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Plastics — Polypropylene (PP) moulding and extrusion materials —

Part 2: Preparation of test specimens and determination of properties

Plastiques — Polypropylène (PP) pour moulage et extrusion —

Partie 2: Préparation des éprouvettes et détermination des propriétés

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Foreword

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International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. 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.

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.

ISO 1873-2 was prepared by Technical Committee ISO/TC 61, *Plastics*, Subcommittee SC 9, *Thermoplastic materials*.

This third edition cancels and replaces the second edition (ISO 1873-2:1997), which has been technically revised. It also incorporates the Amendment ISO 1873-2:1997/Amd.1:2000.

ISO 1873 consists of the following parts, under the general title *Plastics — Polypropylene (PP) moulding and extrusion materials*:

— *Part 1: Designation system and basis for specifications*

— *Part 2: Preparation of test specimens and determination of properties*

Plastics — Polypropylene (PP) moulding and extrusion materials —

Part 2: Preparation of test specimens and determination of properties

1 Scope

This part of ISO 1873 specifies the methods of preparation of test specimens and the test methods to be used in determining the properties of PP moulding and extrusion materials. Requirements for handling test material and for conditioning both the test material before moulding and the specimens before testing are given.

Procedures and conditions for the preparation of test specimens and procedures for measuring properties of the materials from which these specimens are made are given. Properties and test methods which are suitable and necessary to characterize PP moulding and extrusion materials are listed.

The properties have been selected from the general test methods in ISO 10350-1. Other test methods in wide use for, or of particular significance to, these moulding and extrusion materials are also included in this part of ISO 1873, as are the designatory properties specified in Part 1.

In order to obtain reproducible and comparable test results, it is necessary to use the methods of preparation and conditioning, the specimen dimensions and the test procedures specified herein. Values determined will not necessarily be identical to those obtained using specimens of different dimensions or prepared using different procedures.

2 Normative references

The following referenced documents are indispensable for the application 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 62, *Plastics — Determination of water absorption*

ISO 75-2, *Plastics — Determination of temperature of deflection under load — Part 2: Plastics and ebonite*

ISO 178, *Plastics — Determination of flexural properties*

ISO 179-1, *Plastics — Determination of Charpy impact properties — Part 1: Non-instrumented impact test*

ISO 179-2, *Plastics — Determination of Charpy impact properties — Part 2: Instrumented impact test*

ISO 293, *Plastics — Compression moulding of test specimens of thermoplastic materials*

ISO 294-1, *Plastics — Injection moulding of test specimens of thermoplastic materials — Part 1: General principles, and moulding of multipurpose and bar test specimens*

ISO 294-3, *Plastics — Injection moulding of test specimens of thermoplastic materials — Part 3: Small plates*

ISO 294-4, *Plastics — Injection moulding of test specimens of thermoplastic materials — Part 4: Determination of moulding shrinkage*

ISO 527-2, *Plastics — Determination of tensile properties — Part 2: Test conditions for moulding and extrusion plastics*

ISO 899-1, *Plastics — Determination of creep behaviour — Part 1: Tensile creep*

ISO 1133:2005, *Plastics — Determination of the melt mass-flow rate (MFR) and the melt volume-flow rate (MVR) of thermoplastics*

ISO 1183-1, *Plastics — Methods for determining the density of non-cellular plastics — Part 1: Immersion method, liquid pyknometer method and titration method*

ISO 1183-2, *Plastics — Methods for determining the density of non-cellular plastics — Part 2: Density gradient column method*

ISO 1183-3, *Plastics — Methods for determining the density of non-cellular plastics — Part 3: Gas pyknometer method*

ISO 1628-3, *Plastics — Determination of the viscosity of polymers in dilute solution using capillary viscometers — Part 3: Polyethylenes and polypropylenes*

ISO 2818, *Plastics — Preparation of test specimens by machining*

ISO 3167, *Plastics — Multipurpose test specimens*

ISO 4589-2, *Plastics — Determination of burning behaviour by oxygen index — Part 2: Ambient-temperature test*

ISO 6603-2, *Plastics — Determination of puncture impact behaviour of rigid plastics — Part 2: Instrumented impact testing*

ISO 8256, *Plastics — Determination of tensile-impact strength*

ISO 10350-1, *Plastics — Acquisition and presentation of comparable single-point data — Part 1: Moulding materials*

ISO 11357-2, *Plastics — Differential scanning calorimetry (DSC) — Part 2: Determination of glass transition temperature*

ISO 11357-3, *Plastics — Differential scanning calorimetry (DSC) — Part 3: Determination of temperature and enthalpy of melting and crystallization*

ISO 11359-2, *Plastics — Thermomechanical analysis (TMA) — Part 2: Determination of coefficient of linear thermal expansion and glass transition temperature*

ISO 16152, *Plastics — Determination of xylene-soluble matter in polypropylene*

IEC 60093, *Methods of test for volume resistivity and surface resistivity of solid electrical insulating materials*

IEC 60112, *Method for the determination of the proof and the comparative tracking indices of solid insulating materials*

IEC 60243-1, *Electrical strength of insulating materials — Test methods — Part 1: Tests at power frequencies*

IEC 60250, *Recommended methods for the determination of the permittivity and dielectric dissipation factor of electrical insulating materials at power, audio and radio frequencies including metre wavelengths*

IEC 60296, *Fluids for electrotechnical applications — Unused mineral insulating oils for transformers and switchgear*

IEC 60695-11-10, *Fire hazard testing — Part 11-10: Test flames — 50 W horizontal and vertical flame test methods*

ASTM D 5420, *Standard Test Method for Impact Resistance of Flat, Rigid Plastic Specimen by Means of a Striker Impacted by a falling Weight (Gardner Impact)*

3 Preparation of test specimens

3.1 General

It is essential that specimens are always prepared by the same procedure (either injection moulding or compression moulding), using the same processing conditions.

The procedure to be used for each test method is indicated in Tables 3 and 4 (M = injection moulding, Q = compression moulding).

3.2 Treatment of the material before moulding

Before processing, no pre-treatment of the material sample is normally necessary.

3.3 Injection moulding

Injection-moulded specimens shall be prepared in accordance with ISO 294-1 or ISO 294-3, using the conditions specified in Table 1. Work which has been carried out indicates that rectangular bar test specimens machined from the central part of ISO 3167 type A specimens give better precision than specimens injection-moulded directly to their final dimensions from ISO 294-1 type B moulds, and so the use of type A geometry is preferable.

NOTE Details of the work can be found at the following URL:

http://standards.iso.org/iso/1873/-2

An appropriate hold pressure, consistent with the production of blemish-free mouldings, shall be used.

Table 1 — Conditions for injection moulding of test specimens

Material	Melt temperature	Mould temperature	Average injection velocity	Hold pressure time	Total cycle time
	°C	°C	mm/s	s	s
MFR < 1,5 g/10 min	255	40	200 ± 20	40	60
1,5 ⩽ MFR < 7 g/10 min	230	40	200 ± 20	40	60
MFR ⩾ 7 g/10 min	200	40	200 ± 20	40	60

NOTE 1 The uniformity of the mouldings shall be checked by weighing. Their masses shall not differ by more than 1 % from each other.

NOTE 2 Heat-sensitive polypropylenes may undergo molecular breakdown during moulding; therefore an increase in the melt flow rate to > 1,5 times the original value shall be avoided with such materials. If the MFR increases by more than 1,5 times the original value, the melt temperature shall be lowered, 10 °C at a time, until the increase in MFR is < 1,5 times the original value. This adjustment in melt temperature shall be reported.

3.4 Compression moulding

Compression-moulded sheets shall be prepared in accordance with ISO 293 using the conditions specified in Table 2.

Table 2 — Conditions for compression moulding of test specimens

Material	Moulding temperature °C	Average cooling rate °C/min	Demoulding temperature °C	Full pressure MPa	Full-pressure time min	Preheating pressure MPa	Preheating time min
All grades	210	15 ± 5	⩽ 40	5 or 10[a]	5 ± 1	Contact	5 to 15
[a] Use 5 MPa for a frame mould and 10 MPa for a positive mould.							
NOTE Inconsistent cooling rates can lead to significant deviations in measured properties due to the effect on the crystallinity of the specimens. It is therefore desirable to use a moulding machine that is capable of maintaining a constant cooling rate.							

The test specimens required for the determination of the properties shall be machined or stamped from the compression-moulded sheets in accordance with ISO 2818.

NOTE Stamping is suitable for specimens of thicknesses up to 4 mm. Compared with milling or sawing, it imparts less stress to the specimens and deforms them less.

If a frame mould is used, it is necessary to start cooling whilst simultaneously applying the full pressure. This avoids the melt being pressed out of the frame and also avoids sink marks.

With the frame mould, the full pressure is only applied to the frame, and thus the sheets produced may suffer from insufficient homogeneity and pellet boundaries may be preserved.

4 Conditioning of test specimens

Unfilled test specimens shall be conditioned for a period of between 40 h and 96 h at 23 °C ± 2 °C, with no relative humidity requirement. Specimens containing fillers or additives that are susceptible to moisture uptake shall be conditioned in the same way but with an additional requirement for (50 ± 10) % relative humidity.

5 Determination of properties

In the determination of properties and the presentation of data, the standards, supplementary instructions and notes given in ISO 10350-1 shall be applied. Unless specifically stated in Tables 3 and 4, testing of unfilled test specimens shall be carried out at a standard temperature of 23 °C ± 2 °C, with no relative humidity requirement. Specimens made from materials containing fillers or additives that are susceptible to moisture uptake shall be tested in a standard atmosphere of 23 °C ± 2 °C and (50 ± 10) % relative humidity.

Table 3 is compiled from ISO 10350-1, and the properties listed are those which are appropriate to polypropylene (PP) moulding and extrusion materials. These properties are those considered useful for comparisons of data generated for different thermoplastics.

Table 4 contains those properties, not found specifically in Table 3, which are in wide use or of particular significance in the practical characterization of polypropylene (PP) moulding and extrusion materials.

Table 3 — General properties and test conditions (selected from ISO 10350-1)

Property		Symbol	Standard	Specimen type (dimensions in mm)	Specimen preparation[a]	Unit	Test conditions and supplementary instructions
1 Rheological properties							
1.1	Melt mass-flow rate	MFR	ISO 1133:2005	Moulding compound	—	g/10 min	Temperature 230 °C, load 2,16 kg.
1.2	Melt volume-flow rate	MVR				cm^3/10 min	Temperature 230 °C, load 2,16 kg. Use a value for the melt density of 738,6 kg/m^3 to calculate the mass-flow rate of unfilled materials.[b]
1.3	Moulding shrinkage	S_{Mp}	ISO 294-4	60 × 60 × 2	M	%	Parallel.
1.4		S_{Mn}					Normal.
2 Mechanical properties							
2.1	Tensile modulus	E_t	ISO 527-2	ISO 3167		MPa	Test speed 1 mm/min.
2.2	Yield stress	σ_y					Failure with yielding. Test speed 50 mm/min.
2.3	Yield strain	ε_y				%	
2.4	Nominal strain at break	ε_{tB}					
2.5	Stress at 50 % strain	σ_{50}				MPa	Failure without yielding. $\varepsilon_B \leqslant 10$ %: test speed 5 mm/min. $\varepsilon_B > 10$ %: test speed 50 mm/min.
2.6	Stress at break	σ_B					
2.7	Strain at break	ε_B				%	
2.8	Tensile creep modulus	$E_{tc}1$	ISO 899-1			MPa	At 1 h: Strain ⩽ 0,5 %.
2.9		$E_{tc}10^3$					At 1 000 h: Strain ⩽ 0,5 %.
2.10	Flexural modulus	E_f	ISO 178	80 × 10 × 4	M	MPa	Test speed 2 mm/min.
2.11	Charpy impact strength	a_c	ISO 179-1 or ISO 179-2	80 × 10 × 4		kJ/m^2	Edgewise impact, method 1eU. Also record type of failure.
2.12	Charpy notched impact strength	a_{cA}		80 × 10 × 4 Machined V-notch, r = 0,25			Edgewise impact, method 1eA. Also record type of failure.
2.13	Tensile notched impact strength	a_{tI}	ISO 8256	80 × 10 × 4 Machined double V-notch, r = 1		kJ/m^2	Only to be quoted if fracture cannot be obtained with notched Charpy test.
2.14	Puncture energy	W_P	ISO 6603-2	60 × 60 × 2		J	Striker velocity 4,4 m/s. Striker diameter 20 mm. Support ring diameter 40 mm. Lubricate the striker. Clamp the specimen sufficiently to prevent any out-of-plane movement of its outer regions.
2.15	Maximum puncture force	F_M				N	