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Standard Test Method for Lamination Factor of Magnetic Materials¹

This standard is issued under the fixed designation A719/A719M; 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 test method covers measurement of the lamination factor (**Note 1**) of a specimen composed of strips cut from magnetic material.

NOTE 1—Lamination factor is also termed space factor or stacking factor.

1.2 This test method shall be used in conjunction with Practice A34/A34M.

1.3 The values and equations stated in customary (cgs-emu and inch-pound) or SI units are to be regarded separately as standard. Within this test method, SI units are shown in brackets. 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 nonconformance with this test method.

1.4 *This standard does not purport to address the safety concerns associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

A34/A34M Practice for Sampling and Procurement Testing of Magnetic Materials

¹ This test method is under the jurisdiction of ASTM Committee A06 on Magnetic Properties and is the direct responsibility of Subcommittee A06.01 on Test Methods.

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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.

3. Summary of Test Method

3.1 The laminated test specimen is subjected to pressure in a compression device and the resulting volume is then determined from the measured specimen height, width, and length. An equivalent solid volume is calculated from the specimen mass and the true density of the specimen material. The ratio of the calculated (equivalent solid) volume to the measured volume is the lamination factor.

4. Significance and Use

4.1 Lamination factor, S , indicates the deficiency of effective steel volume which is due to the presence of oxides, roughness, insulating coatings, and other conditions affecting the steel surface.

4.2 The term Lamination Factor, S , pertains strictly to the determination of the proportion of material as defined by precise sampling and procedures of this test method. Alternative usage of the term Lamination Factor has evolved to include sampling and procedures outside of the context of this test method. Consideration of alternative sampling and procedures should not be included within the scope of this test method.

5. Apparatus

5.1 *Testing Machine*—A compression testing machine or other compression device capable of exerting the specified pressure.

5.2 *Metal Plates*—Two flat, smooth, rigid metal plates with square edges and ends are required. They shall be of sufficient stiffness to distribute the pressure uniformly over the surface of the sample. Each plate shall be 8.46 in. [215 mm] long and have a minimum width of 1.97 in. [50 mm] so that the area of strips under pressure when testing 1.18-in. [30-mm] wide specimens will be 10 in.² [6450 mm²].

5.2.1 Extensions can be added to the plates to allow the use of micrometers or outside calipers instead of inside calipers for determining plate separation. Precautions must be taken to ensure that, within the limits of accuracy of the measurements, no significant deflection of these extensions result from the test pressure.

5.3 *Length-Measuring Tools*—Calipers or other devices of adequate accuracy for measurement of plate separation.

6. Sampling

6.1 Test strips shall be selected as representative of the surface condition. Core loss test specimens (Epstein test specimens) are normally used for this purpose.

6.2 In routine testing, where the core loss specimens are too small to conform to the minimum number of strips requirement of **Table 1**, sufficient specimens may be combined to provide an adequate test specimen. The combined specimens must be of the same thickness and material, have similar surfaces, and be representative of the surface condition of the test lot.

6.3 When a referee test becomes necessary, the test specimen must be composed of strips taken from one lot of steel. It must be representative of the surface condition, thickness, and other variables. The shearing burrs should be removed and the strips wiped free of loose particles.

7. Test Specimen

7.1 The number of strips in the test specimens shall be equal to or greater than the minimum number of strips prescribed in **Table 1**.

7.2 Each strip shall have a minimum length of 9.84 in. [250 mm] and a width of 1.18 in. [30 mm].

7.3 Length and width dimensions should be known to at least 0.25 % and preferably to 0.1 %.

8. Procedure

8.1 Determine the mass of the test specimen by weighing.

8.2 Stack the strips evenly and place them symmetrically between the two flat plates in the compression testing machine.

8.3 Apply pressure so it is distributed uniformly across the test specimen.

8.4 The recommended standard minimum test pressure shall be 50 psi [345 kPa]. Other pressures, depending on the application, may be agreed upon between the seller and the purchaser.

8.5 If more than one test pressure is used, apply the pressures in ascending order.

8.6 Calculate the average separation of the backing plates, or stack height, at the required pressure from measurements of the plates separation.

8.6.1 When using a compression testing machine make four measurements of the separation, one at each corner of the backing plates.

8.6.2 When using a compression device designed specifically for determining this factor only two measurements, taken on the longitudinal axis of the strips at each end of the plates, are required.

9. Calculation

9.1 Customary Units:

9.1.1 Calculate the percentage lamination factor as follows:

$$S = [m / (2.54 w l \delta h')] \times 100 \quad (1)$$

where:

- S = lamination factor, %;
- m = mass of test specimen, g;
- w = width of test specimen, cm;
- l = length of test specimen, cm;
- δ = density of the specimen material; g/cm³, (see Practice **A34/A34M**); and
- h' = measured average separation of the plate faces or stack height, in.

9.2 SI Units:

9.2.1 Calculate the percentage lamination factor as follows:

$$S = [m / (w l \delta h')] \times 10^8 \quad (2)$$

where:

- S = lamination factor, %;
- m = mass of test specimen, g;
- w = width of specimen, mm;
- l = length of specimen, mm;
- δ = density of specimen material, kg/m³; and
- h' = measured stack height, mm.

10. Precision and Bias

10.1 *Precision*—The precision of the procedure in this test method for measuring the lamination factor of magnetic materials has not been determined.

10.2 *Bias*—Since there is no accepted reference material for determining the bias for the procedure in this test method for measuring lamination factor, bias has not been determined.

11. Keywords

11.1 lamination factor; space factor; stacking factor

TABLE 1 Minimum Number of Strips in Lamination Factor Test Specimens

Thickness		Minimum Number of Strips per Test Specimen
in.	[mm]	
0.031 or greater	0.79 or greater	12
0.0280	0.71	12
0.0250	0.64	12
0.0220	0.55	12
0.0185	0.47	16
0.0140	0.35	20
0.0120	0.30	24
0.0110	0.27	24
0.0100	0.25	28
0.0090	0.23	28
0.0080	0.20	32
0.0070	0.18	36
0.0060	0.15	44
0.0050	0.13	52
0.0040	0.10	64

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