



Designation: C390 – 08 (Reapproved 2024)

Standard Practice for Sampling and Acceptance of Thermal Insulation Lots¹

This standard is issued under the fixed designation C390; 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.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 This practice covers criteria for establishing the acceptability of lots of shipments of preformed board, preformed block and pipe, and batts and blanket thermal insulation based on sampling and inspection.

1.2 This practice is intended for use in conjunction with appropriate ASTM material specifications that classify and describe the specific physical requirements for the product in terms of qualification requirements and inspection requirements. Determination of nonconformity shall be based on the tolerances for individual sample test values prescribed in the material specification.

1.3 This practice may require inspection substantially different from that performed in the normal course of production. If the purchaser requires sampling and acceptance inspection in accordance with this practice, he shall so specify in the order or contract.

1.4 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.5 *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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.6 *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.*

¹ This practice is under the jurisdiction of ASTM Committee C16 on Thermal Insulation and is the direct responsibility of Subcommittee C16.31 on Chemical and Physical Properties.

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2. Referenced Documents

2.1 *ASTM Standards:*²

C168 Terminology Relating to Thermal Insulation

E2234 Practice for Sampling a Stream of Product by Attributes Indexed by AQL

3. Terminology

3.1 *Definitions*—Definitions pertaining to thermal insulating materials are defined in Terminology C168.

3.1.1 *acceptable quality level (AQL)*—when a continuous series of lots is considered, the quality level which for purposes of sampling inspection is the limit of a satisfactory process average. The listed AQL (AQL=10%) is the maximum percent defective level accepted 95 % of the time by the sampling plan.

3.1.2 *acceptance number*—the maximum number of the nonconformities or nonconforming units in the sample that will permit acceptance of the inspected lot or batch.

3.1.3 *inspection*—the process of measuring, examining, testing, gaging, or otherwise comparing the unit with the applicable requirements.

3.1.4 *inspection lot*—a collection of units of product from which a sample is drawn and inspected to determine conformance with the acceptability criteria.

3.1.4.1 *Discussion*—An inspection lot may differ from a lot defined for other purposes.

3.1.5 *inspection, normal*—inspection that is used in accordance with an acceptance sampling scheme when a process is considered to be operating at, or slightly better than, its acceptable quality level.

3.1.6 *inspection, tightened*—a feature of a sampling scheme using stricter acceptance criteria than those used in normal inspection. Tightened inspection is used in some sampling schemes as a protective measure to increase the probability of rejecting lots when experience shows the level of submitted quality has deteriorated significantly.

3.1.6.1 *Discussion*—It is expected that the higher rate of

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.

rejections inherent with tightened inspection will lead the supplier to improve the quality of the submitted product. The criteria for determining when quality has deteriorated significantly must be defined in objective terms for any given sampling scheme.

3.1.7 *lot (batch)*—a definite quantity of some product manufactured under conditions of production that are considered uniform.

3.1.8 *lot size*—the number of units in a lot or inspection lot.

3.1.9 *nonconforming unit*—a unit of product or service containing at least one nonconformity.

3.1.10 *nonconformity*—a departure of a quality characteristic from its intended level or state that occurs with a severity sufficient to cause the product or service not to meet a specification requirement.

3.1.11 *sample*—a group of units, portion of material, or observations taken from the inspection lot that serves to provide information that may be used as a basis for making a decision concerning the lot being inspected.

3.1.12 *sample size*—the number of units in a sample or the number of observations in a sample.

3.1.13 *unit*—an object on which a measurement or observation may be made.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *lot*—an *inspection lot* as defined in 3.1.4.

3.2.2 *shipping package*—the smallest discrete package of thermal insulation for purposes of shipping. Typically, a shipping package is one roll, bundle, bag, or carton of thermal insulation.

3.2.3 *unit*—a *shipping package* as described in 3.2.2.

4. Significance and Use

4.1 The sampling and inspection prescribed in this practice afford the purchaser a practical level of quality assurance on incoming material. They are based on cost/risk relationships considered typical for preformed thermal insulations offered for general use. In all cases, the purchaser should review this practice and determine its suitability in terms of his specific needs.

4.2 This procedure is intended primarily for the inspection of a continuing stream of lots, and there is not a high probability of rejecting occasional off lots. Consumer protec-

tion is based on economic pressure on the producer, through greater risk of lot rejection, to maintain the process average at 90 % conformance or better. Operating characteristic curves for the sampling plans employed can be found in Practice E2234, Table X-C through Table X-F.

4.3 It is not the intent of this procedure to estimate lot quality, control the quality of production, relieve the supplier of responsibility for the quality of material offered, or determine the disposition of material found to be defective after receipt by the purchaser.

5. Classification of Requirements

5.1 ASTM material specifications shall classify physical requirements in two categories:

5.1.1 *Qualification Requirements*—Those requirements which establish the general suitability of the product but are not judged necessary, or practical, for routine inspection. These requirements usually relate to the inherent properties of the material, involve high inspection costs, require long-term tests, or are controlled indirectly by other requirements.

5.1.2 *Inspection Requirements*—Those requirements which can and should be monitored on a routine basis. These requirements are characterized by a high benefit/cost ratio. They may include visual and dimensional requirements, requirements for properties with potentially high variability, or requirements providing indirect control of performance characteristics.

6. Acceptance for Qualification Requirements

6.1 The supplier's certificate of compliance or a third party's certificate of compliance shall be sufficient basis for acceptance of the lot for qualification requirements.

6.1.1 The certificate shall state that compliance to the qualification requirements has been verified by actual inspection of material manufactured within the past three years using the same basic ingredients and manufacturing process as the material offered.

6.1.2 The supplier shall furnish an inspection report upon request.

7. Acceptance for Inspection Requirements

7.1 The acceptance of a lot for inspection requirements shall be based on the sampling plans and acceptance criteria prescribed in Table 1 (preformed board, and preformed block

TABLE 1 Sampling Plan and Acceptance Criteria for Inspection Requirements^A (Preformed Board, and Preformed Block and Pipe)

Lot Size (Shipping Units)	Normal Inspection		Tightened Inspection	
	Sample Size (Shipping Packages)	Acceptance Number, Maximum Number of Nonconforming Units	Sample Size (Shipping Packages)	Acceptance Number, Maximum Number of Nonconforming Units
150 or less	see 7.3	see 7.3	5	1
151 to 1200	5	1	8	1
1201 to 35 000	8	2	8	1
35 000 and over	13	3	13	2

^A The plan for normal inspection of lot sizes of 151 units and over, and the entire plan for tightened inspection are taken from Practice E2234, using Special Inspection Level S-2, AQL = 10 %.