



Designation: C1335 – 23

Standard Test Method for Measuring Non-Fibrous Content of Man-Made Rock and Slag Mineral Fiber Insulation¹

This standard is issued under the fixed designation C1335; 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 a procedure for determining the non-fibrous content (shot) of man-made rock and slag mineral fiber insulation. The procedure covers a dry sieve analysis method to distinguish between fiberized and non-fiberized (shot) portions of a specimen of man-made rock and slag mineral fiber insulation specimen.

1.2 This test method does not apply to rock or slag materials containing any components other than rock and slag mineral fiber, oil, and organic thermal setting binders. Products containing other types of fibers, inorganic binders, or refractory clays are excluded.

NOTE 1—Industrial oils such as mineral or synthetic can be used to enhance the hydrophobic qualities and dust suppression.

1.3 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.4 *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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.5 *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

C168 Terminology Relating to Thermal Insulation

¹ This test method is under the jurisdiction of ASTM Committee C16 on Thermal Insulation and is the direct responsibility of Subcommittee C16.32 on Mechanical Properties.

Current edition approved May 1, 2023. Published May 2023. Originally approved in 1996. Last previous edition approved in 2017 as C1335 – 12 (2017). DOI: 10.1520/C1335-23.

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.

C390 Practice for Sampling and Acceptance of Thermal Insulation Lots

E11 Specification for Woven Wire Test Sieve Cloth and Test Sieves

E178 Practice for Dealing With Outlying Observations

E691 Practice for Conducting an Interlaboratory Study to Determine the Precision of a Test Method

3. Terminology

3.1 *Definitions*—Terminology C168 shall be considered as applying to the terms used in this test method.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *shot*—material that cannot be brushed or mechanically shaken through a No. 100 (150 μ m) sieve.

4. Significance and Use

4.1 Inorganic fibrous thermal insulation can contain varying amounts of non-fibrous material. Non-fibrous material does not contribute to the insulating value of the insulation and therefore a procedure for determining that amount is desirable. Several specifications refer to shot content and percent (%) retained on various screen sizes determined by this test method.

5. Apparatus

5.1 *Furnace*, capable of maintaining $1100 \pm 10^\circ\text{F}$ ($593 \pm 5.6^\circ\text{C}$) for rock and slag wool.

5.2 *U.S.A. Standard Sieve Shaker Machine*.

5.3 *Balance Scale*, capable of weighing to an accuracy of 0.00035 oz (0.01 g).

5.4 *Sieves*—Three 8 in. (203 mm) diameter U.S.A. Standard Sieves. Nos. 20 (850 μ m), 50 (300 μ m), and 100 (150 μ m) nested in order with bottom receiver pan. All sieve design and construction shall be in accordance with Specification E11.

5.5 *Brush*—Approximately 1 in. (25 mm) diameter plastic bristle brush, and approximately 1 in. (25 mm) wide soft paint brush.

5.6 *Crucible Weighing Dish*, tared.

5.7 *Stoppers*, rubber, No. 12 or 13.

5.8 *Cork Borer*, approximately 0.8 in. (20 mm) diameter.

6. Sampling and Preparation of Test Specimen

6.1 For the purposes of standard tests, sampling shall be in accordance with Practice **C390** and Practice **E178** with a minimum of three specimens per lot to be tested.

6.1.1 *Specimen*—This test method requires approximately a 0.35 oz (10 g) specimen.

6.2 Specimen Preparation:

6.2.1 Obtain a representative specimen utilizing a 0.8 in. (20 mm) cork borer for blanket or board and random specimens for loose fill. Fire the specimen in a tared dish at $1100 \pm 10^\circ\text{F}$ ($593 \pm 5.6^\circ\text{C}$) for 15 min. Remove tared dish with specimen and allow to cool for approximately 20 min.

6.2.2 Weigh the crucible weighing dish and fiber on balance scale to the nearest 0.00035 oz (0.01 g), subtract tare dish weight, noting the mass of specimen after firing as *WT*.

7. Procedures

7.1 Shot-Fiber Separation Procedure A (Includes Shaker Machine):

7.1.1 Assemble a nest of sieves (Nos. 20, 50, and 100) starting with a cover and the coarsest sieve on the top and a pan on the bottom.

7.1.2 Place the specimen on the top sieve with receiver(s) in place.

7.1.3 With the plastic bristle brush or rubber stopper, brush to break-up the specimen through the No. 20 sieve.

7.1.4 Deposit one rubber stopper on each sieve screen before final assembly.

7.1.5 Place the entire nested sieve-assembly with specimen on the motor-driven testing sieve shaker and operate the automatic shaker-hammer for 20 min or until all fibrous materials are passed through to the pan.

7.1.6 Carefully remove all material retained on each sieve and weigh individually (without sieve and stopper) on the balance pan.

7.1.6.1 Weigh the material retained on each sieve to the nearest 0.00035 oz (0.01 g).

7.2 Shot-Fiber Separation Procedure B (Manual Operation):

7.2.1 Place the specimen on the top sieve with receivers in place.

7.2.2 With the plastic bristle brush or rubber stopper, brush the specimen through the No. 20 and No. 50 sieves.

7.2.3 With the soft paint brush, brush the specimen through the No. 100 sieve. On all sieves, be certain that all fibrous material is brushed through.

7.2.4 Carefully remove all material retained on each sieve and weigh individually (without sieve) on the balance pan.

7.2.4.1 Weigh the material retained on each sieve to the nearest 0.00035 oz (0.01 g).

8. Calculation

8.1 Calculate the percentage of non-fibrous material for one specimen retained on the No. 20 sieve, No. 50 sieve, and No. 100 sieve, respectively.

8.1.1 Add the No. 20 sieve plus No. 50 sieve plus No. 100 sieve masses together noting as *WP* and calculate as follows:

$$WC = \frac{WP(100)}{WT}$$

where:

WC = % mass of non-fibrous material for one specimen,

WP = mass of material on all sieves, and

WT = mass of specimen after firing/before separation.

8.2 Adding the total percentages of all *WC*(s) (minimum of three specimens/tests) and dividing by the number of *WC*(s) equals the average total percent of shot (shot content).

9. Report

9.1 Report the following information:

9.1.1 A description of the material being tested, including specimen source (company name and manufacturing location), color, production code, or any other information that will help identify specimen.

9.2 The non-fibrous content method used.

9.3 The percentage by weight retained for each sieve size, as well as the total percent non-fibrous material (shot content) to the nearest tenth of a percent. The total percentage shot content will be reported for the average of at least three separate specimen results in accordance with **6.1**.

9.4 The temperature at which the material was fired and the time the U.S.A. Standard Sieve Shaker Machine was operated.

10. Precision and Bias

10.1 *Precision*—The test results for representation of performance of the material will depend on the variability of the material, plus sampling and specimen preparation.

10.1.1 The results were evaluated using Practice **E691**. Repeatability and reproducibility are herein defined as 2.8 times the corresponding standard deviation to obtain a 95% confidence level. Repeatability is the variability between test results within each laboratory, and reproducibility is the variability between test results from different laboratories.

10.1.2 *Interlaboratory tests*—The results of interlaboratory tests conducted in 2003 for Total Shot using procedures “A” and “B” are listed in **Table 1** and **Table 2**. The interlaboratory tests were conducted in accordance with Practice **E691** with exception of the minimum number of test laboratories were not met. The study involved five different materials (specimens) from five different manufacturing facilities with three replicates of each specimen.

10.2 *Bias*—No statement of bias can be made for this test method since there is no standard reference material.

TABLE 1 Precision for Procedure A

5 Specimens 4 Laboratories 3 Replicates		Repeatability		Reproducibility	
Material	Average total % shot	r	% of average	R	% of average
C	15.543	4.213	27.11	4.213	27.11
E	15.704	4.615	29.39	4.615	29.39
B	20.254	0.974	4.81	2.312	11.42
A	22.412	2.521	11.25	3.550	15.84
D	30.952	4.272	13.80	4.272	13.80