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**Rubber- or plastics-coated fabrics —  
Measurement of gas permeability**

*Supports textiles revêtus de caoutchouc ou de plastique — Mesure de  
la perméabilité aux gaz*

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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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

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. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document was prepared by Technical Committee ISO/TC 45, *Rubber and rubber products*, Subcommittee SC 4, *Products (other than hoses)*.

This third edition cancels and replaces the second edition (ISO 7229:2015), which has been technically revised.

The main changes are as follows:

- in 5.4, Figure 1 has been divided into a) and b);
- in 6.3.10,  $\theta$  (delay time) has been added to the key in Figure 3.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at [www.iso.org/members.html](http://www.iso.org/members.html).

## Introduction

The measurement of the permeability of rubber-or plastics-coated fabrics to gases is important in the evaluation of materials for products such as leisure boats, balloons or hoses, and other gas containers in addition to the materials for seals and diaphragms. The permeability of the material is crucial when a product is exposed to differential pressure conditioned environment in its service field.

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# Rubber- or plastics-coated fabrics — Measurement of gas permeability

**WARNING** — Persons using this document should be familiar with normal laboratory practice. This document 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 conform to any national regulatory conditions.

## 1 Scope

This document specifies two methods for measuring gas transmission through rubber- or plastics-coated fabrics, a property known as permeability.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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 2231, *Rubber- or plastics-coated fabrics — Standard atmospheres for conditioning and testing*

ISO 2286-3, *Rubber- or plastics-coated fabrics — Determination of roll characteristics — Part 3: Method for determination of thickness*

## 3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

### 3.1

#### **gas transmission rate**

volume of test gas passing through a test piece per unit area, per unit time with unit partial-pressure difference between the two sides of the test piece

### 3.2

#### **gas permeability coefficient**

volume of test gas passing through a test piece of unit thickness, per unit area, per unit time with unit partial-pressure difference between the two sides of the test piece

### 3.3

#### **gas transmission curve**

curve plotted against time, in the pressure sensor method, of the pressure change on the low-pressure side of the test cell until the gas transmission reaches a steady state after starting the test

Note 1 to entry: See [Figure 3](#).

## 4 Principle

A test piece is placed between two parts of a hermetically sealed measurement cell. Each part of the cell is vacuumed, then one part is filled with test gas to a certain pressure level. The quantity of gas that permeates through the test piece to the lower pressure side is measured and determined by a pressure sensor or by a gas chromatograph. In the gas chromatograph method, measurement condition using equal pressure between two parts of the cell divided by the test piece is given for information in [Annex A](#).

## 5 Test pieces

### 5.1 Shape and dimensions

The test piece shall be of uniform shape and have a thickness of more than 0,10 mm and less than 4,00 mm. When using test pieces other than this, the thickness shall be agreed between the interested parties. The test piece shall be large enough to cover the full area of the test cell.

### 5.2 Measurement of thickness

Measure the thickness of the test piece at five or more points including the centre part of the gas transmission area to the nearest 0,01 mm in accordance with ISO 2286-3 and take the arithmetic mean.

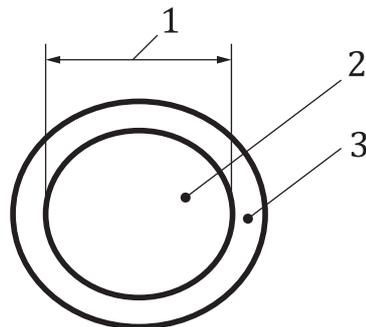
### 5.3 Number of test pieces

Three or more test pieces shall be used.

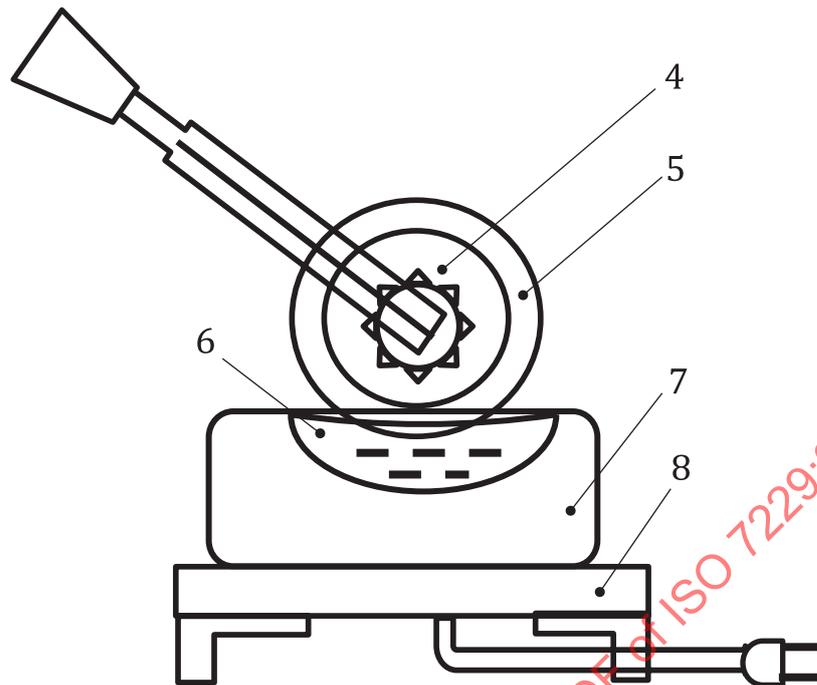
### 5.4 Sealing and masking

A substrate generally passes gas much more easily than coating materials, and even after the test piece is fixed in the cell, the test gas permeated through the coating material can leak out of the cell through the substrate. Cross section cut at the edge around the test piece shall be sealed or masked with wax or a solid type of adhesive which shall not cause any crack nor affect the gas permeability of the test piece during the test.

When a test piece of single-faced coated fabric is used, the surface of the fabric substrate outside the gas permeability measurement area shall be masked besides the edge as shown in [Figure 1](#) a) and b).



a) Test piece



**b) Sealing and masking equipment**

**Key**

1	10 mm – 150 mm (see 6.1.1)	5	test piece
2	gas transmission area <i>A</i> (see 5.7)	6	wax or adhesives
3	sealing and masking zone	7	vessel
4	plate to support for test piece	8	heater

**Figure 1 — Example of the sealing and masking equipment**

## 5.5 Conditioning

The minimum time between vulcanization and commencement of conditioning of test pieces shall be 16 h.

Unless otherwise required in the material specification, the material shall be conditioned before testing for 16 h to 24 h using the method of conditioning “1” specified in ISO 2231. When using a test piece that can be easily affected by moisture, dry it for more than 48 h at test temperature in a desiccator containing a suitable drying agent such as anhydrous calcium chloride.

## 5.6 Test atmosphere

**5.6.1** Laboratory conditions shall be  $(23 \pm 2)$  °C (atmosphere “D”), in accordance with ISO 2231.

**5.6.2** When conducting test at a temperature different from the standard laboratory temperature, the temperature shall be agreed between the interested parties. The test temperature shall be recorded.

## 5.7 Gas transmission area

The gas transmission area *A* (m<sup>2</sup>) shall be calculated from the internal diameter of the test cell. If a sealing ring is used, calculate the gas transmission area from its internal diameter.

## 6 Pressure sensor method

### 6.1 Apparatus

The testing apparatus consists of the test cell, pressure sensors, test gas supply reservoir, vacuum pump and associated pipes and valves. An example of the testing apparatus is shown in [Figure 2](#).

**6.1.1 Test cell**, consisting of a low-pressure side and a high-pressure side, such that when a test piece is mounted in it, the gas transmission area is clearly defined. The high-pressure side has an inlet port to the supply test gas, and a pressure sensor is connected to the low-pressure side to detect the change of pressure caused by the transmitted gas. The mounting surfaces of the cell touching the sample shall be smooth and flat to prevent leakage of gas. The material of the test cell shall be inactive with regard to the test gas and shall not absorb the gas used. A seal such as an O-ring may be used to seal between the face of the test cell and the test piece, in which case, the transmission rate of the seal shall be considerably smaller than that of a test piece so that it does not affect the result of gas transmission test. The diameter of the gas transmission surface shall be within the range of 10 mm to 150 mm according to the range of gas transmission rates expected. The cell may be equipped with an electric or hot water heating jacket system capable of raising the temperature up to 80 °C. The temperature accuracy shall be controlled within  $\pm 2$  °C from 40 °C to 80 °C.

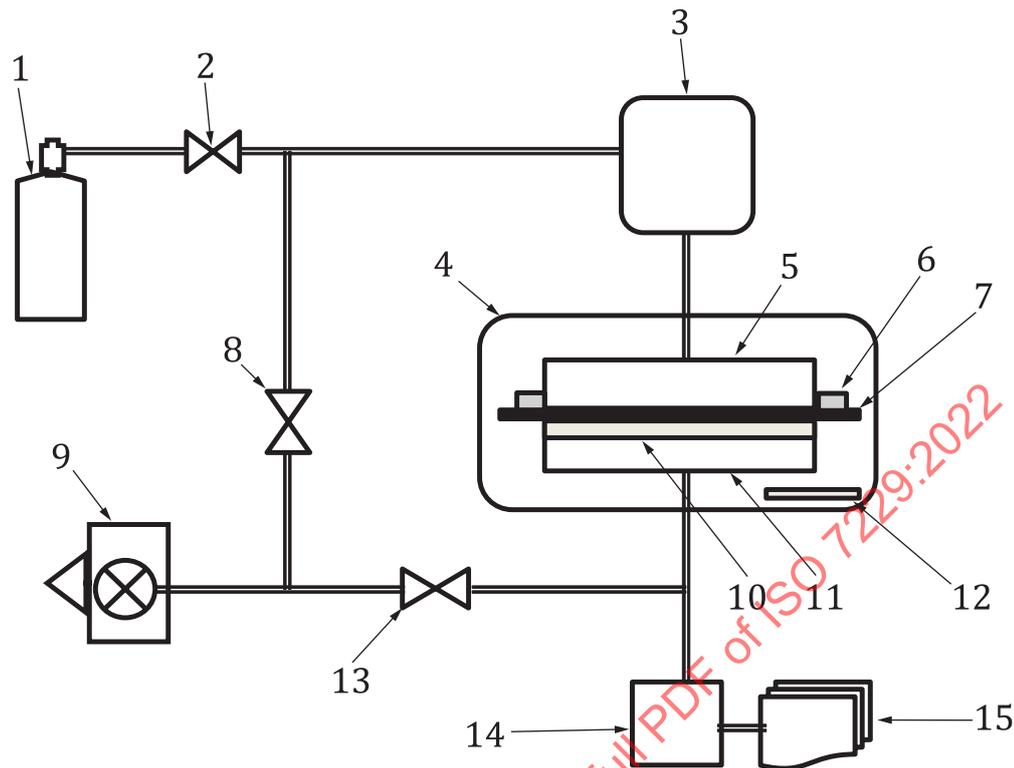
**6.1.2 Test piece support**, installed in the low-pressure side in order to prevent the deformation of the test piece due to the pressure difference. Any material such as filter paper or wire mesh that does not affect the result of gas transmission test may be used. When using filter paper, paper such as that used in chemical analysis is recommended, of thickness 0,1 mm to 0,3 mm according to the depth of low-pressure side of the cell.

**6.1.3 Pressure sensors**, a) to measure the change in pressure on the low-pressure side of the cell, capable of reading at least to 5 Pa — vacuum gauge with no mercury, an electronic diaphragm-type sensor or other suitable sensor shall be used; b) to measure the pressure of the test gas supply tank, capable of reading at least to 100 Pa.

**6.1.4 Test gas supply reservoir**, with a pressure control system to supply test gas to the high-pressure side at a constant pressure. The volume of the reservoir shall be sufficient to ensure that the pressure drop on the high-pressure side due to the transmission of the test gas to the lower pressure side through a test piece is controlled within at least 1 % or less.

**6.1.5 Vacuum pump**, capable of evacuating the test cell to 10 Pa or lower.

**6.1.6 Temperature sensor**, installed in the test cell for measuring test temperature, and capable of reading at least to 0,1 °C.



### Key

1	test gas tank	9	vacuum pump
2	valve 1	10	test piece support
3	test gas supply reservoir	11	low pressure side of test cell
4	test cell	12	temperature sensor
5	high pressure side of test cell	13	valve 3
6	sealing ring	14	pressure sensor
7	test piece	15	data processor
8	valve 2		

Figure 2 — Example of apparatus for gas permeability measurement (pressure sensor method)

## 6.2 Test gas

Use a single gas or a mixture of gases such as air, nitrogen, oxygen, hydrogen, liquefied petroleum gas (in gaseous form) and coal gas. The purity of the single gas or the purity of each component used in the gas mixture shall be 99,5 % of the volume fraction or higher. When using a gas of purity less than this, it shall be agreed between the interested parties. The test gas shall not include any impurity that can affect the measurement.

**WARNING** — When using a toxic gas and/or inflammable gas, necessary measures shall be taken in its use and recovery.

## 6.3 Procedure

6.3.1 Install a suitable test piece support (key 10 in [Figure 2](#)) on the low-pressure side of the test cell.

6.3.2 Lightly and uniformly apply vacuum grease to the surface of the test cell where the test piece touches and mount the test piece on this surface without any wrinkle or sag.

**6.3.3** Place a sealing ring (if used) on the test piece, followed by the upper part of cell. Clamp the two halves of the cell together with uniform pressure so that the test piece is completely sealed in place.

**6.3.4** When making measurements at a different temperature from a standard laboratory temperature, bring the test cell to the test temperature.

**6.3.5** Close valve 1 (key 2 in [Figure 2](#)) and valve 2 (key 8), and open valve 3 (key 13). Start the vacuum pump and then open valve 2 (key 8). Air will be evacuated first from the low-pressure side, followed by the high-pressure side so that the test piece stays close to the test piece support. Continue until evacuation is complete. Since it is necessary to thoroughly remove any absorbed gas, allow sufficient exhaustion time for a test piece of low gas transmission rate to be thoroughly degassed.

The exhaustion time required will differ for different types of samples and different conditioning. For those of low gas transmission rate, overnight is suggested. Long-time exhaustion can remove sample's vaporized component depending on the type of sample.

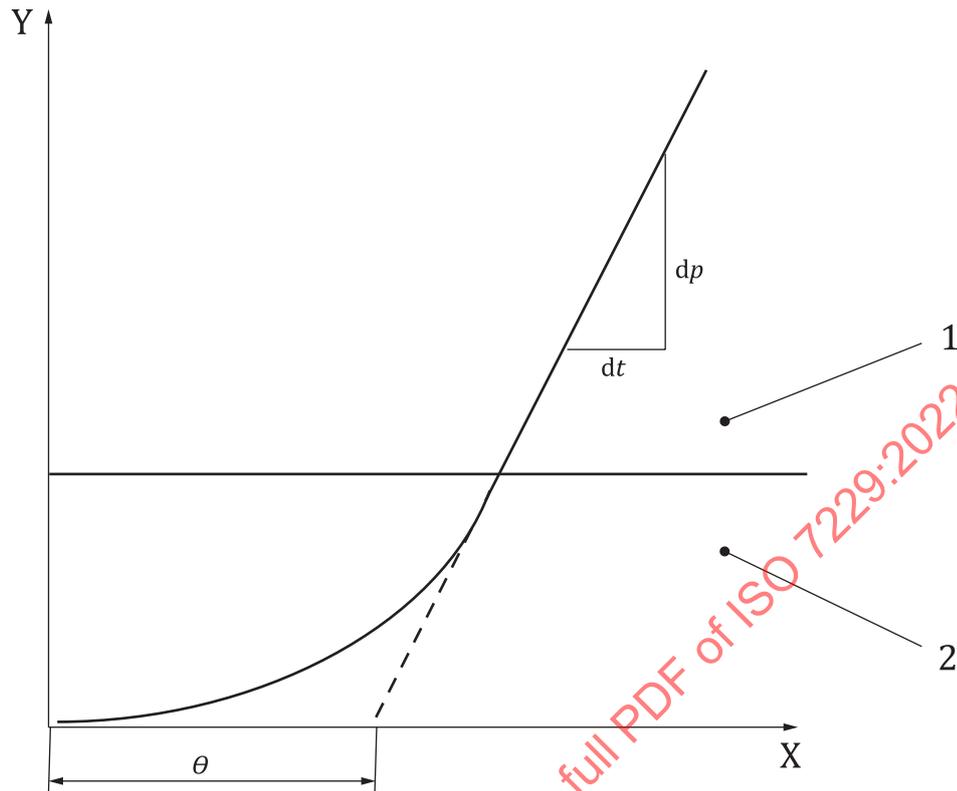
**6.3.6** Close valve 2 (key 8) and valve 3 (key 13) to maintain the pressure on both the low-pressure side and high-pressure side at 10 Pa or less. Stop the vacuum pump.

**6.3.7** If the pressure on the low-pressure side rises, repeat steps [6.3.2](#) to [6.3.6](#) since there is a possibility of gas leakage or there is gas absorbed by the sample.

**6.3.8** Introduce the test gas into the high-pressure side by opening valve 1 (key 2), shutting off the gas supply when the pressure has reached the pressure level ( $P_u$ ) set in the test gas supply reservoir. Keep the pressure of high-pressure side consistent with the accuracy of 1 % or less. Record the pressure  $P_u$  and the temperature  $T$  when the pressure on the low-pressure side starts increasing due to the permeation of the test gas.

**6.3.9** Draw the gas transmission curve by plotting the pressure on low pressure side against time. Continue taking measurements until a constant rate of gas transmission has been reached as indicated by a straight-line (see [Figure 3](#)). A gas transmission curve plotted by automatic recording may also be used.

**6.3.10** Determine the slope of the straight-line portion of the transmission curve ( $dp/dt$ , see [Figure 3](#)). The slope may also be determined automatically from the recorder.

**Key**

- X time (h)
- Y pressure (kPa)
- $\theta$  delay time
- 1 steady-state region
- 2 non-steady-state region

Figure 3 — Gas transmission curve

## 6.4 Calculation and expression of results

### 6.4.1 Gas transmission rate

The gas transmission rate is determined using [Formula \(1\)](#):

$$R = \frac{V_C}{P_0 \times (T/T_0) \times P_u \times A} \times \frac{dp}{dt} \quad (1)$$

where

- $R$  is the gas transmission rate (GTR) ( $\text{cm}^3/\text{m}^2 \cdot 24 \text{ h} \cdot \text{Pa}$ );
- $V_C$  is the volume of the low-pressure side of test cell ( $\text{cm}^3$ );
- $P_0$  is the standard atmospheric pressure (Pa) (= 101 325);
- $T$  is the test temperature (K);
- $T_0$  is the standard state temperature (K) (= 273,15);

$P_u$  is the pressure of test gas in the high-pressure side of test cell (Pa);

$A$  is the gas transmission area (m<sup>2</sup>);

$dp/dt$  is the pressure change of low-pressure side cell per unit time (Pa/24 h).

Express the gas transmission rate as the arithmetic mean of the results obtained for all the test pieces.

#### 6.4.2 Gas permeability coefficient

The gas permeability coefficient is determined using [Formula \(2\)](#):

$$Q = R \times d \quad (2)$$

where

$Q$  is the gas permeability coefficient (cm<sup>3</sup>·m/m<sup>2</sup>·24 h·Pa);

$R$  is the gas transmission rate (GTR) (cm<sup>3</sup>/m<sup>2</sup>·24 h·Pa);

$d$  is the thickness of the test piece (m).

Express the gas transmission rate as the arithmetic mean of the results obtained for all the test pieces.

## 7 Gas chromatography method

### 7.1 Apparatus

The test apparatus consists of a test cell, a gas chromatograph, a test gas controller, a sampling loop, and a vacuum pump and associated pipes and valves. An example of the apparatus is shown in [Figure 4](#).

**7.1.1 Test cell**, in accordance with [6.1.1](#).

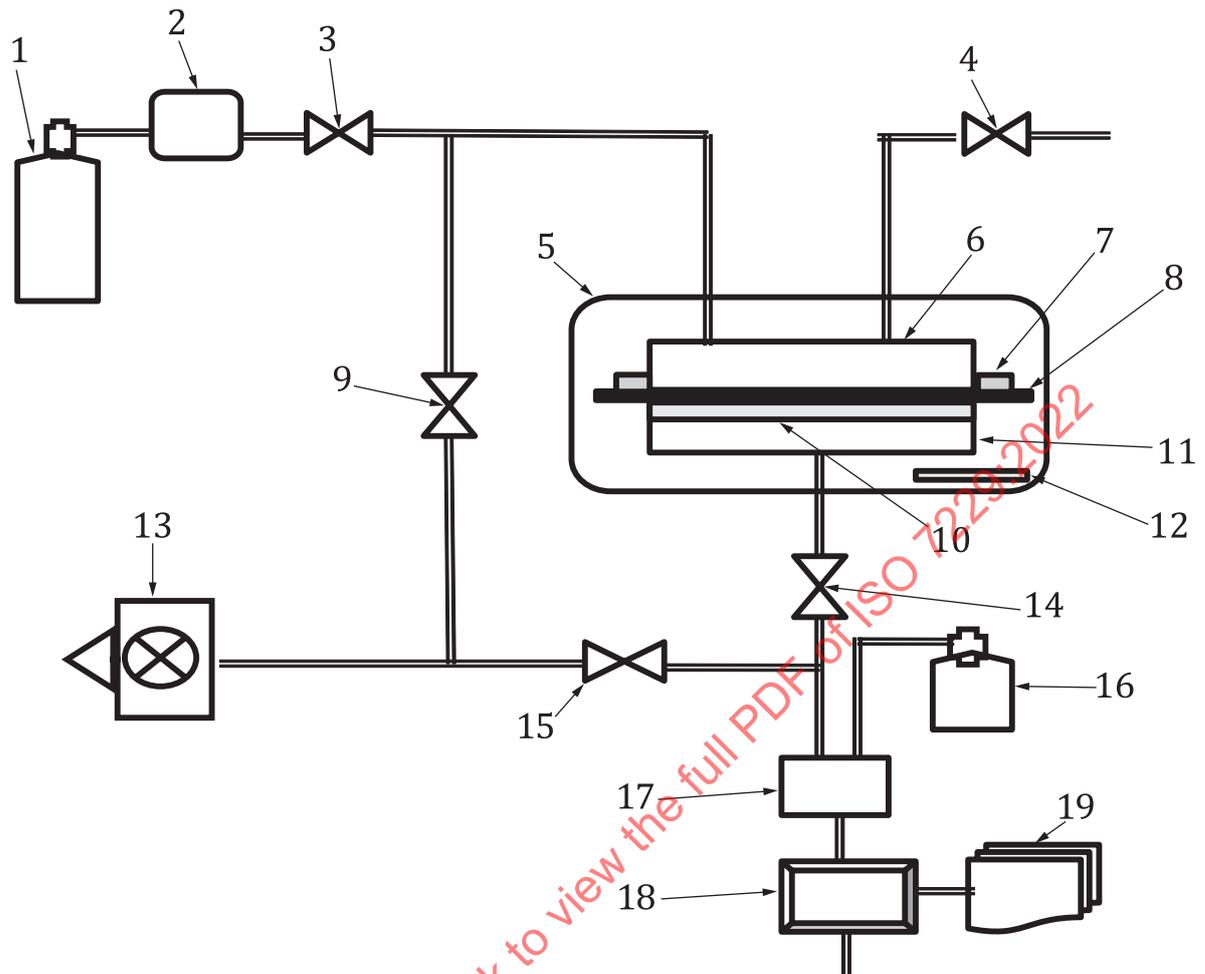
**7.1.2 Test piece support**, in accordance with [6.1.2](#).

**7.1.3 Gas chromatograph**, having a detector such as thermal conductivity detector (TCD) or hydrogen flame ion detector (FID). The detector and the column shall be suitable for the test gas used and of the required sensitivity. The gas chromatograph shall be able to measure the quantity of permeated gas with an accuracy of at least 5 Pa, expressed in terms of the pressure of the gas.

**7.1.4 Test gas controller**, capable of controlling the test gas flow and pressure, and of maintaining them constant. A flowmeter having at least ±3 % accuracy shall be used.

**7.1.5 Vacuum pump**, in accordance with [6.1.5](#).

**7.1.6 Temperature sensor**, in accordance with [6.1.6](#).



### Key

- |    |                                 |    |                                |
|----|---------------------------------|----|--------------------------------|
| 1  | test gas tank                   | 11 | low pressure side of test cell |
| 2  | test gas controller             | 12 | temperature sensor             |
| 3  | valve 1                         | 13 | vacuum pump                    |
| 4  | valve 2                         | 14 | valve 4                        |
| 5  | test cell                       | 15 | valve 5                        |
| 6  | high pressure side of test cell | 16 | carrier gas tank               |
| 7  | sealing ring                    | 17 | sampling loop                  |
| 8  | test piece                      | 18 | gas chromatograph              |
| 9  | valve 3                         | 19 | data processor                 |
| 10 | test piece support              |    |                                |

**Figure 4 — Example of apparatus for gas permeability measurement (gas chromatograph method)**

## 7.2 Test gas

See [6.2](#).

## 7.3 Carrier gas

Use a suitable carrier gas of purity preferably greater than 99,99 % by volume.

## 7.4 Calibration curve

Inject a known quantity of test gas into the gas chromatograph using a syringe or a gas sampler. Determine the area of the peak in the chromatogram corresponding to the gas of interest. Repeat the above measurements with at least three different levels of concentration and prepare a calibration curve from the data obtained. For mixed test gases, it is necessary to produce a calibration curve for each component of the mixture.

## 7.5 Procedure

**7.5.1** Install a suitable test piece support on the low-pressure side of the test cell.

**7.5.2** Lightly and uniformly apply some vacuum grease to the surface of the test cell which will be in contact with the test piece and mount the test piece on this surface without any wrinkle or sag.

**7.5.3** Place a sealing ring on the test piece, followed by the upper part of cell. Clamp the two halves of the cell together with uniform pressure so that the test piece is completely sealed in place.

**7.5.4** When measuring at a different temperature from a standard laboratory temperature, bring the test cell to the test temperature.

**7.5.5** Close valve 1 (key 3 in [Figure 4](#)), valve 2 (key 4) and valve 3 (key 9), and open valve 4 (key 14) and valve 5 (key 15). Start the vacuum pump. Then open valve 3 (key 9). Air will be evacuated first from the low-pressure side cell, followed by the high-pressure side cell so that the test piece stays close to the test piece support. Continue until the evacuation is complete. Since it is necessary to thoroughly remove the absorbed gas, allow sufficient exhaustion time for test pieces of low gas transmission rate.

The exhaustion time will differ for different types of samples and different conditioning. For those of low gas transmission rate, overnight is suggested. It is possible that long-time exhaustion will remove the sample's vaporized component depending on the type of sample.

**7.5.6** When all the air has been evacuated, stop evacuating the high-pressure side of test cell by closing valve 3 (key 9). Introduce the test gas into the high-pressure side through the test gas controller (key 2) by opening valve 1 (key 3) and maintain the high-pressure side at a constant pressure ( $P_u$ ). The test gas will start permeating from high-pressure side to low-pressure side and will be evacuated by the vacuum pump. Record the pressure  $P_u$  and the temperature  $T$ .

**7.5.7** Close valve 5 (key 15), to collect permeated gas in the sampling loop (key 17). After a predetermined time  $t$ , close valve 4 (key 14) and sweep the gas from the sampling loop (key 17) into the chromatographic column (key 18) with the carrier gas (key 16). Measure the area of the peak in the chromatogram corresponding to the gas of interest. Determine, from the calibration curve prepared in [7.4](#), the amount of gas volume  $D_v$ , which is collected in the sampling loop during time  $t$ .

NOTE A suitable predetermined time  $t$  differs depending on the gas permeability of the sample.

**7.5.8** Repeat the procedure from [7.5.5](#) to [7.5.7](#) until a steady-state is reached. The steady-state is assumed to have been reached when the measurement of the amount of gas which permeates the test piece in time  $t$  is substantially constant. A gas transmission curve plotted by automatic recording may also be used.

**7.5.9** Either before or after the test, carry out a blank test to determine the blank quantity of transmitted test gas  $D_b$ . Do this by simultaneously closing valve 1 (key 3) and valve 3 (key 9), thus trapping the gas which is flowing through the loop under the steady-state conditions and subsequently determining the amount of gas  $D_b$  trapped in time  $t$ .

## 7.6 Calculation and expression of results

### 7.6.1 Gas transmission rate

Gas transmission rate is determined from the following [Formula \(3\)](#):

$$R = \frac{(D_v - D_b) \times k}{(T / T_0) \times A \times (t / 1440) \times P_u} \quad (3)$$

where

- $R$  is the gas transmission rate (GTR) ( $\text{cm}^3/\text{m}^2 \cdot 24 \text{ h} \cdot \text{Pa}$ );
- $T$  is the test temperature (K);
- $T_0$  is the standard state temperature (K) (= 273,15);
- $t$  is the time during which test gas is collected in the sampling loop (min);
- $D_b$  is the blank quantity of transmitted test gas ( $\text{cm}^3$ );
- $D_v$  is the measured quantity of transmitted test gas ( $\text{cm}^3$ );
- $P_u$  is the pressure of test gas in the high-pressure side of test cell (Pa);
- $A$  is the gas transmission area ( $\text{m}^2$ );
- $k$  is the device constant for determining the total volume of the low-pressure side.

NOTE The value  $k$  is the ratio of the total volume of the low-pressure side including pipes and sample loop to the volume of the sample loop which is actually used for trapping the transmitted test gas. The value depends on the particular type of apparatus and is given by the manufacturer.

Express the gas transmission rate as the average of the results obtained for all the test pieces.

### 7.6.2 Gas permeability coefficient

The gas permeability coefficient is determined using [Formula \(4\)](#):

$$Q = R \times d \quad (4)$$

where

- $Q$  is the gas permeability coefficient ( $\text{cm}^3 \cdot \text{m}/\text{m}^2 \cdot 24 \text{ h} \cdot \text{Pa}$ );
- $R$  is the gas transmission rate (GTR) ( $\text{cm}^3/\text{m}^2 \cdot 24 \text{ h} \cdot \text{Pa}$ );
- $d$  is the thickness of the test piece (m).

Express the gas transmission rate as the arithmetic mean of the results obtained for all the test pieces.

## 8 Test report

The test report shall include the following information:

- a) test piece details:
  - 1) a full description of the test piece and its origin;
  - 2) the method of pretreatment of the test piece (e.g. sealing, masking, or both);

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- 3) the type of test pieces used;
- b) test method:
  - 1) a reference to this document including its year of publication, i.e. ISO 7229:2022;
  - 2) the test method used (sensor or gas-chromatograph);
- c) test details:
  - 1) the laboratory temperature;
  - 2) the time and temperature of conditioning prior to test;
  - 3) details of any procedures not specified in this document;
- d) test results:
  - 1) the number of test pieces used;
  - 2) the individual test results;
  - 3) the mean results;
- e) test gas:
  - 1) the gas used for measuring permeability;
  - 2) if gas mixture is used, its composition and density;
- f) date(s) of the test.

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## Annex A (informative)

### Gas chromatography method with equal pressure condition

#### A.1 General

A test cell, maintained at atmospheric pressure, is divided into supply side and transmission side by the test piece (see [Figure A.1](#)). The test gas is supplied to the supply side and a carrier gas is passed through the transmission side. The pressure on both sides of the cell is equal and constant. The quantity of test gas passing through the sample is measured by gas chromatograph. In this method, measurements using a test gas containing water vapour and component analysis (if a mixed test gas is used) are also possible.

#### A.2 Apparatus

The test apparatus is the same as given in [7.1](#). An example of the test apparatus assembled is shown in [Figure A.1](#).

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