



# Standard Test Method for Rigidity of Polyolefin Film and Sheeting<sup>1</sup>

This standard is issued under the fixed designation D 2923; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

## 1. Scope \*

1.1 This test method describes two procedures for measuring the rigidity of polyolefin film and sheeting.

1.2 Procedure A prescribes a procedure using high-voltage static eliminators and the use of TFE-fluorocarbon<sup>2</sup>-coated plates to overcome the spurious effects of static electricity and friction.

1.3 Procedure B prescribes the use of a fine powder on uncoated plates to achieve a similar effect.

NOTE 1—Although the two procedures are designed to achieve similar effect, they may not achieve the same results.

1.4 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

1.5 *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.*

NOTE 2—There is no similar or equivalent ISO standard.

## 2. Referenced Documents

### 2.1 ASTM Standards:

D 618 Practice for Conditioning Plastics for Testing<sup>3</sup>

D 1898 Practice for Sampling of Plastics<sup>4</sup>

## 3. Terminology

### 3.1 Definitions:

3.1.1 *rigidity*—that combination of thickness and inherent stiffness of a polyolefin film or sheet which resists flexure.

## 4. Summary of Test Method

4.1 The resistance to flexure of the sample is measured by a strain gage affixed to the end of a beam, the opposite end of which flexes the sample by forcing it into a groove or slot in a

horizontal platform upon which the sample rests. An indicating microammeter, wired to the strain gage, is calibrated in grams of load sensed by the strain gage. The rigidity is read directly from the meter and expressed as grams per centimetre of sample width.

## 5. Significance and Use

5.1 The rigidity of a polyolefin web can affect its machinability, particularly on those packaging machines where a cut portion of a web is required to remain flat momentarily without being supported on all sides.

5.2 Rigidity is not a simple property since it depends on two other properties of the sample: the thickness (gage), and the stiffness which is an inherent property of the material of which the film or sheet is made. The combined effect of these two factors is the rigidity that influences performance on converting machines.

## 6. Interferences

6.1 Static electricity has considerable influence on the measured rigidity. It contributes to poor precision and accuracy, frequently giving results biased toward the high side.

6.2 To a lesser extent, precision and accuracy are adversely affected by the frictional properties of the sample, particularly when the coefficient of friction is close to 1.

6.3 The interference caused by the level of static electricity and friction of the specimen is overcome in Procedure A by electrically destaticizing the sample and using TFE-fluorocarbon-coated plates and in Procedure B by dusting the platform with a fine powder at the start of the test.

## 7. Apparatus

### 7.1 Procedure A:

7.1.1 *Handle-O-Meter*, or equivalent, with TFE-fluorocarbon-coated plates complete with calibrating and augmenting weights.<sup>5</sup>

7.1.2 *Cutting Board or Template* suitable for preparing 203 by 203-mm (8.0 by 8.0-in.) specimens.

7.1.3 *High-Voltage Static Eliminator*—<sup>6</sup>and Generator.

### 7.2 Procedure B:

<sup>1</sup> This test method is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.19 on Film and Sheeting.

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<sup>2</sup> This test method is based on the use of Teflon®, a registered trademark of E. I. duPont de Nemours & Co.

<sup>3</sup> *Annual Book of ASTM Standards*, Vol 08.01.

<sup>4</sup> Discontinued; see *1997 Annual Book of ASTM Standards*, Vol 08.01.

<sup>5</sup> The Handle-O-Meter and auxiliary equipment are available from Thwing-Albert Instrument Co., Philadelphia, PA.

<sup>6</sup> Simco Shockless Bars are suitable for this test method.

\*A Summary of Changes section appears at the end of this standard.

7.2.1 *Handle-O-Meter*, or equivalent, complete with calibrating and augmenting weights.

7.2.2 *Cutting Board or Template* suitable for preparing 203 by 203-mm (8.0 by 8.0-in.) specimens.

7.2.3 *Fine-Particle Silica*, starch, or equivalent, having an approximate nominal particle size of 50  $\mu\text{m}$  or less.

## 8. Sampling

8.1 The material shall be sampled in accordance with Practice D 1898.

## 9. Test Specimens

9.1 Using a cutting board or template, cut a minimum of three 203 by 203-mm (8.0 by 8.0-in.) test specimens with the edges parallel to the machine and transverse directions of the film. Mark the specimens in the machine direction and transverse direction.

9.2 The specimens shall be conditioned in accordance with Procedure A of Practice D 618.

## 10. Calibration

10.1 Calibrate the Handle-O-Meter in accordance with the instructions described in Appendix X1.

10.2 Calibrate other equipment in accordance with the manufacturer's instructions.

## 11. Procedure

### 11.1 *Method A:*

11.1.1 Turn on the static eliminator.

11.1.2 Just before placing a test specimen on the instrument, slowly draw the specimen several times over the bar of the static eliminator.

11.1.3 With the penetrator beam raised above the slot, lay the test specimen on the platform of the instrument so that the length of the slot is at right angles to the machine direction of the specimen. For example, in measuring machine direction rigidity, the bottom edge of the penetrator beam, which is parallel to the slot length, will contact the film in a line perpendicular to the machine direction of the film.

11.1.4 Position the specimen on the platform so that one-third of the specimen is to the right of the slot.

11.1.5 With the specimen in the correct position and the toggle switch on RUN, press the momentary contact switch to start the test cycle.

11.1.6 Read the maximum value in grams (to the nearest 0.5 g) indicated on the meter.

NOTE 3—Readings in excess of the maximum meter value require use of an augmenting weight in accordance with the manufacturer's instructions. The proper reading with a 40-g augmenting weight is 40 g plus the maximum meter value.

NOTE 4—If the total reading is in excess of the maximum value plus augmenting weights, reduce the specimen width (measured distance along

the slot) until an on-scale reading is obtained.

11.1.7 Upon completion of the cycle, rotate the specimen 90° and repeat 11.1.1 through 11.1.6 for measurement in the transverse direction.

11.1.8 Turn the specimen over so that the opposite side of the film is being forced into the opening and repeat 11.1.1 through 11.1.7.

11.1.9 Repeat 11.1.1 through 11.1.8 for the remaining specimens.

### 11.2 *Method B:*

11.2.1 Place a light "dust" layer of powder on the Handle-O-Meter platform.

11.2.2 Follow 11.1.3 to 11.1.9.

## 12. Calculation

12.1 Calculate the average Handle-O-Meter rigidity in the machine direction and transverse direction for each side as follows:

$$R_{MDN} = (r/n) / W \text{ or } R_{TDN} = (r/n) / W \quad (1)$$

where:

$R_{MDN}$  = average machine direction rigidity for Side N, g/cm.

$R_{TDN}$  = average transverse direction rigidity for Side N, g/cm.

$N$  = 1 or 2

$r$  = sum of meter readings for specimens tested, g,

$n$  = number of specimens tested, and

$W$  = specimen width along the slot, cm.

12.1.1 If the  $R_{MD}$  (or  $R_{TD}$ ) for Side 1 is equal to  $R_{MD}$  (or  $R_{TD}$ ) for Side 2, the average of the two may be taken as the  $R_{MD}$  (or  $R_{TD}$ ) of the specimen. The two  $R_{MD}$ 's (or  $R_{TD}$ 's) shall be judged equal if they agree with each other within  $\pm 10\%$ , the error limits of the test.

## 13. Report

13.1 Report the following information:

13.1.1 The average Handle-O-Meter rigidity in each direction,

13.1.2 Specimen width,

13.1.3 Procedure used,

13.1.4 Direction tested, and

13.1.5 Sample thickness.

NOTE 5—If the sides are different, report values for each side tested.

## 14. Precision and Bias

14.1 The precision and bias statement is currently being prepared.

## 15. Keywords

15.1 film; olefins; rigidity; sheet

APPENDIX

(Nonmandatory Information)

X1. CALIBRATION

X1.1 The instrument must be located on a solid, vibration-free, level surface. Refer to Fig. X1.1 for the placement and names of the components of the Handle-O-Meter.

X1.2 The opening through which the penetrator beam travels must be checked each time the instrument is used or once a week if the machine is in continual use. For routine work, a 5-mm (0.197-in.) opening will be used.

X1.2.1 Place the centering gage shown in Fig. X1.2 in the opening with the penetrator beam resting in the upper slot of the centering gage. Fig. X1.3

X1.2.2 The gage should fit snugly in the opening (no more than 0.025-mm (0.01-in.) clearance on each side).

X1.2.3 Adjust the opening if the gage is loose by releasing the set screws holding the plate and sliding both sides until contact is made with the centering gage. Tighten the set screws holding the plates and remove the gage.

X1.3 The following steps should be followed in consecutive order to check the calibration of the Handle-O-Meter. Refer to Fig. X1.1 for placement of control.

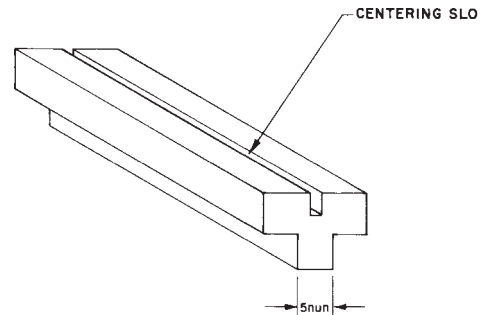
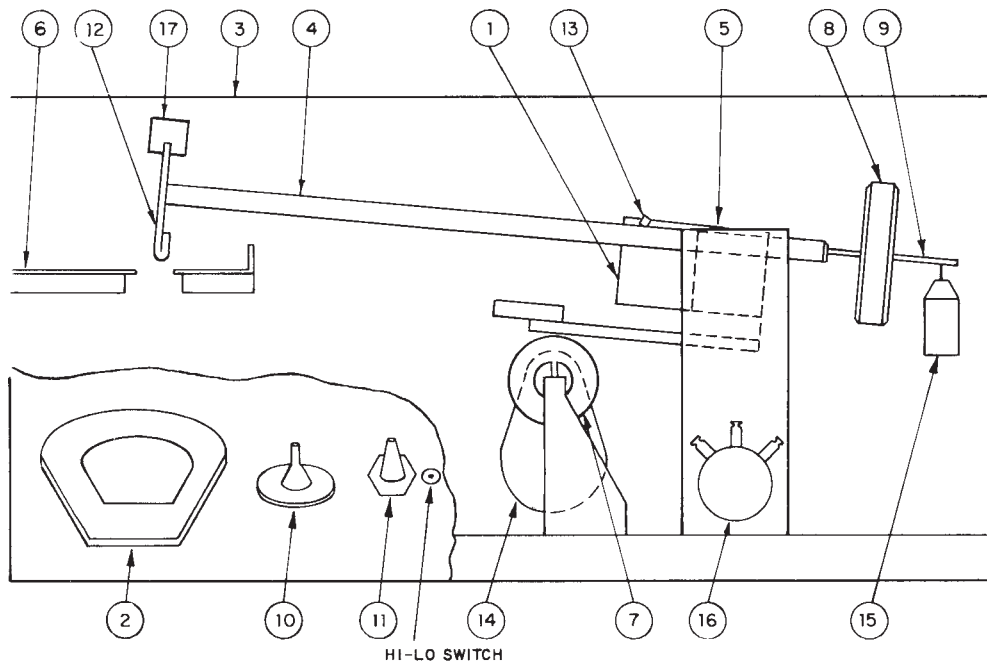


FIG. X1.2 Centering Gage

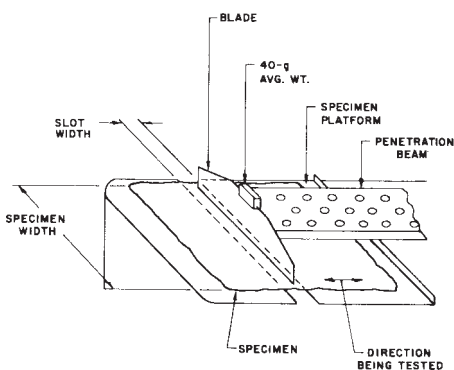
X1.3.1 Put toggle switch in RUN position and press the momentary contact switch. The blade of the penetration beam will move into the slot to a depth governed by the position of the load cell anchor nut.

X1.3.2 Adjust the load cell anchor nut so that the blade will penetrate to a depth of 7.94 mm (0.3125 in.) below the surface of the platform. Turning off the nut clockwise will increase the depth setting and vice versa.



- |                                  |                              |
|----------------------------------|------------------------------|
| 1. Load cell                     | 10. Toggle switch            |
| 2. Microammeter                  | 11. Momentary toggle switch  |
| 3. Case                          | 12. Blade                    |
| 4. Penetrator beam               | 13. Load-cell anchor nut     |
| 5. Load-cell bracket             | 14. Motor                    |
| 6. Specimen platform             | 15. Range calibrating weight |
| 7. Cam                           | 16. Range rheostat           |
| 8. Penetrator beam counterweight | 17. 40-g augmenting weight   |
| 9. Counterweight                 |                              |

FIG. X1.1 Handle-O-Meter Components



**FIG. X1.3 Specimen in Place for Test**

X1.3.3 With the toggle switch in the OFF position, adjust the microammeter to the mechanical zero with the zero adjust screw on the front of the microammeter.

X1.3.4 With the toggle switch in either the RUN or OFF position, the microammeter should read zero. Adjust the penetration beam counterweight until a zero reading occurs.

X1.3.5 Place the toggle switch in the RUN position and press the momentary contact switch until the cycle starts. When the blade reaches the level of the specimen platform, change the toggle switch to the TEST position. The microammeter should continue to read zero. This was a test to determine if the microammeter reads zero when the blade first touches the specimen.

X1.3.6 Reach through the side door on the right side of the case and hang the range calibrating weight in the groove of the counterweight stand.

X1.3.7 With the weight in this position, the reading on the microammeter should be 40.0 g. If it is not correct, reach through the side door and adjust the range rheostat until the reading is 40.0 g.

NOTE X1.1—Handle-O-Meter of a capacity double that of No. 211-2 is available. This is accomplished by furnishing an electric load cell of higher capacity, a switch shunted across a meter for a 2 to 1 ratio of indications. There is a HI-LO switch on the face of the instrument and with the LO position the instrument operates the same as No. 211-2 and readings are taken directly from the meter; however, with the switch in the HI position, all meter readings must be doubled to reflect the shunting offset and therefore can be used for stiffer or higher capacity tests.

X1.3.8 Remove the calibrating weight and check that the zero reading is indicated on the microammeter. If the reading has shifted, repeat X1.3.5 to and including X1.3.7.

X1.3.9 Place the 40-g augmenting weight on the blade, while the 40.0-g range calibrating weight is hung on the counterweight stud. The microammeter reading should now be zero, since each weight is counteracting the other.

X1.3.10 Remove both weights before going on to the operating procedures.

X1.3.11 The actual weight of the calibration weight and the augmenting weight must be checked once a month and weigh  $40 \pm 0.1$  g.

## SUMMARY OF CHANGES

This section identifies the location of selected changes to this test method. For the convenience of the user, Committee D20 has highlighted those changes that may impact the use of this test method. This section may also include descriptions of the changes or reasons for the changes, or both.

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(1) Corrected placement of specimen on platform.

(2) Clarified equation in Calculations.

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