



Standard Specification for Preformed Flexible Elastomeric Cellular Thermal Insulation in Sheet and Tubular Form¹

This standard is issued under the fixed designation C534/C534M; 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 specification covers preformed flexible elastomeric cellular thermal insulation in sheet and tubular form. Grade 1 covers materials to be used on commercial or industrial systems with operating temperatures from -183 to 104°C [-297 to 220°F], Grade 2 covers material used on industrial systems with operating temperatures from -183 to 175°C [-297 to 350°F], and Grade 3 covers material used on industrial systems with operating temperatures from -183 to 120°C [-297 to 250°F] where halogens are not permitted.

1.2 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

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:²

- C168 Terminology Relating to Thermal Insulation
- C177 Test Method for Steady-State Heat Flux Measurements and Thermal Transmission Properties by Means of the Guarded-Hot-Plate Apparatus
- C390 Practice for Sampling and Acceptance of Thermal Insulation Lots
- C335 Test Method for Steady-State Heat Transfer Properties of Pipe Insulation

¹ This specification is under the jurisdiction of ASTM Committee C16 on Thermal Insulation and is the direct responsibility of Subcommittee C16.22 on Organic and Nonhomogeneous Inorganic Thermal Insulations.

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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.

- C411 Test Method for Hot-Surface Performance of High-Temperature Thermal Insulation
- C447 Practice for Estimating the Maximum Use Temperature of Thermal Insulations
- C518 Test Method for Steady-State Thermal Transmission Properties by Means of the Heat Flow Meter Apparatus
- C534 Specification for Preformed Flexible Elastomeric Cellular Thermal Insulation in Sheet and Tubular Form
- C585 Practice for Inner and Outer Diameters of Thermal Insulation for Nominal Sizes of Pipe and Tubing
- C692 Test Method for Evaluating the Influence of Thermal Insulations on External Stress Corrosion Cracking Tendency of Austenitic Stainless Steel
- C795 Specification for Thermal Insulation for Use in Contact with Austenitic Stainless Steel
- C871 Test Methods for Chemical Analysis of Thermal Insulation Materials for Leachable Chloride, Fluoride, Silicate, and Sodium Ions
- C1045 Practice for Calculating Thermal Transmission Properties Under Steady-State Conditions
- C1058 Practice for Selecting Temperatures for Evaluating and Reporting Thermal Properties of Thermal Insulation
- C1114 Test Method for Steady-State Thermal Transmission Properties by Means of the Thin-Heater Apparatus
- C1304 Test Method for Assessing the Odor Emission of Thermal Insulation Materials
- C1427 Specification for Extruded Preformed Flexible Cellular Polyolefin Thermal Insulation in Sheet and Tubular Form
- C1763 Test Method for Water Absorption by Immersion of Thermal Insulation Materials
- D883 Terminology Relating to Plastics
- D1622 Test Method for Apparent Density of Rigid Cellular Plastics
- D1667 Specification for Flexible Cellular Materials—Poly (Vinyl Chloride) Foam (Closed-Cell)
- E84 Test Method for Surface Burning Characteristics of Building Materials
- E96/E96M Test Methods for Water Vapor Transmission of Materials
- E177 Practice for Use of the Terms Precision and Bias in ASTM Test Methods

TABLE 1 Physical Requirements for Type I (Tubular) and Type II (Sheet)^A

Property	Unit	Grade 1	Grade 2 (higher temperature)	Grade 3 (non-chloride/non-fluoride containing)
Apparent thermal conductivity, max., at a mean temperature of:	W/m·K [Btu·in./h·ft ² ·°F]			
-150°C [-238°F]		0.023[0.16]	0.023 [0.16]	0.023 [0.16]
-100°C [-148°F]		0.028 [0.18]	0.028 [0.18]	0.028 [0.18]
-29°C [-20°F]		0.036 [0.25]	0.036 [0.25]	0.036 [0.25]
-18°C [0°F]		0.038 [0.26]	0.038 [0.26]	0.038 [0.26]
24°C [75°F]		0.040 [0.28]	0.043 [0.30]	0.040 [0.28]
50°C [120°F]		0.043 [0.30]	0.047 [0.32]	0.043 [0.30]
86°C [150°F]		0.045 [0.31]	0.049 [0.34]	0.045 [0.31]
150°C [300°F]		NA	0.061 [0.42]	NA
Water absorption, max.	% by volume	0.20	0.20	0.20
Water-vapor permeability, max.	g/Pa·s·m [perm-in.]	1.44 × 10 ⁻¹⁰ [0.10]	4.32 × 10 ⁻¹⁰ [0.30]	4.32 × 10 ⁻¹⁰ [0.30]
Linear shrinkage, max after soak at maximum use temperature	% linear change	7.0 %	7.0 %	7.0 %

^A Table 1 describes two types of flexible elastomeric cellular thermal insulation. The values stated in Table 1 may not always be appropriate as design values. For specific design recommendations using a particular product and for supporting documentation, consult the manufacturer.

E456 Terminology Relating to Quality and Statistics

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

E2231 Practice for Specimen Preparation and Mounting of Pipe and Duct Insulation Materials to Assess Surface Burning Characteristics

2.2 Other Standards:³

CAN/ULC-S102 Standard Method of Test for Surface Burning Characteristics of Building Materials and Assemblies

3. Terminology

3.1 *Definitions*—Terms used in this specification are defined in Terminology C168 and in Terminology D883.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *cellular elastomeric foam*—a closed-cell foam made of natural or synthetic rubber, or a mixture of the two, and containing other polymers, other chemicals, or both, which is permitted to be modified by organic or inorganic additives. These foams have properties similar to those of vulcanized rubber, namely, (1) the ability to be converted from a thermoplastic to a thermosetting state by cross-linking (vulcanization) and (2) the ability to recover substantially its original shape when strained or elongated.

3.2.2 *flexible cellular*—a flexible cellular organic polymeric material shall not rupture within 60 s when a specimen 200 by 25 by 25 mm [8 by 1 by 1 in.] is bent around a 25-mm [1-in.] diameter mandrel at a uniform rate of one lap in 5 s in the form of a helix at a temperature between 18 and 29°C [65 and 85°F].

NOTE 1—The flexibility of these materials may decrease at lower temperatures.

4. Classification

4.1 The types are designated below:

4.1.1 *Type I*—Tubular.

Grade 1 Use temperature -183 to 104°C [-297 to 220°F].

Grade 2 Use temperature -183 to 175°C [-297 to 350°F].

Grade 3 Use temperature -183 to 120°C [-297 to 250°F].

4.1.2 *Type II*—Sheet.

Grade 1 Use temperature -183 to 104°C [-297 to 220°F].

Grade 2 Use temperature -183 to 175°C [-297 to 350°F].

Grade 3 Use temperature -183 to 104°C [-297 to 220°F].

4.2 Grade 1 is flexible elastomeric material for use on typical commercial systems.

4.3 Grade 2 is a high temperature flexible elastomeric material.

4.4 Grade 3 is an elastomeric material that does not contain any leachable chlorides, fluorides or polyvinyl chloride.

NOTE 2—Continuous long-term exposure at or above the upper use temperature may cause degradation in the form of loss of flexibility

5. Materials

5.1 These products shall be made of a homogeneous blend of natural or synthetic rubber that is permitted to be modified with various thermoplastic or thermosetting resins, plasticizers, modifiers, antioxidants, curatives, blowing agents and other additives. These products are thermoset and are not thermoplastic in nature.

5.2 These products are expanded with chemical blowing agents that decompose with the application of heat. The gases produced by these blowing agents are similar to those found in the atmosphere and thus the diffusion rate is not significant. These gases do not change over time and the thermal conductivity of the insulation is stable over time.

5.3 Flexible, elastomeric, cellular thermal insulations shall be of uniform core density and have closed cells. Even though these insulation materials are permitted to have a smooth skin surface on one or both sides, they are to be considered homogeneous for the purposes of determining thermal performance.

6. Physical Requirements

6.1 *Qualification Requirements*—Thermal conductivity, water vapor permeability and dimensional stability physical properties listed in Table 1, are defined as qualification requirements (refer to Practice C390, Section 5, Classification of Requirements and Section 6, Acceptance for Qualification Requirements).

³ Available from Underwriters Laboratories (UL), 2600 N.W. Lake Rd., Camas, WA 98607-8542, <http://www.ul.com>.



TABLE 2 Dimensional Tolerances, mm [in.]

	Tolerances
Type I—Tubular Material	
Inside diameter, mm [in.]:	
Up to 10 [3/8], incl.	+2.5 [3/32], -0
13 [1/2] to 22 [7/8], incl.	+3 [1/8], -0
25 [1] to 38 [1 1/2], incl.	+5 [3/16], -0
41 [1 5/8] to 60 [2 3/8], incl.	+6 [1/4], -0
Over 60 [2 3/8]	+10 [3/8], -0
Wall thicknesses, mm [in.]:	
Up to 19 [3/4], incl.	+3 [1/8], -0
19 and over [3/4]	+5 [3/16], -0
Length, mm [in.]	+75 [3], -25 [1]
Type II—Sheet Material	
Thickness, mm [in.]:	
Up to 13 [1/2], incl.	± 2 [± 1/16]
Over 13 [1/2]	± 3 [± 3/32]
Length and width, mm [in.]:	
Up to 150 [6], incl.	± 6 [± 1/4]
Over 150 [6] to 300 [12], incl.	± 10 [± 3/8]
Over 300 [12]	± 3%

6.2 Inspection Requirements:

6.2.1 The requirements for water absorption listed in Table 1 is defined as an inspection requirement (refer to Practice C390, Section 5, Classification of Requirements, and Section 7, Acceptance for Inspection Requirements).

6.2.2 All dimensional requirements shall be as described in Section 6 and Table 2.

6.2.3 All workmanship, finish and appearance requirements shall be as described in Section 9.

6.2.4 Compliance with inspection requirements shall be in accordance with Practice C390.

6.3 Both Type I and Type II insulations shall conform to the physical property requirements listed in Table 1.

6.4 The material shall be free of objectionable odors at all temperatures within the recommended use range when tested according to Test Method C1304.

6.5 *Surface Burning Characteristics*—The material shall be tested to assess its surface burning characteristics, at the thickness supplied, in accordance with Test Method E84 with mounting according to Practice E2231. The results shall be reported. In Canada, use Test Method CAN/ULC-S102 and report the results.

6.5.1 This test method does not always define the hazard potentially presented by preformed flexible elastomeric cellular thermal insulation under actual fire conditions. It is retained for reference in this standard as test data are required by some codes.

6.5.2 Preformed flexible cellular elastomeric thermal insulation is an organic material and is combustible. Do not expose it to flames or other ignition sources. In some applications, the fire test response characteristics of the material are addressed through requirements established by the appropriate governing documents.

6.6 *Leachable Chloride/Fluoride Content*—Grade 3 shall be below the detectable limit of the test procedure used for leachable chlorides or fluorides when tested according to Test Method C871.

7. Standard Shapes, Sizes and Dimensions

7.1 *Type I*—Tubular materials are manufactured in 1.83 m [72 in.] standard lengths, as well as in continuous lengths. Insulation is manufactured for diameters up to 200 mm [8 in. nominal pipe size (NPS)] with wall thickness up to 50 mm [2 in.].

7.2 *Type II*—Sheet material is manufactured in thicknesses up to 50 mm [2 in.]. Sheets are manufactured in sizes up to 1.22 m [48 in.] in width and in continuous lengths. Other sizes are available upon request. Individual dimensions shall conform to those specified by the manufacturer.

7.3 Actual dimensions shall be agreed upon between the manufacturer and the purchaser. The procedure section and the pipe and tubing diameter information of Practice C585 is beneficial in determining these actual dimensions.

7.4 The insulation tolerances shall conform to Table 2.

8. Surface

8.1 *Type I*—All surfaces (except ends and slits that are mechanically cut) shall have natural skins.

8.2 *Type II*—Sheet material is manufactured either with skin on one side or with skin on two sides. The surface shall be at the manufacturer's option, unless otherwise specified.

9. Workmanship, Finish, and Appearance

9.1 The insulation shall be free of visual defects that will adversely affect the service quality. For example, blisters, blow holes and tears when occurring to an excessive degree shall be judged to adversely affect the service quality of the material.

10. Sampling

10.1 The insulation shall be sampled in accordance with Practice C390. Details shall be agreed upon between the buyer and seller.

10.2 When possible, the insulation shall be tested in the form supplied. However, when Type I does not lend itself to testing or to making of test specimens because of its shape, standard test sheets shall be prepared from tubular material having equivalent physical characteristics to Type I (see 10.1 and 11.1.2).

11. Test Methods

11.1 Test Conditions:

11.1.1 The physical requirements enumerated in this specification shall be determined in accordance with the following test methods:

11.1.2 When standard test sheets are required for tubular material, they shall be prepared by longitudinally slitting the tubular specimens along one wall thickness, opening and laying the sample flat.

11.1.3 These products are produced with either skin on one side or skin on both sides. Testing shall be done in the final end use form.

11.2 Apparent Thermal Conductivity:

11.2.1 *Type I*—Choose from Test Methods **C177**, **C518**, **C1114** or **C335** in conjunction with Practice **C1045**. Use standard test sheet for **C177**, **C518** or **C1114**.

NOTE 3—Test Method **C335** may be used for below ambient conditions. The authors of this reference state, “the regression curves for sheet and pipe insulation agree with 1.5 and 2.5 % at mean temperatures of 25 and 10°C, respectively. The measured apparent thermal conductivities of both types of materials are well below the maxima allowed by **C534**.⁴

11.2.2 *Type II*—Choose from Test Methods **C177**, **C518** or **C1114** in conjunction with Practice **C1045**.

11.2.3 Tests shall be conducted with a temperature differential of $25 \pm 5^\circ\text{C}$ [$50 \pm 10^\circ\text{F}$] between the hot and cold plates of the testing apparatus in accordance with Table 3 of Practice **C1058**.

11.2.4 The mean apparent thermal conductivity for four samples of the material tested shall not be greater than the value stated in Table 1. The apparent thermal conductivity of an individual specimen shall not greater than 105 % of the value stated in Table 1.

11.3 Water Vapor Permeability:

11.3.1 *Type I and Type II*—Use standard test sheets for Type I. For Type II, use the desiccant method of Test Methods **E96/E96M** with the following conditions:

11.3.2 The desiccant method shall be performed at a 50 ± 5 % relative humidity at $23 \pm 2^\circ\text{C}$ [$73 \pm 4^\circ\text{F}$],

11.3.3 The preferred specimen thickness shall be 13 mm [$\frac{1}{2}$ in.] with skin on at least one side,

11.3.4 The specimen shall be tested so that the skin surface is toward the high humidity, and

11.3.5 All samples shall be run a minimum of three weeks (504 h) or longer to ensure that equilibrium conditions have been reached.

11.4 Linear Shrinkage:

11.4.1 *Scope*—This test method covers the evaluation of linear shrinkage of flexible cellular elastomeric thermal insulation.

11.4.2 *Significance and Use*—This test method provides a relatively simple and short-term evaluation of in-use performance with regard to linear shrinkage. This standard does not address ID or Wall dimensional changes.

11.4.3 Test at the upper temperature limit of the material as defined in the Scope and test at -101°C [-150°F].

11.4.4 Apparatus:

11.4.4.1 *Oven*—An air-circulating oven equipped with a temperature control to maintain a temperature of $175 \pm 1.7^\circ\text{C}$ [$350 \pm 3^\circ\text{F}$].

11.4.4.2 *Freezer*—An air-circulating freezer equipped with a temperature control to maintain a temperature of $-101 \pm 1.7^\circ\text{C}$ [$-150 \pm 3^\circ\text{F}$].

11.4.4.3 *Steel Rule*—Graduated in millimeters [inches] capable of measuring to increments of 1.0 mm [0.05 in.]

11.4.5 Test Specimens:

11.4.5.1 *Type I*—Three 300 mm [12 in.] long specimens from each of the test samples.

11.4.5.2 *Type II*—Three specimens 300 by 75 mm [12 by 3 in.] cut from each of the test samples.

11.4.6 Procedure:

11.4.6.1 At each of two points 250 mm [10 in.] apart on the centerline of each specimen, place a benchmark.

11.4.6.2 Condition the specimen 24 h at a temperature of $23 \pm 2^\circ\text{C}$ [$73.4 \pm 3.6^\circ\text{F}$] and measure the distance between the Benchmarks to the nearest 1.0 mm [0.05 in.].

11.4.6.3 Place the specimens in the oven or freezer operating at the specified temperature. After 7 days remove the specimens from the oven, or freezer and condition for at least 2 h at $23^\circ\text{C} \pm 2^\circ\text{C}$ [$73.4^\circ\text{F} \pm 3.6^\circ\text{F}$] and re-measure.

11.4.7 *Report*—Report the average linear shrinkage of the three specimens from each lot as a change in length. Between the two benchmarks expressed as a percentage of the length measured originally.

11.4.8 *Precision and Bias Statement for Linear Shrinkage – Definitions and Additional Information:*

11.4.8.1 For precise definitions of statistical terms, refer to Terminology **E456**.

11.4.8.2 For more information on calculation methods relating to the use of statistical procedures, refer to Practices **E177** and **E691**.

11.4.8.3 Standard **C534** and Standard **C1427** have identical linear shrinkage tests. This study included the three material types called out in standard **C534** and the one type called out in standard **C1427**. Samples consisted of 7 different specimens (varying by size and manufacturer) for each of the 4 types called out. The specimens were tested according to their classified grade maximum temperature use. The testing was conducted at 6 laboratories. The results from all samples were used to develop the repeatability and reproducibility values. This was a very broad study considering the range of specimens used. It was felt that the data could be improved by working with the laboratories in their test procedures and data reporting.⁵

11.4.8.4 *Repeatability Statement*—The repeatability standard deviation has been determined to be 0.41 with a mean value of 4.23 %. for all materials tested. This corresponds to a 95 % repeatability value of ± 26.9 %.

11.4.8.5 *Reproducibility Statement*—The reproducibility standard deviation has been determined to be 0.79 with a mean value of 4.23 % for all materials tested. This corresponds to a 95 % reproducibility value of ± 52.2 %.

11.5 Water Absorption:

11.5.1 *Type I and Type II*—Test Method **C1763** Method B. Submersion time shall be 2 h.

11.5.2 The specimens shall have a skin on at least one surface.

11.6 Maximum Use Temperature:

11.6.1 When tested in accordance with 11.6.2, the insulation shall not soften, collapse, melt or drip during hot surface

⁴ Wiles, K.E., Desjarlais, A.O., Stovall, T.K., McElroy, D.L., Childes, K.W., and Miller, W.A., “A Pipe Insulation Test Apparatus for Use Below Room Temperature,” *Insulation Materials: Testing and Applications, 4th Volume, ASTM STP 1426*, A.O. Desjarlais and R.R. Zarr, Eds. ASTM International, West Conshohocken, PA, 2002.

⁵ Supporting data have been filed at ASTM International Headquarters and may be obtained by requesting Research Report RR:C16-1029.

exposure. No cracking, delamination, or warping, shall be evident upon post-test inspection.

11.6.2 Type I and Type II shall be tested in accordance with Test Method **C411** and the hot surface performance of Practice **C447** at the insulation's maximum use temperature and at the manufacturer's maximum recommended thickness. The surface shall be at the intended temperature when testing begins. No special requirements for heat-up shall be specified by the manufacturer.

11.7 *Leachable Chloride / Fluoride Content:*

11.7.1 *Type I and Type II*—Test Method **C871**.

12. Inspection

12.1 Inspection of the material shall be made at the point of shipment or at the point of delivery, as agreed upon between the purchaser and the supplier.

13. Rejection

13.1 Material that fails to conform to the requirements of this specification is subject to be rejected. Rejection shall be reported to the manufacturer or supplier promptly and in writing.

14. Packaging and Marking

14.1 Unless otherwise agreed or specified between the purchaser and the supplier, material under this specification shall be packaged in the manufacturer's standard commercial containers.

14.2 Unless otherwise specified, shipping containers shall be marked with the name and designation of the manufacturer, grade of material, type, size, thickness and quantity of the material in the container.

15. Keywords

15.1 cellular elastomeric; cellular materials; elastomeric; flexibility; linear shrinkage; preformed thermal insulation; sheet material; thermal insulating materials—pipe

APPENDIX

(Nonmandatory Information)

X1. SUPPLEMENTARY INFORMATION

X1.1 *Water-Soluble Chlorides and Use on Austenitic Stainless Steel:*

X1.1.1 Water-soluble or leachable chlorides and other halides are normally present in trace quantities in most commercial elastomeric thermal insulation materials. In the presence of moisture and oxygen, as well as under certain service conditions, these ions are capable of initiating stress corrosion cracking in susceptible metal alloys such as austenitic stainless steels. There are not sufficient leachable inhibitors present in the elastomeric insulation to prevent the effects by stress corrosion on austenitic stainless steel.

X1.1.2 It is not practical to indicate a safe upper limit for the chloride content since water may leach out soluble chlorides from a substantial volume of insulation material or the environment and allow these chlorides to be concentrated at the metal-insulation interface.

X1.1.3 Austenitic stainless steel may be used in a variety of operating systems. Extra care should be taken if these insulation materials are to be used on austenitic stainless steel systems that operate above 54°C [130°F]. Consult the manufacturer for specific recommendations.

X1.1.4 Consult the manufacturer for specific test results of leachable chlorides if this material is to be used in a containment area of a nuclear power facility.

X1.1.5 For more information, refer to Specification **C795** and Test Methods **C692** and **C871**.

X1.2 *Water Absorption/Water Vapor Infiltration*—Due to the closed-cell structure of these materials, they do not absorb significant amounts of liquid water. They may, however, be affected by water vapor permeability. Great care should be taken during installation of any system operating below ambient temperature to ensure that all seams and joints are properly sealed. Particular attention should be paid to water vapor permeability during the material selection process as this will have an impact on the long-term performance of the insulation system.

X1.3 *Density*—The density of this type of insulation material is not a performance property. For reference purposes only, densities of these types of products typically range from 48 to 136 kg/m³ [3.0 to 8.5 lb/ft³] when measured in accordance with Test Method **D1622** or Specification **D1667**.

X1.4 *Preventing Corrosion of Copper Lines*—Useful information for preventing corrosion of insulated copper lines may be found ASTM STP 1320.⁶

X1.5 *Flexibility*—Flexibility at the time and temperature of installation is a key parameter for these materials. Flexibility at temperatures outside of normal installation temperatures

⁶ Hough, P. A., and Lenox, R. S., "Preventing Environmentally-Caused Corrosion of Insulated Copper Lines," R.S. Graves and R.R. Zarr, Eds., *Insulation Materials: Testing and Applications: Third Volume, ASTM STP 1320*, ASTM International, 1997 pp.473–484.



change for a variety of reasons

X1.5.1 Flexibility at lower temperatures may decrease but is reversible as the temperature increases. Continuous long-term exposure at or above the upper use temperature may cause non-reversible loss of flexibility due to continued crosslinking of these materials.

X1.6 *Hot Surface Performance Characteristics*—When this type of material is used on hot applications, two phenomena occur which should be considered when selecting the material for an application.

X1.6.1 Initially the product will expand as the gas in the cells expands. Care should be taken when applying a jacket

material to allow for this expansion. This phenomenon is reversible as the temperature declines.

X1.6.2 Heat will cause the elastomeric insulation to harden. As the temperature approaches the stated high temperature limit, the process occurs faster. This hardening will not negatively effect the thermal performance of the product. The hardening will be most noticeable closer to the heat source. This effect is based on time and temperature. Sufficient thickness should be applied to ensure the effect does not propagate to the surface.

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