
**Rubber, vulcanized or thermoplastic —
Determination of flex cracking and crack
growth (De Mattia)**

*Caoutchouc vulcanisé ou thermoplastique — Détermination de la
résistance au développement d'une craquelure (De Mattia)*



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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 132 was prepared by Technical Committee ISO/TC 45, *Rubber and rubber products*, Subcommittee SC 2, *Testing and analysis*.

This fifth edition cancels and replaces the fourth edition (ISO 132:2005), of which it constitutes a minor revision the main purpose of which was to add Annex A concerning calibration and Annex B with precision results.

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Introduction

Repeated bending or flexing of a rubber causes cracks to develop in that part of the surface where tension stress is set up during flexing or, if this part of the surface contains a crack, causes this crack to extend in a direction perpendicular to the stress. Certain soft vulcanizates, for instance those prepared from styrene-butadiene rubber, show marked resistance to crack initiation, but it is possible for these vulcanizates to have a low resistance to growth (propagation) of cracks. It is important, therefore, to measure both the resistance to crack initiation by flexing and the resistance to crack propagation.

The method is suitable for rubbers that have reasonably stable stress-strain properties, at least after a period of cycling, and do not show undue stress softening or set, or highly viscous behaviour. The results obtained for some thermoplastic rubbers should be treated with caution if the elongation at yield is below, or close to, the maximum strain imposed during the test.

Vertical line of dots

Rubber, vulcanized or thermoplastic — Determination of flex cracking and crack growth (De Mattia)

WARNING — Persons using this International Standard should be familiar with normal laboratory practice. This standard does not purport to address all of the safety problems, if any, associated with its use. It is the responsibility of the user to establish appropriate safety and health practices and to ensure compliance with any national regulatory conditions.

IMPORTANT — Certain procedures specified in this International Standard might involve the use or generation of substances, or the generation of waste, that could constitute a local environmental hazard. Reference should be made to appropriate documentation on safe handling and disposal after use.

1 Scope

This International Standard specifies a method of test intended for use in comparing the resistance of vulcanized or thermoplastic rubbers to the formation and growth of cracks, when subjected to repeated flexing on the De Mattia type machine. For determination of crack growth, an artificial cut is made in the test piece to initiate cut growth.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 18899:2004, *Rubber — Guide to the calibration of test equipment*

ISO 23529, *Rubber — General procedures for preparing and conditioning test pieces for physical test methods*

3 Apparatus

3.1 De Mattia type machine, the essential features of which are as follows:

The machine has stationary parts, provided with grips for holding one end of each of the test pieces in a fixed position, and similar but reciprocating parts for holding the other end of each of the test pieces. The travel is $57^{+0,5}_0$ mm and is such that the maximum distance between each set of opposing grips is 75^{+1}_0 mm (see Figure 1).

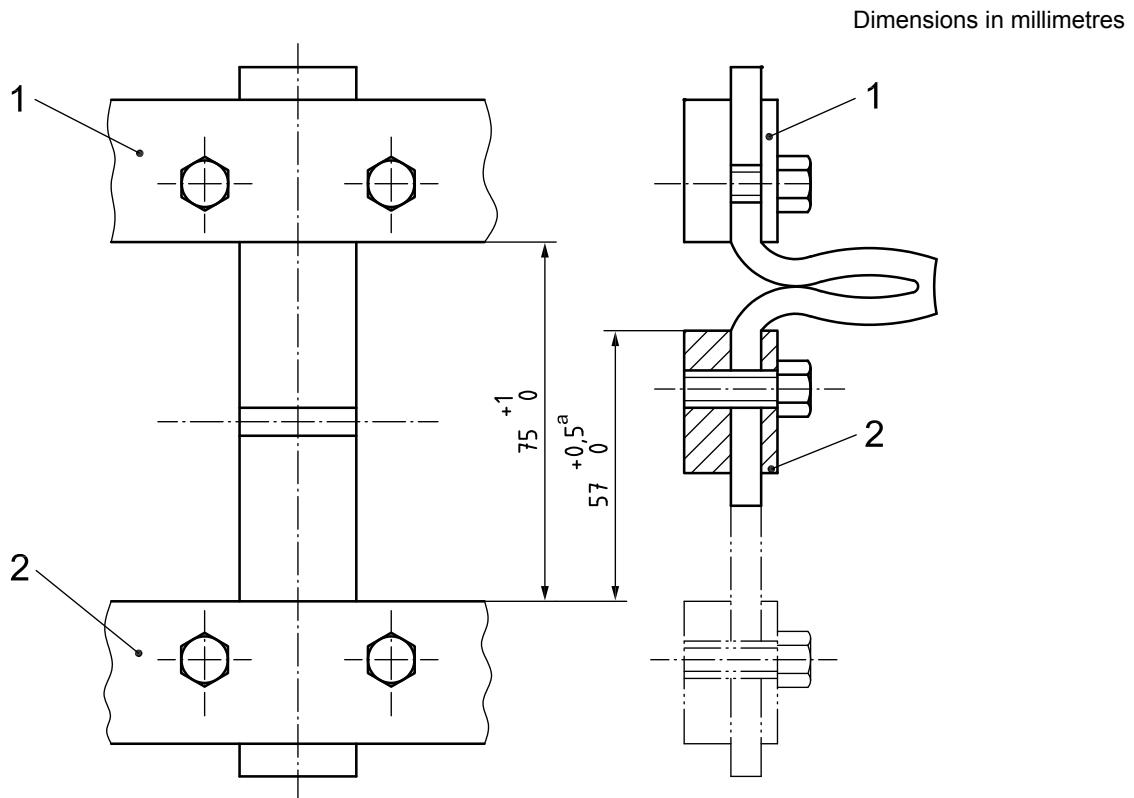
The reciprocating parts are so arranged that their motion is straight and in the direction of, and in the same plane as, the common centreline of each opposing pair of grips. The planes of the gripping surfaces of each opposing pair of grips remain parallel throughout the motion.

The eccentric which actuates the reciprocating parts is driven by a constant-speed motor to give $5,00 \text{ Hz} \pm 0,17 \text{ Hz}$, with sufficient power to flex at least six, and preferably 12, test pieces at one test. The grips hold the test pieces firmly, without undue compression, and enable individual adjustment to be made to the test pieces to ensure accurate insertion.

It is useful to arrange the test pieces in two equal groups, so that one group is being flexed while the other group is being straightened, thus reducing the vibration in the machine.

For testing at elevated or subnormal temperatures, the machine can be enclosed in a chamber with temperature control near the centre of the test piece to $\pm 2\text{ }^\circ\text{C}$, if necessary, by using an air circulator.

3.2 Piercing tool and suitable jig, for piercing the test pieces (see 5.2).



Key

- 1 upper grip
- 2 lower grip
- a Travel.

Figure 1 — De Mattia type machine

4 Calibration

The requirements for calibration of the test apparatus are given in Annex A.

5 Test pieces

5.1 Shape, dimensions and preparation

Each test piece shall be a strip with a moulded groove. The strips can be moulded individually in a multiple-cavity mould, as shown in Figure 2, or can be cut from a wide slab having a moulded groove.

The groove in the test piece shall have a smooth surface and be free from irregularities from which cracks can start prematurely. The groove shall be moulded into the test piece or slab by a half-round ridge in the centre of the cavity.

The half-round ridge shall have a radius of $2,38 \text{ mm} \pm 0,03 \text{ mm}$. The moulded groove shall be perpendicular to the direction of mill grain.

Results can be compared only between test pieces having thicknesses, measured close to the groove, which are within the tolerances, because the results of the test are dependent upon the thickness of the test piece.

If finished products are to be tested, test pieces without a groove can be used. They shall be prepared in accordance with ISO 23529. Cracks shall not be assessed on surfaces that have been cut or buffed. The use of test pieces cut and/or buffed from finished products shall be stated in the test report.

Dimensions in millimetres

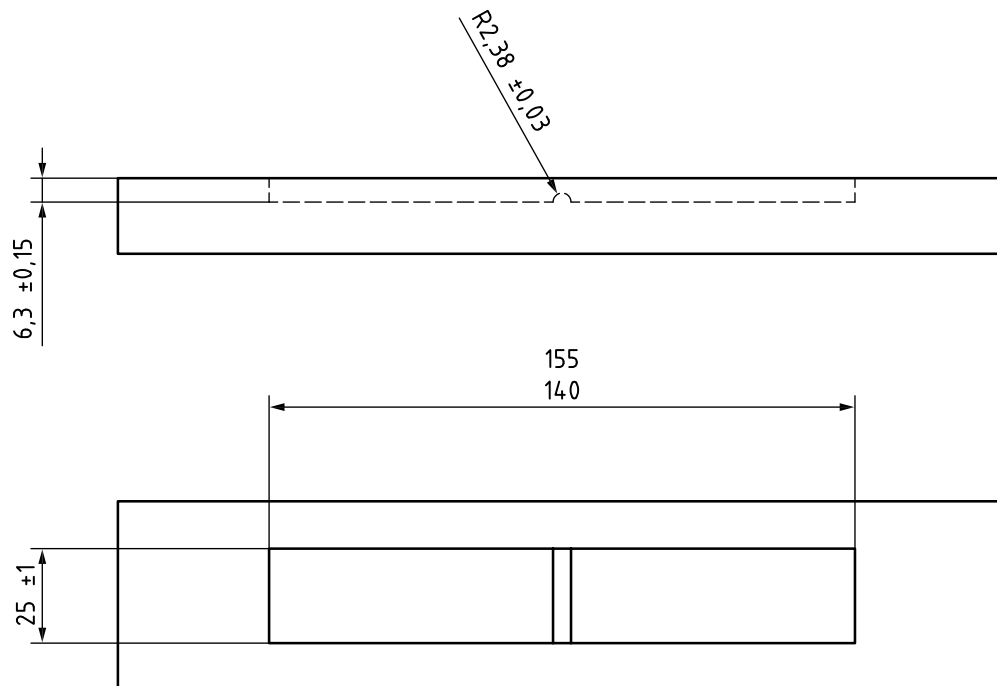


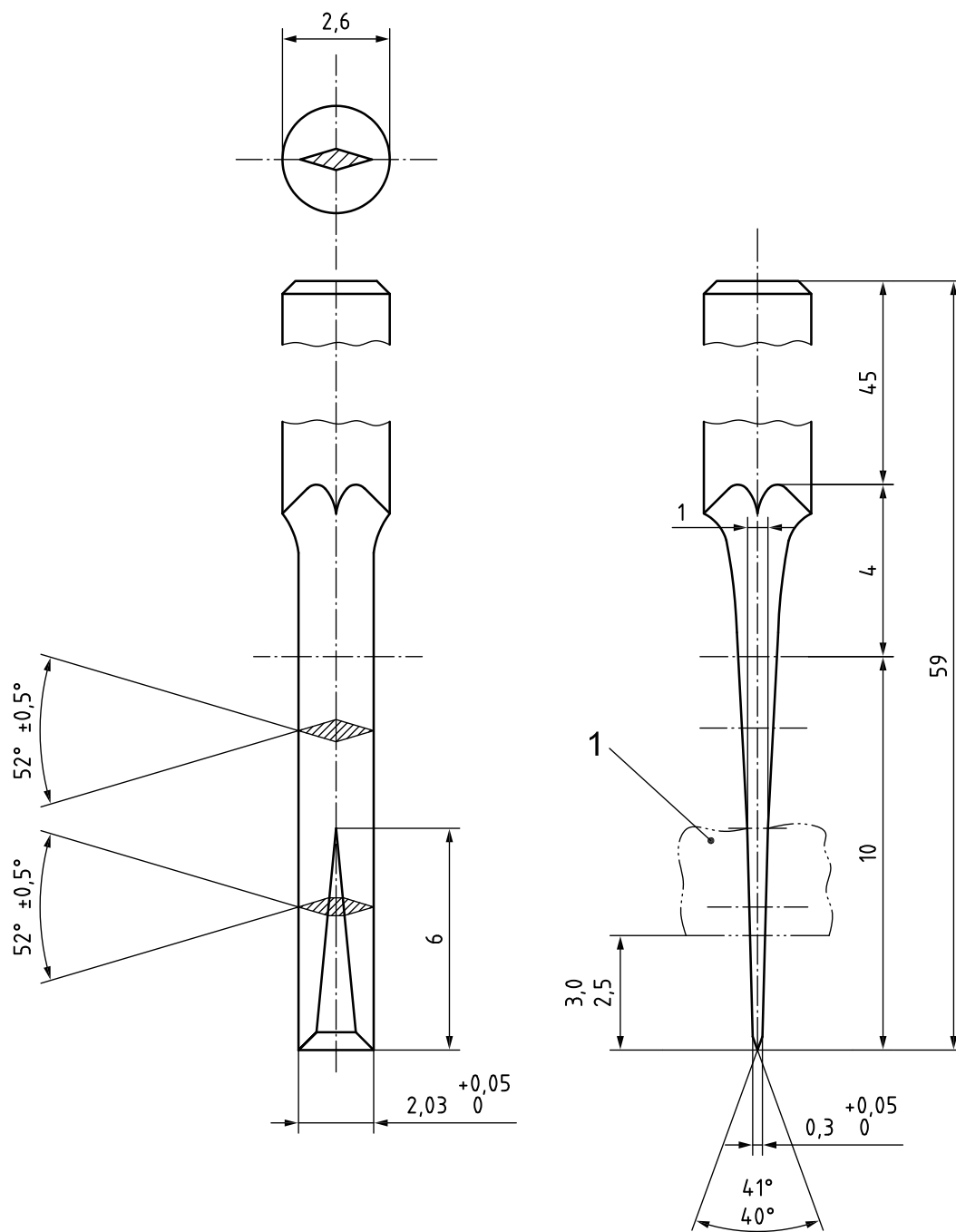
Figure 2 — Form for moulding test piece

5.2 Preparation of test pieces for crack growth measurement

Each test piece shall be prepared by piercing the bottom of the groove at a point equidistant from the sides, using a suitable jig. The piercing tool shall conform to the dimensions given in Figure 3. The piercing tool shall be maintained perpendicular to both the transverse and longitudinal axes, and the cut accomplished by a single insertion and withdrawal of the tool. The cut shall be parallel to the longitudinal axis of the groove. Lubrication with water containing a suitable wetting agent can be used.

A suitable jig shall be provided to hold the piercing tool; the exact details are not specified but the principles of operation shall be as follows:

The test piece shall be held flat in a solid support. The piercing tool shall be normal to the support and placed centrally with respect to the groove in the test piece, with the cutting edge of the piercing tool parallel to the axis of the groove. Means shall be provided for passing the piercing tool through the entire thickness of the rubber, and the support shall have a hole of a size just sufficient to permit the piercing tool to project through the base of the test piece to not less than 2,5 mm and not more than 3 mm.



Key

1 test piece

Figure 3 — Piercing tool

5.3 Time interval between vulcanization and testing

For all test purposes, the minimum time between vulcanization and testing shall be 16 h in accordance with ISO 23529.

For non-product tests, the maximum time between vulcanization and testing shall be 4 weeks and, for evaluations intended to be comparable, the tests shall, as far as possible, be carried out after the same time interval.

As far as possible, samples and test pieces shall be kept away from exposure to light.

5.4 Conditioning

For tests under standard laboratory conditions (see Clause 6), individually moulded test pieces shall be conditioned under the test conditions for a period of time in accordance with ISO 23529 immediately before testing.

Slab samples shall be similarly conditioned before the test pieces are cut. These test pieces can be either tested immediately or kept at the test temperature until tested.

For tests at other temperatures (see Clause 6), after the conditioning period specified above the test pieces shall be brought to the test temperature by keeping in a chamber at this temperature for 3 h, then tested immediately (see ISO 23529).

The same test temperature shall be used throughout any test or series of tests intended to be comparable.

5.5 Number of test pieces

At least three, and preferably six, test pieces from each rubber compound shall be tested. If comparison is required between different compounds, ensure that test pieces of each compound are mounted at the same time on the same test machine.

6 Test conditions

6.1 Temperature

Tests are normally performed at a standard laboratory temperature as defined in ISO 23529, although elevated or subnormal temperatures can often be used to advantage. In the latter case, the test temperature shall be selected from ISO 23529.

6.2 Humidity

With compounds where the results are known to be sensitive to humidity, the test shall be carried out under standard laboratory conditions (temperature and humidity) as defined in ISO 23529.

NOTE An influence of humidity has been observed with fluororubbers, polyurethane rubbers and other rubbers containing hydrophilic fillers.

7 Procedure

7.1 General

The presence of significant amounts of ozone in the laboratory atmosphere affects the results. Periodic checks are advised to ensure that the ambient ozone concentration is preferably less than 1 part by volume per 100 million parts of air.

The test shall not be made in a room which contains any apparatus that generates ozone, such as a fluorescent lamp, or which for any reason has an atmosphere with an ozone content above that of normal indoor air. The motor used to drive the test machine shall be of a type that does not generate ozone.

7.2 Determination of flex cracking

Separate the pairs of grips to their maximum extent, and insert the test pieces so that they are flat and not under tension, with the groove in each test piece midway between the two grips in which that test piece is held, and on the outside of the angle made by the test piece when it is bent.

Ensure that the test pieces are positioned at exactly 90° to the grips.

Start the machine and continue the test with frequent inspections until the first small sign of cracking is detected on each test piece. Record the number of flexing cycles at this point, restart the machine and stop it after intervals of, for instance, 1 h, 2 h, 4 h, 8 h, 24 h, 48 h, 72 h and 96 h. As an alternative, stop it after intervals in which the number of flexing cycles is increased in geometric progression, a suitable ratio being 1,5 on each occasion. Carry out each inspection of the test pieces with the test pieces fixed in place but the grips separated to a distance of 65 mm.

Cracks occurring at the edge of the test piece shall be ignored.

Grade the severity of cracking by comparison with a standard scale, as specified in 8.1. Do not run the test pieces to complete rupture, but to a given grade of cracking.

7.3 Determination of crack growth

Measure the initial length L of the cut, preferably using a low-power magnifying glass.

Insert the test pieces as described in 7.2, first paragraph.

Start the machine and stop it at frequent intervals to measure the length of the cut, for example after 1, 3 and 5 kilocycles and at such further or intermediate intervals as appear necessary. At each inspection, separate the grips to a distance of 65 mm and measure the length of the cut, preferably using a low-power magnifying glass.

Do not run the test pieces to complete rupture, but to a specified crack growth in accordance with 8.2.

8 Expression of results

8.1 Determination of flex cracking

The comparison includes an assessment of the length, depth and number of cracks.

Cracking shall be graded in accordance with the following scale:

Grade 1

The cracks at this stage look like pin pricks to the naked eye. Grade as 1 if the "pin pricks" are 10 or less in number.

Grade 2

Assess as grade 2 if either of the following applies:

- a) the "pin pricks" exceed 10 in number;

- b) the number of cracks is less than 10, but one or more cracks have developed beyond the “pin prick” stage, i.e. have perceptible length without much depth and their length is not more than 0,5 mm.

Grade 3

One or more of the “pin pricks” have become obvious cracks, i.e. have appreciable length and little depth and their length is greater than 0,5 mm but not greater than 1 mm.

Grade 4

The length of the largest crack is greater than 1 mm but not greater than 1,5 mm.

Grade 5

The length of the largest crack is greater than 1,5 mm but not greater than 3 mm.

Grade 6

The length of the largest crack is greater than 3 mm.

NOTE No distinction is made between cracks that have grown in isolation and those that have grown by coalescence.

Determine the median number of kilocycles to reach each grade of cracking. Plot the grades from 1 to 6 against the median number of corresponding kilocycles of flexing on linear graph paper and draw a smooth curve through the points. Using graphical interpolation, deduce the number of kilocycles required for each grade of cracking. The number of kilocycles required to reach grade 3 is the mean flex cracking resistance. Instead of graphical interpolation, a computer programme can be used for the calculation.

8.2 Determination of crack growth

Plot the crack length versus the number of flexing cycles for each test piece. Draw a smooth curve through the points and read off

- a) the number of kilocycles required for the cut to extend from L mm to $(L + 2)$ mm;
- b) the number of kilocycles required for the cut to extend from $(L + 2)$ mm to $(L + 6)$ mm;
- c) if desired, the number of kilocycles required for the cut to extend from $(L + 6)$ mm to $(L + 10)$ mm.

For each of these cut extensions, calculate the median number of kilocycles.

9 Precision

See Annex B.

10 Test report

The test report shall include the following information:

- a) details of sample and test piece preparation:
 - 1) a full description of the sample and its origin,
 - 2) the method of preparation of the test piece from the sample, for example moulded or cut;

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- b) a full reference to the test method used, i.e. the number of this International Standard;
- c) test details:
 - 1) the property determined (flex cracking or crack growth),
 - 2) the laboratory temperature,
 - 3) the number of test pieces used,
 - 4) the time and temperature of conditioning prior to the test,
 - 5) the temperature of test and the relative humidity, if necessary,
 - 6) details of any procedures not specified in this International Standard;
- d) test results:
 - 1) for the determination of flex cracking:
 - the median number of kilocycles required to reach each grade of cracking, from grade 1 to grade 6 or
 - the mean flex cracking resistance or
 - the number of kilocycles up to which no cracks occur,
 - 2) for the determination of crack growth, the median number of kilocycles for the cut to extend
 - from L mm to $(L + 2)$ mm,
 - from $(L + 2)$ mm to $(L + 6)$ mm and, if desired,
 - from $(L + 6)$ mm to $(L + 10)$ mm;
- e) the date(s) of testing.

Annex A (normative)

Calibration schedule

A.1 Inspection

Before any calibration is undertaken, the condition of the items to be calibrated shall be ascertained by inspection and recorded in any calibration report or certificate. It shall be reported whether calibration was carried out in the "as-received" condition or after rectification of any abnormality or fault.

It shall be ascertained that the apparatus is generally fit for the intended purpose, including any parameters specified as approximate and for which the apparatus does not therefore need to be formally calibrated. If such parameters are liable to change, then the need for periodic checks shall be written into the detailed calibration procedures.

A.2 Schedule

Verification/calibration of the test apparatus is a mandatory part of this International Standard. However, the frequency of calibration and the procedures used are, unless otherwise stated, at the discretion of the individual laboratory, using ISO 18899 for guidance.

The calibration schedule given in Table A.1 has been compiled by listing all of the parameters specified in the test method, together with the specified requirement. A parameter and requirement can relate to the main test apparatus, to part of that apparatus or to an ancillary apparatus necessary for the test.

For each parameter, a calibration procedure is indicated by reference to ISO 18899, to another publication or to a procedure particular to the test method which is detailed (whenever a calibration procedure which is more specific or detailed than that in ISO 18899 is available, it shall be used in preference).

The verification frequency for each parameter is given by a code-letter. The code-letters used in the calibration schedule are:

- C requirement to be confirmed, but no measurement;
- N initial verification only;
- S standard interval as given in ISO 18899;
- U in use.

Table A.1 — Calibration frequency schedule

Parameter	Requirement(s)	Subclause in ISO 18899:2004	Verification frequency guide	Notes
De Mattia type machine with fixed and reciprocating grips	The motion shall be straight, and in the direction and plane of the common centreline of each opposing pair of grips. The planes of opposing grips shall remain parallel throughout the motion.	C	N	
Grips	One fixed, one moving. Shall hold the test piece firmly and allow individual adjustment.	C	U	
Grip travel	$57^{+0,5}_0$ mm	15.2	S	
Maximum grip separation	75^{+1}_0 mm	15.2	S	
Frequency	5,00 Hz \pm 0,17 Hz	23.3	S	
Power	Sufficient to flex 6 to 12 test pieces at one test	C	N	
Temperature control	± 2 °C	18	S	For non-ambient temperatures
Piercing tool	As shown in Figure 3	15.2, 15.3	S	
Piercing jig	Capable of holding the piercing tool normal to the test piece. Fitted with a means of passing the tool through the test piece to project out 2,5 mm to 3,0 mm on the other side.	C 15.2	N S	

In addition to the items listed in Table A.1, use of the following is implied, all of which need calibrating in accordance with ISO 18899:

- a thermometer for monitoring the conditioning and test temperatures;
- instruments for determining the dimensions of the test pieces;
- an instrument for measuring the crack length.

Annex B (informative)

Precision

B.1 General

The calculations to determine the repeatability and reproducibility were performed in accordance with ISO/TR 9272. Consult this for precision concepts and nomenclature. In addition to the precision data itself, this annex gives guidance on the use of repeatability and reproducibility results.

B.2 Programme details

B.2.1 An interlaboratory test programme (ITP) was organized in 2009.

Test pieces prepared from cured sheets of four compounds, A, B, C and D, were sent out to all participating laboratories. Details of these compounds are given in Table B.1.

Table B.1 — Formulations of compounds A, B, C and D used in the ITP

Values in parts per hundred rubber

Ingredient	Compound			
	A	B	C	D
S-SBR 5025-1	96	96	—	—
BR CB 24	30	30	—	—
NR	—	—	100	100
HD silica (BET: 175 m ² /g)	80	40	—	—
Carbon black: ECORAX® 1990	—	—	52	—
Carbon black: Type N220	—	—	—	55
Silica (BET: 130 m ² /g)	—	—	13	—
TESPT	—	—	2	—
Carbon black: type N330 + TESPT (50:50)	12,8	6,4	—	—
ZnO	3	3	3	3
Stearic acid	2	2	3	3
Naphthenic oil	10	10	—	—
6PPD	1,5	1,5	1	1
TMQ	—	—	1	1
Light shield wax	1	1	1	1
DPG	2	2	—	—
CBS	1,5	1,5	—	—
TBzTD	0.2	0.2	—	—
TBBS-80	—	—	1,2	1,2
PVI	—	—	0,15	0,15
Sulfur	1,5	1,5	1,5	1,5

From each compound, 2×3 test pieces without a cut and 2×3 test pieces with a cut were prepared and sent to each laboratory with instructions to carry out the flex cracking and crack growth measurements during each of two test periods a week apart.

Nine laboratories participated in the ITP. The results of only six laboratories were included in the final evaluation because the other three did not carry out a second period of testing.

B.2.2 The precision determined is a type 1 precision as no mixing or curing of the test compounds was done in the participating laboratories.

B.3 Precision results

The precision results are given in Tables B.2 and B.3. The symbols used in the tables are defined as follows:

s_r is the within-laboratory standard deviation, in measurement units;

r is the repeatability limit, in measurement units;

(r) is the repeatability, in percent (relative);

s_R is the between-laboratory standard deviation, in measurement units;

R is the reproducibility limit, in measurement units;

(R) is the reproducibility, in percent (relative).

Table B.2 — Precision for determination of flex cracking

Material	Mean level kilocycles	Within-laboratory			Between-laboratory			Number of laboratories ^a
		s_r	r	(r)	s_R	R	(R)	
Test piece without cut: grade 1								
A	28,58	20,04	56,12	196,39	23,77	66,57	232,94	4
B	28,42	3,06	8,58	30,18	21,34	59,75	210,26	3
C	22,88	4,55	12,75	55,72	19,82	55,51	242,61	5
D	29,35	6,52	18,26	62,22	19,36	54,20	184,66	5
Group average		—	23,93	86,13	—	59,01	217,62	—
Test piece without cut: grade 2								
A	29,05	2,34	6,56	22,57	15,89	44,50	153,20	3
B	29,05	3,08	8,62	29,68	20,25	56,71	195,21	3
C	84,43	10,82	30,31	35,90	55,92	156,59	185,46	6
D	79,61	6,99	19,58	24,59	37,96	106,28	133,51	5
Group average		—	16,27	28,18	—	91,02	166,85	—
Test piece without cut: grade 3 (= mean flex cracking resistance)								
A	34,13	7,37	20,64	60,48	16,03	44,89	131,53	3
B	30,15	3,11	8,72	28,93	18,37	51,44	170,62	3
C	115,52	15,94	44,64	38,64	60,90	170,52	147,61	6
D	133,02	3,57	10,00	7,52	64,31	180,06	135,36	5
Group average		—	21,00	33,89	—	111,73	146,28	—
Test piece without cut: grade 4								
A	39,47	8,81	24,68	62,53	13,42	37,57	95,20	39,47
B	31,77	3,35	9,37	29,49	15,64	43,78	137,83	31,77
C	119,40	17,41	48,74	40,82	45,58	127,62	106,89	119,40
D	132,38	8,09	22,66	17,12	48,83	136,73	103,28	132,38
Group average		—	26,36	37,49	—	86,43	110,80	—
Test piece without cut: grade 5								
A	60,60	24,24	67,88	112,02	18,21	50,99	84,14	60,60
B	35,42	3,06	8,57	24,21	9,46	26,50	74,83	35,42
C	145,54	20,19	56,52	38,83	42,95	120,27	82,64	145,54
D	160,40	8,15	22,83	14,23	44,70	125,17	78,03	160,40
Group average		—	38,95	47,32	—	80,73	79,91	—
Test piece without cut: grade 6								
A	75,93	27,15	76,01	100,10	52,12	145,93	192,18	75,93
B	65,42	5,10	14,29	21,84	43,13	120,77	184,62	65,42
C	224,75	14,17	39,68	17,65	110,11	308,30	137,18	224,75
D	264,16	11,54	32,31	12,23	109,70	307,17	116,28	264,16
Group average		—	40,57	37,96	—	220,54	157,56	—

^a Number of labs remaining after deletion of outliers, using procedure given in ISO/TR 9272:2005 as option 2.

Table B.3 — Precision for determination of crack growth

Material	Mean level kilocycles	Within-laboratory			Between-laboratory			Number of laboratories ^a
		s_r	r	(r)	s_R	R	(R)	
Test piece with cut: 2 mm to 4 mm								
A	0,26	0,00	0,00	0,00	0,11	0,32	122,79	5
B	0,99	0,22	0,62	62,61	0,28	0,79	80,00	5
C	3,09	0,39	1,09	35,21	0,93	2,61	84,51	5
D	2,98	0,84	2,35	78,95	1,60	4,49	150,67	5
Group average		—	1,02	44,19	—	2,05	109,49	—
Test piece with cut: 4 mm to 8 mm								
A	1,31	0,11	0,32	24,37	0,39	1,10	84,01	5
B	3,89	0,73	2,03	52,26	1,09	3,04	78,10	6
C	29,73	6,19	17,34	58,32	6,72	18,81	63,27	5
D	30,17	9,55	26,74	88,62	14,79	41,41	137,25	5
Group average		—	11,61	55,89	—	16,09	90,66	—
Test piece with cut: 8 mm to 12 mm								
A	3,95	0,22	0,62	15,69	0,95	2,65	67,14	5
B	8,43	1,60	4,49	53,23	2,60	7,29	86,44	6
C	103,59	23,42	65,58	63,31	24,68	69,11	66,71	5
D	107,42	36,87	103,23	96,10	52,53	147,08	136,92	5
Group average		—	43,48	57,08	—	56,53	89,30	—
^a Number of labs remaining after deletion of outliers, using procedure given in ISO/TR 9272:2005 as option 2.								

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- [1] ISO/TR 9272:2005, *Rubber and rubber products — Determination of precision for test method standards*

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