, rate of flame spread, smoke generation, or the nature of the products of combustion. Test conditions are those most conducive to flame propagation and the method simulates the worst possible exposure condition. The specimen is mounted vertically. The igniting flame is hot; the fuel supply is unlimited; and the flame is not removed from the specimen throughout the test.

8.9 *Lip Pressure*:⁷

8.9.1 This test method determines the pressure exerted by the gasket on collateral material positioned within the gasket channel or channels. It simulates actual use conditions and provides a measurement of the force required to open the lips of the gasket channel to that distance representing the thickness of material for which the gasket is designed. In the case of double channel gaskets, this measurement is made with a solid material of the intended thickness in position in the channel

opposite to that being tested. Thus these measurements reflect the forces to be encountered during application.

8.9.2 *Apparatus*:

8.9.2.1 The testing machine shall be a power-driven tension-testing machine of the movable cross-head type, equipped with adjustable cross-head speed and a suitable dynamometer and indicating or recording device for measuring the applied force within ±2 %.

8.9.2.2 The grips to be used with the testing machine described in 8.9.2.1 shall be of a type similar to those shown in Fig. 3. They shall exert a uniform pressure across the gripping surface, increasing as the tension increases, so as to prevent uneven slipping.

8.9.2.3 The lip dividers used to separate the lips of the test specimen shall be made of stainless steel as shown in Fig. 4. Their length shall be at least equal to that of the test specimen.

8.9.2.4 The metal spacer to be used when testing double-channel gaskets, as shown in Fig. 3, shall be the same length as

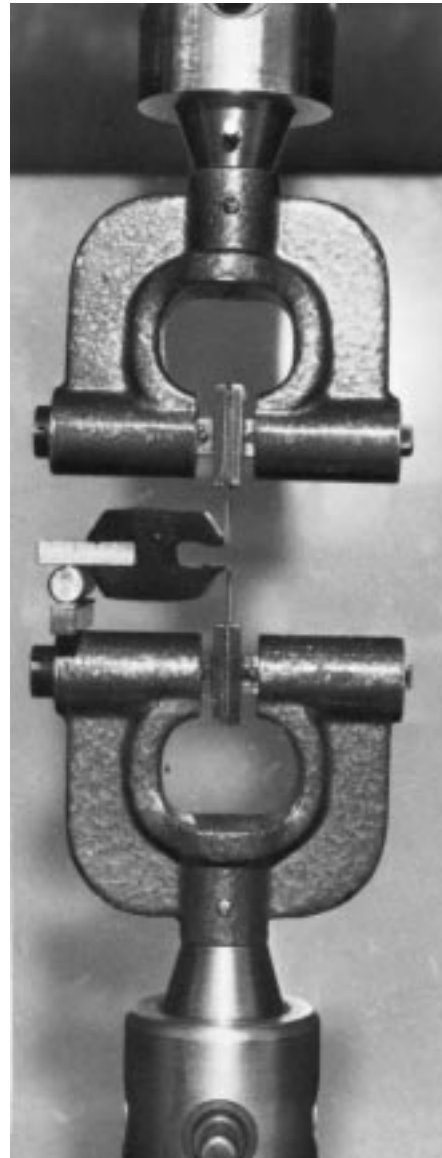


FIG. 3 Tension Tester for Lip Pressure

⁷ Supporting data are available from ASTM Headquarters. Request RR: C24-1009.

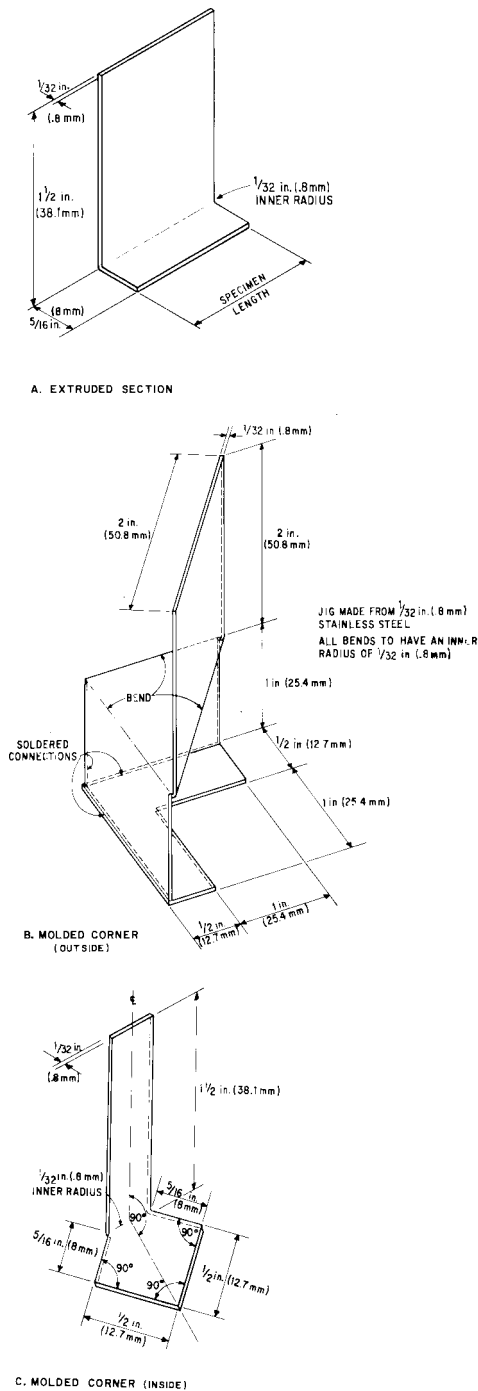


FIG. 4 Lip Dividers

the test specimen, the same thickness as the material the gasket is designed to hold, and at least 0.50 in. (13 mm) wider than the depth of the channel.

8.9.3 Test Specimen:

8.9.3.1 The extruded test specimen shall be a piece of the actual gasket at least 1 in. (25 mm) in length. A minimum of four specimens from each lot shall be tested.

8.9.4 Procedure:

8.9.4.1 Place the test specimen in the testing machine as shown in Fig. 3, ensuring that the locking strip is in place and that, if it is a double-channel-type gasket, the specified spacer is properly positioned in the channel opposite from that being tested. Provide means of supporting the test assembly so that when tension is applied to the channel lips, the assembly will remain in a horizontal position (Note 5). It is important to ensure that the lip dividers have a secure hold on the gasket lips and that they are also securely held by the grips of the machine. Conduct the test at $73.4 \pm 1.8^{\circ}\text{F}$ ($23 \pm 1^{\circ}\text{C}$).

NOTE 3—When testing single channel gaskets, the spacers obviously cannot be used. However, some means must be provided to hold the test specimen in a horizontal position during testing.

8.9.4.2 Separate the lips of the gasket channel at a uniform rate of 0.20 in. (5.1 mm)/min, until the distance between the lips is equal to the minimum thickness of the material they are designed to hold.

8.9.4.3 When the lips have been separated the specified distance, stop the testing machine and record the amount of force in lbf (or kgf) required to produce this opening.

8.9.4.4 Repeat 8.9.4.1-8.9.4.3 until all of the extruded channels of a minimum of four specimens of each type have been tested.

8.9.4.5 Calculate the lip pressure of each channel tested as follows:

$$\text{Lip pressure, lbf/linear in. (N/linear cm)} = F/L \quad (1)$$

where:


F = force required to open the lips the specified distance, lbf (or N), and
 L = length of test specimen in in. (or cm), to the nearest 0.1 in. (0.2 cm).

8.9.5 Report—The following test information shall be reported:

- 8.9.5.1 Date of test,
- 8.9.5.2 Type of testing machine used,
- 8.9.5.3 Description or numbers of the lot or lots tested,
- 8.9.5.4 The width of the filler strip to the nearest 0.001 in. (0.025 mm), and
- 8.9.5.5 Lip pressure for each gasket channel tested.

9. Keywords

9.1 compression; elastomer; elastomeric; gasket; locking; lock-strip; preformed; seal; strip; zipper

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