



# Standard Test Method for Carbon Black-Void Volume at Mean Pressure<sup>1</sup>

This standard is issued under the fixed designation D7854; 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 covers a procedure to measure a carbon black structure property known as Void Volume at mean pressure. Compressed void volumes are obtained by measuring the compressed volume of a weighed sample in a cylindrical chamber as a function of pressure exerted by a movable piston. A profile of void volume as a function of pressure provides a means to assess carbon black structure at varying levels of density and aggregate reduction.

1.2 The values stated in SI units are to be regarded as standard. No other units of measurement are included in this 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:<sup>2</sup>

[D1799 Practice for Carbon Black—Sampling Packaged Shipments](#)

[D1900 Practice for Carbon Black—Sampling Bulk Shipments](#)

[D2414 Test Method for Carbon Black—Oil Absorption Number \(OAN\)](#)

[D3493 Test Method for Carbon Black—Oil Absorption Number of Compressed Sample \(COAN\)](#)

[D4483 Practice for Evaluating Precision for Test Method Standards in the Rubber and Carbon Black Manufacturing Industries](#)

<sup>1</sup> This test method is under the jurisdiction of ASTM Committee D24 on Carbon Black and is the direct responsibility of Subcommittee D24.11 on Carbon Black Structure.

Current edition approved Jan. 1, 2016. Published February 2016. Originally approved in 2013. Last previous edition approved in 2015 as D7854 – 15. DOI: 10.1520/D7854-16.

<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

## 3. Terminology

3.1 Refer to Sections 4 and 9 for a more complete understanding of the use of these terms in this test method.

### 3.2 Definitions of Terms Specific to This Standard:

3.2.1 *applied pressure, n*—the pressure exerted on a sample mass by a movable piston in a cylindrical chamber, where the load cell or force measuring system is in contact with the movable piston.

3.2.2 *compressed volume (carbon black), n*—the apparent volume that a specified mass of carbon black occupies when it is contained in a specified cylindrical chamber and subjected to a single uniaxial compression at a specified pressure by means of a movable piston.

3.2.3 *geometric mean pressure, n*—the geometric mean of the applied and transmitted pressures at a specific void volume; the geometric mean pressure is defined in Eq 1:

$$\text{Geometric Mean } P_{GM} = (P_a \times P_t)^{0.5} \quad (1)$$

3.2.4 *theoretical volume (carbon black), n*—the volume that a specific mass of carbon black would occupy if there were no void space within the carbon black, and is given by the ratio of mass to skeletal density, where the skeletal density is determined by an accepted test method.

3.2.5 *transmitted pressure, n*—the resulting pressure transmitted through a sample in a cylindrical chamber, where the load cell or force measuring system is in contact with the sample opposite the movable piston, typically via a stationary second piston.

3.2.6 *void volume (carbon black), n*—a measure of the intra-aggregate void space or occluded volume within the primary structure of carbon black, characterized by the irregularity and non-sphericity of carbon black aggregate particles, and expressed as the difference (compressed volume minus theoretical volume) as a function of specified uniaxial compression pressure, and normalized to 100 g mass.

3.2.6.1 *Discussion*—Carbon blacks resist packing, compression, and fracture due to aggregate irregularities and entanglements, size distribution, and aggregate strength resulting from particle to-particle necks within aggregate branches. Compressed void volume is also affected by reacting forces to the cylinder wall and the piston tip, which in turn depend on factors including sample shape (that is, the ratio of sample height to cylinder diameter) or interfacial area, which can

influence the uniformity of the compaction density. Since compressed void volumes as a function of applied pressure are known to be specific to sample mass and cylinder geometry, such a compressed void volume is biased due to error in the applied pressure relationship. The applied pressure bias is a result of force losses due to friction between the sample and cylinder wall interface. There is presently no known technique to properly correct applied pressure measurements for an instrument design using a single load cell since friction coefficients ( $\mu$ ) are not constant for carbon black products or applied pressures. For this reason, the most useful technique for comparing compressed void volumes is based on a numerical technique known as mean compaction force or mean pressure. The mean pressure technique requires an instrument design consisting of two load cells to enable the measurement of compressed void volume as a function of applied and transmitted force or pressure. Such a design allows the computation of void volumes at mean pressures, a method which has been demonstrated to minimize the effects of carbon black sample mass and cylinder geometry.

#### 4. Summary of Test Method

4.1 The measured compressed volume (apparent volume) of a weighed dry test sample is obtained in a void volume instrument as a function of specified pressure. The instrument consists of an apparatus which can apply uniaxial compression to a test sample in a cylindrical sample chamber where applied and transmitted forces (or pressures) are measured. The compressed void volume is obtained by subtracting the theoretical volume from the apparent volume, then expressing the result unitized to 100 g mass, as a function of specified mean pressure.

#### 5. Significance and Use

5.1 The void volume of a carbon black expressed as a function of geometric mean pressure, VVGM, is a carbon black structure property. Structure is a generic term that is a function of the shape irregularity and deviation from sphericity of carbon black aggregates. The greater a carbon black resists compression by having substantial aggregate irregularity and non-sphericity, the greater the compressed volume and void volume. Also, the more that a carbon black resists compression, the greater the energy required to compress the sample per unit void volume.

5.2 Structure is a property that strongly influences the physical properties developed in carbon black-elastomer compounds for use in tires, mechanical rubber goods, and other manufactured rubber products. Structure measurements by OAN (Test Method [D2414](#)) and COAN (Test Method [D3493](#)), are based on oil absorption.

#### 6. Apparatus

6.1 *Analytical Balance*, or equivalent, capable of a weighing sensitivity of 0.1 mg.

6.2 *Gravity Convection Drying, Oven*, capable of maintaining  $125 \pm 5^\circ\text{C}$ .

6.3 *Weighing Dish, Camel Hair or Similar Brush*, to be used for weighing and transferring samples.

6.4 *Void Volume Instrument*, to be used to measure the compressed volume (apparent volume) of carbon blacks as a function of applied pressure, from which the void volume is calculated at specified intervals of geometric mean pressure (that is, geometric mean of applied and transmitted pressures). The void volume instrument or device shall conform to the following generic specifications and be capable of operating as outlined in Section 9.

6.4.1 The instrument shall have a rigid framework that contains a cylindrical sample chamber. Hysteresis and elasticity in the framework under the range of applied forces should be accounted for in the displacement measurement.

6.4.2 The cylinder shall have a uniform diameter.

6.4.3 By means of a suitable mechanism with sufficient power for the compression forces as required for testing, the piston shall be capable of being moved to compress the sample. A device to record the movement of the piston and measure displacement shall be provided. The compressed volume of any sample is determined by the distance from the end of the piston to the end of the cylinder; this is designated as a “height” in the calculations discussed in Section 10. The sample height and cylinder diameter are used to calculate an apparent sample volume.

6.4.4 Load cells or other suitable force or pressure measurement devices are used to measure the applied and transmitted pressures.

6.4.5 The instrument design shall provide continuous compression at a controlled and constant rate thereby allowing continuous measurements of apparent volume and pressures at specified data intervals.

6.4.6 The instrument uses an electric motor or hydraulic fluid to operate a linear actuator attached to a piston.

6.4.7 The instrument incorporates two load cells to directly measure applied and transmitted forces or pressures.

6.4.8 The instrument design shall provide a means to save and store the compression data up to a minimum of 100 MPa geometric mean pressure for subsequent analysis.

#### 7. Sampling

7.1 Samples of candidate carbon blacks shall be taken in accordance with Practice [D1799](#) or [D1900](#).

#### 8. Calibration

8.1 *Calibration*—The manufacturer will typically calibrate the instrument measurement systems. The height measurement system is typically calibrated using a physical standard such as a calibrated steel plug. Load cells are typically calibrated or verified using a reference load cell. Traceability is recommended for all calibration devices. Follow the manufacturer’s recommendations for calibration frequency and verification.

#### 9. Procedure

9.1 *Sample Preparation*—Dry an adequate sample of the carbon black for at least 1 h in a gravity-convection oven set at  $125 \pm 5^\circ\text{C}$ , in an open container of suitable dimensions, so that the depth of black is no more than 10 mm. Cool to room temperature in a desiccator before use.

**TABLE 1 Precision Parameters for D7854, Void Volume at 50 MPa Mean Pressure<sup>A</sup>**

Material	Number of Labs	Unit m <sup>3</sup> /kg Mean Level	Sr	r	(r)	SR	R	(R)
SRB 8D	18	24.9	0.20	<b>0.58</b>	1.55	0.29	<b>0.83</b>	2.19
SRB 8A	21	46.5	0.25	<b>0.70</b>	1.25	0.39	<b>1.10</b>	2.15
SRB 8E	20	50.5	0.22	<b>0.63</b>	2.32	0.38	<b>1.09</b>	3.33
SRB 8F	18	61.4	0.34	<b>0.95</b>	1.86	0.48	<b>1.35</b>	2.07
SRB 8B	21	70.7	0.31	<b>0.89</b>	1.26	0.56	<b>1.58</b>	2.24
SRB 8C	23	73.9	0.49	<b>1.38</b>	1.51	0.54	<b>1.53</b>	2.37
	Average Pooled	54.7	0.30	<b>0.86</b>	1.63	0.44	<b>1.25</b>	2.39

<sup>A</sup> Precision is based on absolute void volume measurements (non-normalized data) from an inter-laboratory precision program conducted in 2014.

9.2 Weigh a mass of sample specified by the instrument manufacturer, typically 1.000, 2.000 g, or 4.000 g to the nearest 0.1 mg.

9.3 Define the analysis conditions to include void volume measurements at 50.0, 75.0, and 100.0 MPa geometric mean pressure with a compression rate of 1 to 2 MPa/s. In practice this is accomplished by defining a scan from the lowest detection pressure to at least 100 MPa geometric mean pressure.

9.4 Transfer the weighed sample to the instrument. Brush the sample pan and funnel to ensure the entire sample is introduced into the cylinder. Proceed with the test.

9.5 At the end of the test insure residual carbon black has been removed from the cylinder and piston tips.

## 10. Void Volume Calculations

10.1 The void volume (VV) is calculated from the apparent compressed volume as follows. The apparent compressed volume of the sample is evaluated by Eq 2.

$$V_A = h \times 3.1416 D^2/4 \quad (2)$$

where:

$V_A$  = the apparent compressed volume of the carbon black sample, cm<sup>3</sup>, from a single uniaxial compression.

$h$  = the “height” of the compressed carbon black in the cylinder, cm, and

$D$  = the diameter of the cylinder, cm.

10.2 The theoretical volume of the carbon black is evaluated by Eq 3.

$$V_T = m/d_{CB} \quad (3)$$

where:

$V_T$  = the theoretical volume of the carbon black sample, cm<sup>3</sup>,

$d_{CB}$  = accepted true (skeletal) density of the carbon black = 1.90 g/cm<sup>3</sup>, and

$m$  = mass of the carbon black sample, g.

10.3 The void volume of a carbon black per unit mass (100 g) is given by Eq 4.

$$VV = (V_A - V_T)/m (100) \quad (4)$$

where:

$VV$  = void volume of carbon black sample, 10<sup>-5</sup> m<sup>3</sup>/kg (cm<sup>3</sup>/100 g),

$V_A$  = the apparent compressed volume of the carbon black sample, cm<sup>3</sup>, from a single uniaxial compression (Eq 2), and

$V_T$  = the theoretical volume of the carbon black sample, cm<sup>3</sup>, (Eq 3).

NOTE 1—Some carbon blacks have reported skeletal densities of approximately 1.8 to 2.0 g/cm<sup>3</sup>. The accepted skeletal density of rubber carbon black is 1.90 g/cm<sup>3</sup>.

## 11. Report

11.1 Report the following information:

11.1.1 Sample Identification.

11.1.2 Void volume expressed to the nearest 0.1 10<sup>-5</sup> m<sup>3</sup>/kg (0.1 cm<sup>3</sup>/100g) measured at 50.0, 75.0, and 100.0 MPa Geometric mean pressures.

11.1.3 Sample mass in grams weighed to nearest 0.1 mg.

11.1.4 Cylinder diameter to the nearest 0.001 mm.

## 12. Precision and Bias<sup>3</sup>

12.1 These precision statements have been prepared in accordance with Practice D4483-99. Refer to this practice for terminology and other statistical details.

12.2 The precision results in this precision and bias section give an estimate of the precision of this test method with the materials used in the particular interlaboratory program described below. The precision parameters should not be used for acceptance or rejection testing of any group of materials without documentation that they are applicable to those particular materials and the specific testing protocols of the test method.

12.3 A type 2 inter-laboratory precision program was conducted in 2014 as detailed in Tables 1-3. Both repeatability and reproducibility represent short term (daily) testing conditions. The testing was performed using two operators in each laboratory performing the test once on each of two days (total of four tests). Acceptable difference values were not measured. The between operator component of variation is included in the calculated values for r, (r), R, and (R).

12.4 The results of the precision calculations for this test method are given in Tables 1-3. The materials are arranged in ascending “mean level” order. The preferred precision estimates are absolute (see bolded values in Tables 1-3).

<sup>3</sup> A research report is forthcoming.

**TABLE 2 Precision Parameters for D7854, Void Volume at 75 MPa Mean Pressure<sup>A</sup>**

Material	Number of Labs	Unit m <sup>3</sup> /kg Mean Level	Sr	r	(r)	SR	R	(R)
SRB 8D	20	23.0	0.18	<b>0.52</b>	1.51	0.32	<b>0.90</b>	2.39
SRB 8A	19	41.8	0.26	<b>0.73</b>	1.26	0.34	<b>0.95</b>	2.59
SRB 8E	21	45.7	0.20	<b>0.58</b>	2.27	0.42	<b>1.18</b>	3.93
SRB 8F	21	54.0	0.29	<b>0.81</b>	0.99	0.46	<b>1.29</b>	1.72
SRB 8B	21	62.4	0.25	<b>0.72</b>	1.16	0.56	<b>1.59</b>	2.55
SRB 8C	20	64.2	0.22	<b>0.63</b>	1.74	0.39	<b>1.11</b>	2.28
		Average Pooled						
		48.5	0.24	<b>0.67</b>	1.49	0.41	<b>1.17</b>	2.58

<sup>A</sup> Precision is based on absolute void volume measurements (non-normalized data) from an inter-laboratory precision program conducted in 2014.

**TABLE 3 Precision Parameters for D7854, Void Volume at 100 MPa Mean Pressure<sup>A</sup>**

Material	Number of Labs	Unit m <sup>3</sup> /kg Mean Level	Sr	r	(r)	SR	R	(R)
SRB 8D	20	21.6	0.18	<b>0.52</b>	1.54	0.34	<b>0.97</b>	2.45
SRB 8A	21	38.6	0.25	<b>0.72</b>	1.42	0.41	<b>1.17</b>	2.85
SRB 8E	20	42.2	0.21	<b>0.60</b>	2.42	0.43	<b>1.20</b>	4.50
SRB 8F	20	49.0	0.27	<b>0.76</b>	1.03	0.42	<b>1.20</b>	1.98
SRB 8B	21	56.8	0.28	<b>0.78</b>	1.37	0.60	<b>1.70</b>	2.99
SRB 8C	20	57.7	0.21	<b>0.60</b>	1.87	0.40	<b>1.14</b>	3.03
		Average Pooled						
		44.3	0.23	<b>0.66</b>	1.61	0.44	<b>1.23</b>	2.97

<sup>A</sup> Precision is based on absolute void volume measurements (non-normalized data) from an inter-laboratory precision program conducted in 2014.

**12.5 Repeatability**—The pooled repeatability, *r*, for void volume at 50 MPa mean pressure has been established as 0.86 cm<sup>3</sup>/100 g (see [Table 1](#)). The pooled repeatability, *r*, for void volume at 75 MPa mean pressure has been established as 0.67 cm<sup>3</sup>/100 g (see [Table 2](#)). The pooled repeatability, *r*, for void volume at 100 MPa mean pressure has been established as 0.66 cm<sup>3</sup>/100 g (see [Table 3](#)). The best estimate of the test precision is given by the pooled values and these should be used unless there is a good reason to use a different value. Any other value in [Tables 1-3](#) may be used as an estimate of repeatability, if justified, such as when testing the same material as, or a material similar to, those in the tables. The difference between two single test results (or determinations) found on identical test material under the repeatability conditions prescribed for this test will exceed the repeatability value on an average of not more than once in 20 cases in the normal and correct operation of the method. Two single test results that differ by more than the appropriate value from [Tables 1-3](#) must be suspected of being from different populations and some appropriate action taken.

NOTE 2—Appropriate action may be an investigation of the test method procedure or apparatus for faulty operation or the declaration of a significant difference in the two materials, samples, etc., which generated the two test results.

**12.6 Reproducibility**—The pooled reproducibility, *R*, for void volume at 50 MPa mean pressure has been established as 1.25 cm<sup>3</sup>/100 g (see [Table 1](#)). The pooled reproducibility, *R*, for void volume at 75 MPa mean pressure has been established as

1.17 cm<sup>3</sup>/100 g (see [Table 2](#)). The pooled reproducibility, *R*, for void volume at 100 MPa mean pressure has been established as 1.23 cm<sup>3</sup>/100 g (see [Table 3](#)). The best estimate of the test precision is given by the pooled values and these should be used unless there is a good reason to use a different value. Any other value in [Tables 1-3](#) may be used as an estimate of reproducibility, if justified, such as when testing the same material as, or a material similar to, those in the tables. The difference between two single and independent test results found by two operators working under the prescribed reproducibility conditions in different laboratories on identical test material will exceed the reproducibility value on an average of not more than once in 20 cases in the normal and correct operation of the method. Two single test results produced in different laboratories that differ by more than the appropriate value from [Tables 1-3](#) must be suspected of being from different populations and some appropriate investigative or technical/commercial action taken.

**12.7 Bias**—In test method terminology, bias is the difference between an average test value and the reference (true) test property value. Reference materials do not exist for this test method so it is not possible to establish reference (true) test property values to be used in determining bias. Bias, therefore, cannot be determined for this test method.

### 13. Keywords

13.1 apparent volume; geometric mean pressure; structure; theoretical volume; void volume

*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](mailto:service@astm.org) (e-mail); or through the ASTM website ([www.astm.org](http://www.astm.org)). Permission rights to photocopy the standard may also be secured from the Copyright Clearance Center, 222 Rosewood Drive, Danvers, MA 01923, Tel: (978) 646-2600; <http://www.copyright.com/>*