

# INTERNATIONAL STANDARD

**ISO**  
**6915**

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## **Flexible cellular polymeric materials — Polyurethane foam for laminate use — Specification**

*Matériaux polymères alvéolaires souples — Mousse de polyuréthane  
pour utilisation sous forme de feuilles pour assemblages —  
Spécifications*



Reference number  
ISO 6915:1991(E)

**ISO 6915:1991(E)****Foreword**

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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.

International Standard ISO 6915 was prepared by Technical Committee ISO/TC 45, *Rubber and rubber products*.

This second edition cancels and replaces the first edition (ISO 6915:1984), of which it constitutes a minor revision.

Annexes A and B form an integral part of this International Standard.

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# Flexible cellular polymeric materials — Polyurethane foam for laminate use — Specification

## 1 Scope

This International Standard specifies the minimum requirements for flexible polyurethane foams up to and including 20 mm thick intended for combination with suitable substrates such as non-woven, woven or knitted fabrics, to form a laminate.

Three types of flexible polyurethane foam are specified as follows:

type 1: polyether;

type 2: polyester with minimum elongation at break of 200 %;

type 3: polyester with minimum elongation at break of 300 %.

## 2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 845:1988, *Cellular plastics and rubbers — Determination of apparent (bulk) density*.

ISO 1798:1983, *Polymeric materials, cellular flexible — Determination of tensile strength and elongation at break*.

ISO 1923:1981, *Cellular plastics and rubbers — Determination of linear dimensions*.

ISO 2440:1983, *Polymeric materials, cellular flexible — Accelerated ageing tests*.

## 3 Appearance

**3.1** The material shall consist of a uniform network of cells and shall be free from any flaws, stains and other defects which might detrimentally affect the serviceability.

**3.2** Material of thickness up to and including 6 mm shall lie flat when laid on a flat surface.

**3.3** The material shall have no holes more than 3 mm in diameter through the full thickness of the foam. The maximum number of holes of diameter between 1,5 mm and 3 mm in any 60 m<sup>2</sup> of material shall be not more than four for material of thickness 2 mm or less, and not more than eight for thicker material.

**3.4** The colour shall be reasonably uniform and shall be as agreed between the supplier and the purchaser, having regard to the tendency for polyurethane foam to change colour on exposure to light.

## 4 Joints

Where it is necessary to join lengths of material together, the joint shall be as strong as the foam itself, and the adhesive or method of joining used shall not be injurious to the foam or to the material to which it is to be laminated. The construction and minimum spacing of joints shall be as agreed between the purchaser and the supplier.

## 5 Odour

The material shall be free from objectionable odour.

The degree of permissible odour shall be agreed between the purchaser and the supplier.

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**6 Dimensions****6.1 Thickness**

The nominal thickness shall be agreed between the purchaser and the supplier.

Tolerances on thickness shall be as given in table 1.

**Table 1 — Thickness tolerances**

Values in millimetres

Thickness	Tolerance	
	+	-
Less than 4	0,3	0,2
4 and over	0,5	0,3

Thickness measurement shall be carried out in accordance with ISO 1923:1981, sub-clause 4.3.

**6.2 Width**

The width of the material shall be agreed between the purchaser and the supplier.

Tolerances on width shall be as given in table 2.

**Table 2 — Width tolerances**

Values in millimetres

Width	Tolerance
Less than 1 200	+40 0
1 200 and over	+55 0

**6.3 Length**

The minimum length of a roll shall be agreed between the purchaser and the supplier.

The length of a roll shall be determined by winding the roll on a slack winding machine.

**7 Apparent density**

The apparent density of the material, when determined by the method given in ISO 845, shall be within  $\pm 10\%$  of the nominal value agreed between the purchaser and the supplier.

**8 Cell count**

The cell count shall be as agreed between the purchaser and the supplier subject to a tolerance of  $\pm 10\%$ . It shall be expressed in cells per linear 100 mm, and shall be determined by the method described in annex A.

NOTE 1 The cell count method described produces a result representative of the count at a single position. Variations may occur within a sheet of foam and, if necessary, these can be established by agreement between the purchaser and the supplier.

**9 Performance requirements**

The performance requirements, determined in accordance with the appropriate methods indicated in table 3, shall be in accordance with the limits stated in the table.

**10 Packaging and marking**

The product shall be packaged in such a manner as to be protected against possible contamination and deformation. Each product or package shall be marked with the following information:

- the name and/or distinctive mark of the manufacturer;
- the batch number or other reference to identify the individual rolls with manufacturing batches;
- the nominal thickness;
- the nominal width;
- the length;
- the number of this International Standard and type of sheeting.

Table 3 — Performance requirements of flexible polyurethane foams

Property	Type 1	Type 2	Type 3	Method of test
<b>Tensional properties</b>				
<b>Initial values</b>				
Tensile strength (kPa), min.	100	120	160	ISO 1798
Elongation at break (%), min.	200	200	300	ISO 1798
<b>After humidity ageing in accordance with ISO 2440 (3 h at 105 °C and 100 % relative humidity)</b>				
Tensile strength (% of initial value), min.	80	80	80	ISO 1798
Elongation at break (% of initial value), min.	80	80	80	ISO 1798
<b>After heat ageing in accordance with ISO 2440 (16 h at 140 °C)</b>				
Tensile strength (% of initial value), min.	80	80	80	ISO 1798
Elongation at break (% of initial value), min.	80	80	80	ISO 1798
<b>Solvent swelling</b>				
Temporary swelling (%), max.	80	15	15	Annex B of this International Standard
Permanent swelling (%), max.	6,5	2,5	2,5	

## Annex A (normative)

### Measurement of cell count

#### A.1 Scope

This annex describes a method for measuring the cell count of cellular material. It is a method of comparing the cell structure of foam materials.

Due to the variation in individual cell size even in uniform cell structures, it is more convenient to report the number of cells per unit length rather than the actual cell size.

#### A.2 Definition

For the purposes of this annex, the following definition applies:

**A.2.1 cell count:** the number of cells per 100 mm in the cellular material under specified conditions.

#### A.3 Apparatus

A 25 mm cloth counting glass shall be used.

#### A.4 Test pieces

Test pieces may consist of any sample of foam material which is free of skin and has a plane surface large enough to accommodate the counting glass.

Surfaces revealing a marked elongation of the cellular structure or striations shall not be measured unless specifically required.

#### A.5 Conditioning

Test pieces shall not be measured less than 72 h after manufacture. Prior to measurement, the test pieces shall be stored for at least 16 h in one of the following standard atmospheres:

23 °C ± 2 °C, (50 ± 5) % relative humidity;

or

27 °C ± 2 °C, (65 ± 5) % relative humidity.

#### A.6 Procedure

After conditioning as described in A.5, lay the test piece on a flat, horizontal surface without strain and count the actual number of cells against the counting edge of the glass. Carry out three counts at a given position. Multiply the median value of the three counts by four to provide the count per 100 mm.

Where cell counts along and across the test piece are important, a set of counts shall be made in each direction.

NOTE 2 The process of counting may be eased by lightly marking the surface of the foam with ink in the counting area, to indicate the uppermost layer of cells.

## Annex B (normative)

### Measurement of solvent swelling

#### B.1 Scope

The annex describes a method for measuring the volume swelling of urethane foam after immersion in perchloroethylene under specified conditions. Other solvents may be used by agreement between the parties concerned.

#### B.2 Test piece

The test piece shall be a die-cut 100 mm diameter disc, the thickness of which shall be measured in accordance with ISO 1923:1981, sub-clause 4.3.

#### B.3 Solvent

The solvent shall be of recognized analytical reagent quality. When using perchloroethylene, fresh solvent shall be used for each test piece.

**WARNING — Precautions governing the use of toxic solvents should be observed throughout the test.**

#### B.4 Conditioning

Samples and test pieces shall be tested not less than 72 h after manufacture. They shall be conditioned immediately before testing for a period of not less than 16 h in one of the following standard atmospheres:

23 °C ± 2 °C, (50 ± 5) % relative humidity;

or

27 °C ± 2 °C, (65 ± 5) % relative humidity.

#### B.5 Test temperature

Unless otherwise specified, the test shall be carried out at a temperature of 23 °C ± 2 °C.

#### B.6 Procedure

##### B.6.1 Measurement of temporary swelling

Place the test piece in a dish of dimensions approximately 300 mm × 200 mm containing perchloroethylene to a depth of 25 mm to 30 mm. After

5 min submerge the test piece by covering it with a 200 mm square of wire gauze with a nominal aperture size of 250 µm ("legs" may be formed by bending a 12,5 mm strip on two opposite sides to 90°). After the foam has been in contact with the solvent for a total period of 30 min, remove the wire gauze and lift the test piece from the solvent by means of a flat wire gauze scoop consisting of a 175 mm square of wire gauze with a nominal aperture size of 250 µm and fitted with a wire frame and handle. Secure the scoop at an angle of 45° and allow the test piece to drain for 5 min. Cover the test piece with a 150 mm square glass plate, 6,5 mm thick. Invert the glass, test piece and scoop and, after the scoop has been removed, measure the diameter of the test piece and the thickness of the test piece with glass plate in accordance with ISO 1923.

#### B.6.2 Measurement of permanent swelling

Allow the test piece to stand at room temperature for a period of not less than 24 h or until such time as it is completely free from solvent. Check by weighing to constant mass. If possible, dry the test piece in a fume cupboard without forced extraction.

Measure the diameter and thickness in accordance with ISO 1923.

#### B.7 Expression of results

##### B.7.1 Temporary swelling

The temporary swelling, expressed as a percentage, is given by the formula

$$\frac{d_2^2(h_2 - h_4) - d_1^2 h_1}{d_1^2 h_1} \times 100$$

where

- $d_1$  is the original diameter of the test piece;
- $d_2$  is the diameter of the test piece soaked in solvent;
- $h_1$  is the original thickness of the test piece;
- $h_2$  is the thickness of the test piece soaked in solvent, plus that of the glass plate;
- $h_4$  is the thickness of the glass plate.

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**B.7.2 Permanent swelling**

The permanent swelling, expressed as a percentage, is given by the formula

$$\frac{d_3^2 h_3 - d_1^2 h_1}{d_1^2 h_1} \times 100$$

where

$d_3$  is the final diameter of the test piece;

$h_3$  is the final thickness of the test piece;

$d_1$  and  $h_1$  have the same meanings as in B.7.1.



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