



Standard Test Method for Measuring Trueness and Squareness of Rigid Block and Board Thermal Insulation¹

This standard is issued under the fixed designation C 550; 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 test method covers locations for measuring the trueness and squareness of rigid block/board thermal insulation. This test method does not purport to address the variability in board thickness. Thickness is addressed in other ASTM standards.

1.2 The values stated in inch-pound 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.*

2. Referenced Documents

2.1 ASTM Standards:

C 168 Terminology Relating to Thermal Insulation²

C 390 Criteria for Sampling and Acceptance of Preformed Thermal Insulation Lots²

3. Terminology

3.1 **Definitions**—For definitions of terms used in this test method, refer to Terminology C 168.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 **squareness**—the lack of deviation from a right angle.

3.2.2 **trueness**—the lack of deviation from straightness or flatness.

4. Significance and Use

4.1 Insulating blocks or boards that are not true or square may not fit properly. Extra labor may be required to obtain proper fit and may affect the product performance as well as the appearance of the finished installation.

4.2 This test method provides terminology and describes locations for obtaining consistent measurements of trueness and squareness of blocks and boards.

5. Apparatus

5.1 **Straightedge**, minimum length equal to the maximum dimension of the block or board with a maximum out of trueness of ± 0.003 in./ft (± 0.25 mm/m).

5.2 **Rigid Ruler**, graduated to 0.03 in. (1.0 mm) or finer.

5.3 **Square**, shall have sides at least as long as the longest side of the block. If the longest side of the block is greater than 20 in. (500 mm), then the length of the square must be at least 20 in. (500 mm). The maximum deviation from 90° shall be no more than ± 3 min (± 0.9 mrad).

5.4 **Flat Surface**, large enough to accommodate the block or board in its full length and width dimensions, with a trueness of ± 0.008 in./ft (± 0.65 mm/m).

5.5 **Feeler Gage Set**, from 0.001 to 0.020 in. (0.03 to 0.50 mm).

5.6 **Tape Measure**, steel, long enough to measure the longest side of the block, graduated in 0.031 in. (1 mm) intervals.

6. Test Specimens

6.1 The test specimens shall be of commercial size.

6.2 The number of test specimens shall be defined by the appropriate product specification.

6.3 When the appropriate product specification does not cover sampling, samples shall be selected in accordance with Criteria C 390 inspection requirements.

7. Procedure

7.1 Edge Trueness in the x/y Direction:

7.1.1 With the straightedge next to the block/board on the flat surface, concave deviation from true shall be determined at the point of maximum deviation (see Fig. 1 A and B).

7.1.2 For convex deviation from true, the deviation shall be measured by equalizing the distance between the straightedge and the block/board at both corners of the block/board (see Fig. 1 A and B).

7.1.3 Deviation from true shall be determined to the nearest 0.03 in. (1.0 mm).

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 April 10, 2003. Published June 2003. Originally published in 1964. Last previous edition C 550 – 95 (2001).

² *Annual Book of ASTM Standards*, Vol 04.06.

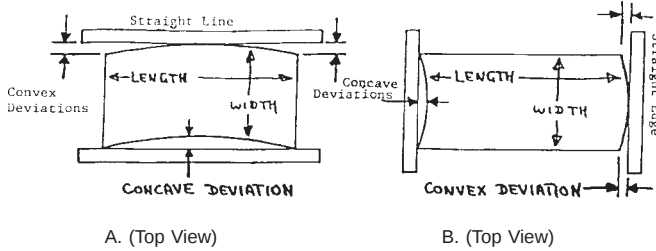


FIG. 1 Edge Trueness

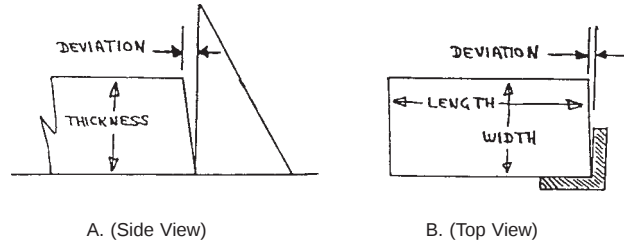
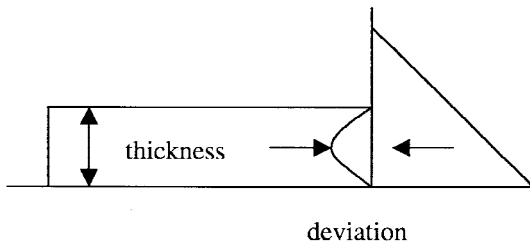


FIG. 2 Squareness

C. Concave Deviation



D. Convex Deviation

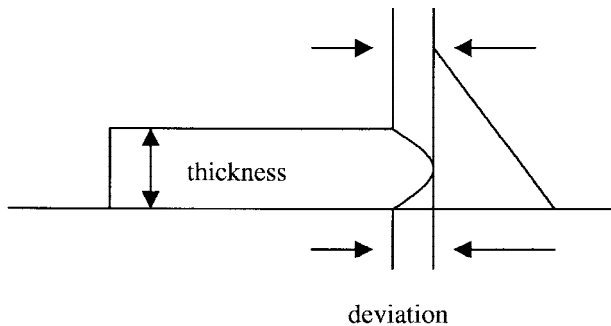


FIG. 1 Edge Trueness (continued)

7.2 Edge Trueness in the z (Thickness) Direction:

7.2.1 With the square next to the block/board as shown in Fig. 1C, the concave deviation from true shall be determined at the point of maximum deviation.

7.2.2 For convex deviation from true, the deviation shall be measured by equalizing the distance between the square and the block/board at both surfaces of the block/board as shown in Fig. 1D.

7.2.3 Deviation from true shall be determined to the nearest 0.03 in. (0.8 mm).

7.3 Edge Squareness:

7.3.1 For edge squareness, the block/board shall be placed on the flat surface such that the deviation from square is apparent as in Fig. 2A.

7.3.2 With the square resting on the flat surface, determine the deviation from square to the nearest 0.03 in. (1.0 mm) for all four edges at the point of maximum deviation.

7.4 Corner Squareness:

7.4.1 For corner squareness, the square shall be placed against the long edge as in Fig. 2B.

7.4.2 Determine the deviation from square for all four corners at 20 in. (500 mm) from the edge to the nearest 0.03 in. (1.0 mm). If the block/board is less than 20 in. (500 mm) in width, determine the deviation at full width and report the deviation at full width.

7.5 Face Trueness:

7.5.1 For edge face trueness, place the block/board on the flat surface with the concave face down as in Fig. 3A.

7.5.2 Without additional force or load to the block/board, determine the edge face trueness at the point of maximum deviation to the nearest 0.03 in. (1.0 mm).

7.5.3 For end face trueness, place the block/board on the flat surface with the concave face down as in Fig. 3B.

7.5.4 Determine end face trueness as in 7.5.2.

8. Report

8.1 Report the following information:

8.1.1 Product type and nominal dimensions.

8.1.2 Manufacturer and date of manufacture or lot number.

8.1.3 Date of testing.

8.1.4 Temperature during testing.

8.2 Trueness:

8.2.1 Maximum deviation from edge and end trueness in inches (or millimetres).

8.2.2 Maximum deviation from edge trueness across the width in inches (or millimetres).

8.2.3 Maximum deviation from end trueness across the width in inches (or millimetres).

8.3 Squareness:

8.3.1 Maximum deviation from edge squareness in inches (or millimetres).

8.3.2 Maximum deviation from corner squareness in inches (or millimetres).

8.4 Face Trueness:

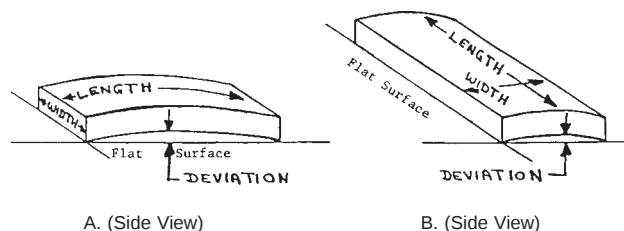


FIG. 3 Face Trueness

8.4.1 Maximum deviation from flatness along the length of the block/board in inches (or millimetres).

8.4.2 Maximum deviation from flatness across the width of the block/board in inches (or millimetres).

9. Precision and Bias

9.1 The precision and bias for the procedure in this test method for measuring the trueness and squareness of rigid block thermal insulation are being determined.

9.2 The precision of this test method is not known because inter-laboratory data are not available. This test method may not be suitable for use in specifications or in case of disputed results as long as these data are not available.

10. Keywords

10.1 flatness; rigid thermal insulation; squareness; trueness

ASTM International takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this standard. Users of this standard are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.

This standard is subject to revision at any time by the responsible technical committee and must be reviewed every five years and if not revised, either reapproved or withdrawn. Your comments are invited either for revision of this standard or for additional standards and should be addressed to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. If you feel that your comments have not received a fair hearing you should make your views known to the ASTM Committee on Standards, at the address shown below.

This standard is copyrighted by ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959, United States. Individual reprints (single or multiple copies) of this standard may be obtained by contacting ASTM at the above address or at 610-832-9585 (phone), 610-832-9555 (fax), or service@astm.org (e-mail); or through the ASTM website (www.astm.org).