

TABLE 1 Parallel Flexural Strength, Method B (lbf) 5 Labs / 81 Data Points

Panel	Average ^a	Standard Deviation of the Sample Averages	Repeatability Standard Deviation	Reproducibility Standard Deviation	Repeatability Limit	Reproducibility Limit
	\bar{x}	$s_{\bar{x}}$	s_r	s_R	r	R
A	49.4871	6.3911	11.9766	12.6641	33.5344	35.4593
B	85.2847	5.4871	16.3279	16.3279	45.7180	45.7180
C	35.6045	4.3757	6.3969	7.2970	17.9112	20.4316

^a The average of the laboratories' calculated averages.

TABLE 2 Perpendicular Flexural Strength, Method B (lbf) 7 Labs / 117 Data Points

Panel	Average ^a	Standard Deviation of the Sample Averages	Repeatability Standard Deviation	Reproducibility Standard Deviation	Repeatability Limit	Reproducibility Limit
	\bar{x}	$s_{\bar{x}}$	s_r	s_R	r	R
A	136.1732	3.6219	6.2402	6.8696	17.4725	19.2075
B	205.7995	7.4166	8.6020	10.9361	24.6457	30.6212
C	80.0015	1.9560	1.5668	2.4066	4.4431	6.8196

^a The average of the laboratories' calculated averages.

8. Core, End, and Edge Hardness (Method A)

8.1 Summary of Test Method—The core, end, and edge hardness of gypsum panel products is evaluated by determining the force required to push a steel punch into the area of test.

8.2 Significance and Use—This test method covers a procedure for evaluating the ability of the gypsum panel product core, ends, and edges to resist crushing during handling or use of the material. This test method is used to determine compliance with gypsum panel product specifications. The degree of correlation between these test methods and service performance has not been determined.

8.3 Apparatus—See 6.1. Clamp or secure the specimen to the base of the test apparatus shown in Fig. 1 with the face of the specimen perpendicular to the base of the test apparatus and parallel to the movement of the steel punch. Secure the steel punch to the moving head of the test apparatus, positioned so that its center axis is parallel with the line of travel and so that the punch is inserted into the core equidistant from the surfaces of the specimen. Use a steel punch 0.099 ± 0.003 in. (2.515 ± 0.076 mm) in diameter and more than $\frac{1}{2}$ in. (12.7 mm) long with the bearing surface machined to a 90° angle in reference to the punch center line (see Fig. 1 for test setup schematic).

8.4 Sampling—Sampling shall be in accordance with Section 4.

8.5 Test Specimens:

8.5.1 Specimens for Core Hardness—Using a table or band saw, cut one specimen from the center of each gypsum panel product sample approximately 12 by not less than 3 in. (305 by 76 mm), with the 12-in. dimension perpendicular to the edges of the products. The smaller, not less than 3 in., dimension will vary depending on the specific punch length and opening in the testing machines. Place the sample in the tester, with the loading arm in a horizontal position and with the punch resting on the specimen. Saw cuts along the 12-in. dimension shall be smooth and square with the smaller (not less than 3-in.) dimension, as well as with the specimen.

8.5.2 Specimens for End Hardness—Cut specimens the same size and method as described in 8.5.1 from one mill-cut end of the gypsum panel product, with the 12-in. (305 mm) dimension perpendicular to the edges and run tests only on the mill-cut end of the specimens.

8.5.3 Specimens for Edge Hardness—Cut specimens the same size and method as described in 8.5.1 from the opposite edges of each gypsum panel product, with the 12 in. (305 mm) dimension of the specimens parallel with the edges. For gypsum panel products with surfacing material, cut a $\frac{1}{8}$ to $\frac{1}{2}$ -in. (6 to 13 mm) strip of surfacing material from the edge of the test specimens exposing the core for test. Remove as little of the core as possible when removing the surfacing material. Prepare the first test area $2 \pm \frac{1}{8}$ in. (51 ± 13 mm) from one edge of the specimen, with the next two test areas approximately 4 in. (102 mm) apart.

8.5.4 Condition specimens in accordance with Section 5.

8.6 Procedure—Using the apparatus in 8.3, clamp or secure the specimen in a fixed vertical position on its 12 in. (305 mm) dimension edge (see Fig. 1 for test setup schematic. If necessary, modify the flexural strength test equipment to conduct the core, end, and edge hardness test). Place this test surface not less than 1 in. (25 mm) above the grip of the specimen holder. Conduct three tests spaced approximately 4 in. (102 mm) apart on each specimen, with the first test area $2 \pm \frac{1}{8}$ in. (51 ± 13 mm) from one edge of the specimen. Position the steel punch over the test area and apply the load. Report as the core, end, or edge hardness the load required to push the steel punch a distance of $\frac{1}{8}$ in. (13 mm) into the core of the specimen.

8.6.1 Procedure for Core Hardness—Test in three locations on either of the 12-in. (305 mm) saw cut edges of each specimen.

8.6.2 Procedure for End Hardness—Test in three locations on the 12-in. (305 mm) mill-cut end of each specimen.

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Michael Seilmaier



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