
Plastics — Determination of the fluidity of plastics using capillary and slit-die rheometers

*Plastiques — Détermination de la fluidité au moyen de rhéomètres
équipés d'une filière capillaire ou plate*

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Contents

Page

Foreword	iv
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 General principles	4
5 Apparatus	4
5.1 Test device	4
5.2 Temperature control	9
5.3 Measurement of temperature and calibration	9
5.4 Measurement of pressure and calibration	10
5.5 Measurement of the volume flow rate of the sample	11
6 Sampling	11
7 Procedure	11
7.1 Cleaning the test device	11
7.2 Selection of test temperatures	11
7.3 Preparation of samples	12
7.4 Preheating	13
7.5 Determination of the maximum permissible test duration	13
7.6 Determination of test pressure at constant volume flow rate: Method 2	13
7.7 Determination of volume flow rate at constant test pressure: Method 1	13
7.8 Waiting periods during measurement	14
7.9 Measurement of extrudate swelling	14
8 Expression of results	15
8.1 Volume flow rate	15
8.2 Apparent shear rate	15
8.3 Apparent shear stress	16
8.4 True shear stress	17
8.5 True shear rate	21
8.6 Viscosity	22
8.7 Determination of extrudate swelling	22
9 Precision	23
10 Test report	24
10.1 General	24
10.2 Test conditions	24
10.3 Flow characteristics	25
10.4 Visual examination	26
Annex A (informative) Method of correcting for the influence of H/B on the apparent shear rate	27
Annex B (informative) Measurement errors	29
Annex C (informative) Uncertainties in the determination of shear viscosity by capillary extrusion rheometry testing	30
Bibliography	36

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).

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).

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: Foreword - Supplementary information

The committee responsible for this document is ISO/TC 61, *Plastics*, Subcommittee SC 5, *Physical-chemical properties*.

This third edition cancels and replaces the second edition (ISO 11443:2005), of which it constitutes a minor revision with the following changes:

- polybutene-1 (PB-1) with typical temperature range of 150 °C to 230 °C has been added in [Table 3](#);
- normative references have been updated.

Plastics — Determination of the fluidity of plastics using capillary and slit-die rheometers

1 Scope

This International Standard specifies methods for determining the fluidity of plastics melts subjected to shear stresses at rates and temperatures approximating to those arising in plastics processing. Testing plastics melts in accordance with these methods is necessary since the fluidity of plastics melts is generally not dependent solely on temperature, but also on other parameters, in particular shear rate and shear stress.

The methods described in this International Standard are useful for determining melt viscosities from 10 Pa·s to 10⁷ Pa·s, depending on the measurement range of the pressure and/or force transducer and the mechanical and physical characteristics of the rheometer. The shear rates occurring in extrusion rheometers range from 1 s⁻¹ to 10⁶ s⁻¹.

Elongational effects at the die entrance cause extrudate swelling at the die exit. Methods for assessing extrudate swelling have also been included.

The rheological techniques described are not limited to the characterization of wall-adhering thermoplastics melts only; for example, thermoplastics exhibiting “slip” effects^{[1][2]} and thermosetting plastics can be included. However, the methods used for determining the shear rate and shear viscosity are invalid for materials which are not wall-adhering. Nevertheless, this International Standard can be used to characterize the rheological behaviour of such fluids for a given geometry.

ISO 11443:2014

2 Normative references

<https://standards.iteh.ai/catalog/standards/sist/4739b9b3-6af2-4ed7-aec4-49cec748a580/iso-11443-2014>

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1133-1, *Plastics — Determination of the melt mass-flow rate (MFR) and melt volume-flow rate (MVR) of thermoplastics — Part 1: Standard method*

ISO 1133-2, *Plastics — Determination of the melt mass-flow rate (MFR) and melt volume-flow rate (MVR) of thermoplastics — Part 2: Method for materials sensitive to time-temperature history and/or moisture*

ISO 4287, *Geometrical Product Specifications (GPS) — Surface texture: Profile method — Terms, definitions and surface texture parameters*

ISO 6507-1, *Metallic materials — Vickers hardness test — Part 1: Test method*

ISO 11403-2, *Plastics — Acquisition and presentation of comparable multipoint data — Part 2: Thermal and processing properties*

3 Terms and definitions

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

3.1

Newtonian fluid

fluid for which the viscosity is independent of the shear rate and of time

3.2

non-Newtonian fluid

fluid for which the viscosity varies with the shear rate and/or with time

Note 1 to entry: For the purposes of this International Standard, this definition refers to fluids for which the viscosity varies only with the shear rate.

3.3

apparent shear stress

τ_{ap}
fictive shear stress to which the melt in contact with the die wall is subjected, expressed in pascals (Pa)

Note 1 to entry: It is calculated as the product of test pressure and the ratio of die cross-sectional area to die wall area.

3.4

apparent shear rate

$\dot{\gamma}_{ap}$
fictive shear rate that the melt at the wall would experience at the observed volume flow rate if its behaviour were Newtonian, expressed in reciprocal seconds (s^{-1})

3.5

true shear stress

τ
actual shear stress to which the melt in contact with the die wall is subjected, expressed in pascals (Pa)

Note 1 to entry: It is estimated from the test pressure p by applying corrections for entrance and exit pressure losses, or is directly determined from the melt pressure gradient in the channel.

Note 2 to entry: For the purposes of notation, the absence of a subscript is used to denote true values.

3.6

true shear rate

$\dot{\gamma}$
shear rate obtained from the apparent shear rate $\dot{\gamma}_{ap}$ by taking into account the deviations from Newtonian behaviour by appropriate correction algorithms (see Note to 8.2.2), expressed in reciprocal seconds (s^{-1})

Note 1 to entry: For the purposes of notation, the absence of a subscript is used to denote true values.

3.7

viscosity

η
viscosity in steady shear, defined as the ratio $\tau / \dot{\gamma}$ of true shear stress τ to true shear rate $\dot{\gamma}$, expressed in pascal seconds (Pa·s)

3.8

apparent viscosity

η_{ap}
ratio $\tau / \dot{\gamma}_{ap}$ of apparent shear stress τ_{ap} to apparent shear rate $\dot{\gamma}_{ap}$, expressed in pascal seconds (Pa·s)

3.9

Bagley corrected apparent viscosity

η_{apB}
ratio $\tau / \dot{\gamma}_{ap}$ of true shear stress τ to apparent shear rate $\dot{\gamma}_{ap}$, expressed in pascal seconds (Pa·s)

3.10**Rabinowitsch corrected apparent viscosity** η_{apR} ratio $\tau_{ap} / \dot{\gamma}$ of apparent shear stress τ_{ap} to true shear rate $\dot{\gamma}$, expressed in pascal seconds (Pa·s)

Note 1 to entry: This term is appropriate for use when testing with a single die of large length-to-diameter aspect ratio for which entrance effects are negligible.

3.11**volume flow rate** Q volume of melt flowing through the die per unit time, expressed in cubic millimetres per second (mm³/s)**3.12****swell ratio at room temperature** S_a

ratio of the diameter of the extrudate to the diameter of the capillary die, both measured at room temperature

3.13**swell ratio at the test temperature** S_T

ratio of the diameter of the extrudate to the diameter of the capillary die, both measured at the test temperature

3.14**percent swell at room temperature** S_a

difference between the diameter of the extruded strand and the diameter of the capillary die, expressed as a percentage of the diameter of the capillary die, both measured at room temperature

3.15**percent swell at the test temperature** S_T

difference between the diameter of the extruded strand and the diameter of the capillary die, expressed as a percentage of the diameter of the capillary die, both measured at the test temperature

Note 1 to entry: Equivalent slit-die extrudate swell terms can be derived based on the thickness of slit-die extrudate with reference to the slit-die thickness.

3.16**preheating time**

time interval between completion of charging of the barrel and the beginning of measurement

3.17**dwelling time**

time interval between the completion of charging of the barrel and the end of measurements

Note 1 to entry: In certain special cases, it can be necessary to note the dwelling time at the end of each measurement where more than one measurement per barrel filling is made.

3.18**extrusion time**

time corresponding to the period of measurement for a given shear rate

3.19**critical shear stress**

value of the shear stresses at the die wall at which any of the following occur:

- a discontinuity in the curve plotting shear stress against flow rate or shear rate;
- roughness (or waving) of the extrudate as it leaves the die

Note 1 to entry: It is expressed in pascals (Pa).

3.20

critical shear rate

shear rate corresponding to the critical shear stress, expressed in reciprocal seconds (s^{-1})

4 General principles

The plastics melt is forced through a capillary or slit die of known dimensions. Two principal methods can be used: for a specified constant test pressure p , the volume flow rate Q is measured (method 1), or for a specified constant volume flow rate Q , the test pressure p is measured (method 2). These methods can be used with capillary dies (method A) and slit dies (method B). For full designation of the test method options, see [Table 1](#).

Table 1 — Designation of test methods

Die cross section	Preset parameter	
	Test pressure, p	Volume flow rate, Q
Circular (capillary die)	A1	A2
Rectangular (slit die)	B1	B2

Measurements can be made using a range of values of the preset parameter (either applied test pressure in method 1, or volume flow rate in method 2).

If a slit die with pressure transducers positioned along its length and also upstream of the die entry is used, then entrance and exit pressure drop values can be determined. If capillary dies of the same radius but of varying lengths are used, then the sum of the entrance and exit pressure drops can be determined.

A slit die with pressure transducers positioned along its length is particularly suited for automated measurements using online computer evaluation.

Recommended values for capillary die dimensions and for flow rates and temperatures to be used in testing are presented either in the relevant clauses below or in ISO 11403-2.

NOTE In using a slit die, either the aspect ratio H/B between the thickness H and the width B of the slit is small or else a correction for H/B (see [Annex A](#)) is necessary. In the latter case, the calculated quantities are dependent on assumptions made in deriving the correction formulae used, notably that elastic effects are irrelevant.

5 Apparatus

5.1 Test device

5.1.1 General

The test device shall consist of a heatable barrel, the bore of which is closed at the bottom end by an interchangeable capillary or slit die. The test pressure shall be exerted on the melt contained in this barrel by a piston, screw, or by the use of gas pressure. [Figures 1](#) and [2](#) show typical examples; other dimensions are permitted.

5.1.2 Rheometer barrel

The barrel shall consist of a material resistant to wear and corrosion up to the maximum temperature of the heating system.

The barrel can have a lateral bore for the insertion of a melt-pressure transducer close to the die entrance.

The permissible deviations in the mean bore diameter throughout the length of the barrel shall be less than $\pm 0,007$ mm.

The barrel shall be manufactured using techniques and materials that produce a Vickers hardness preferably of at least 800 HV 30 (see ISO 6507-1 and Note 1) and a surface roughness of less than $R_a = 0,25$ μm (average arithmetic discrepancy, see ISO 4287).

NOTE 1 For temperatures up to 400 °C, nitrided steel has been found suitable. Materials of hardness values lower than that specified but of sufficient corrosion and abrasion resistance have been found to be acceptable for construction of the barrel and dies.

NOTE 2 An increase in barrel-bore diameter increases the number of measurements that can be made with a single barrel filling and increases the shear rate range of the instrument. Disadvantages of using a larger barrel-bore diameter are that larger sample masses are required and that the time necessary to reach temperature equilibrium throughout the sample is greater. The barrel-bore diameters of commercially available rheometers lie in the range between 6,35 mm and 25 mm.

5.1.3 Capillary dies (method A)

5.1.3.1 The entire length of the capillary die wall shall be machined to an accuracy of $\pm 0,007$ mm for the diameter (D) and $\pm 0,025$ mm for the length (L) (see Figure 1).

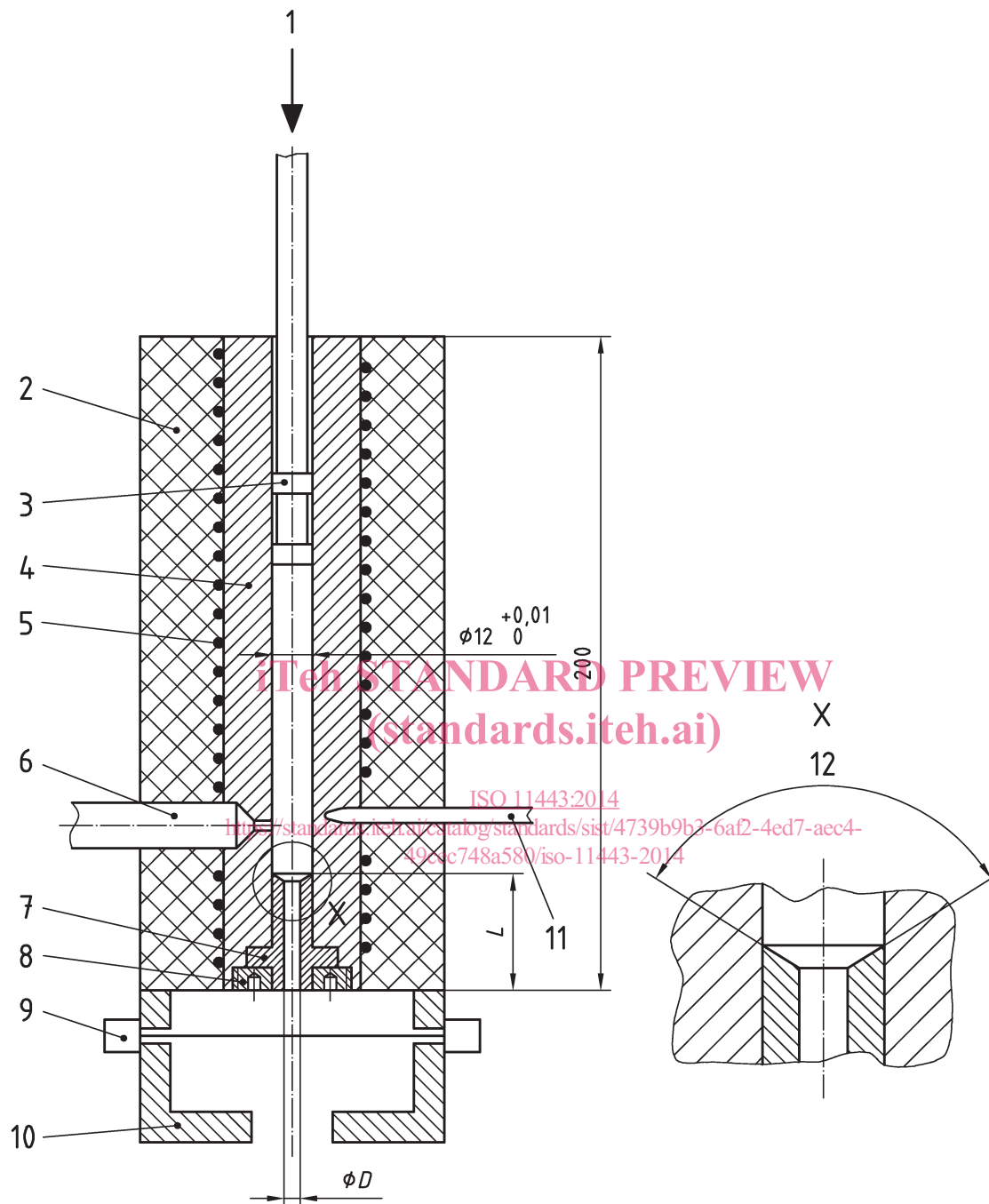
The capillary shall be manufactured using techniques and materials that produce a Vickers hardness preferably of at least 800 HV 30 (see ISO 6507-1 and Note 1 to 5.1.2) and a surface roughness of less than $R_a = 0,25$ μm (average arithmetic discrepancy, see ISO 4287).

The capillary opening shall show no visible machining marks nor perceptible eccentricity.

NOTE 1 Diameters of capillary dies typically used lie in the range between 0,5 mm and 2 mm, with various lengths to obtain the desired L/D ratios. For testing of filled materials, larger diameters might be required.

NOTE 2 Hardened steel, tungsten carbide, stellite, and hardened stainless steel are the most common die materials.

NOTE 3 The precision with which capillary dimensions can be measured is dependent upon both the capillary radius and the capillary length. With capillaries of diameter smaller than 1,25 mm, the specified precision ($\pm 0,007$ mm) is difficult to obtain. Due to the extreme sensitivity of flow data to capillary dimensions, it is important that the capillary dimensions, and the precision with which the dimensions are measured, are known and reported. This also applies to the dimensions (thickness, width, and length) of slit dies (see 5.1.4).

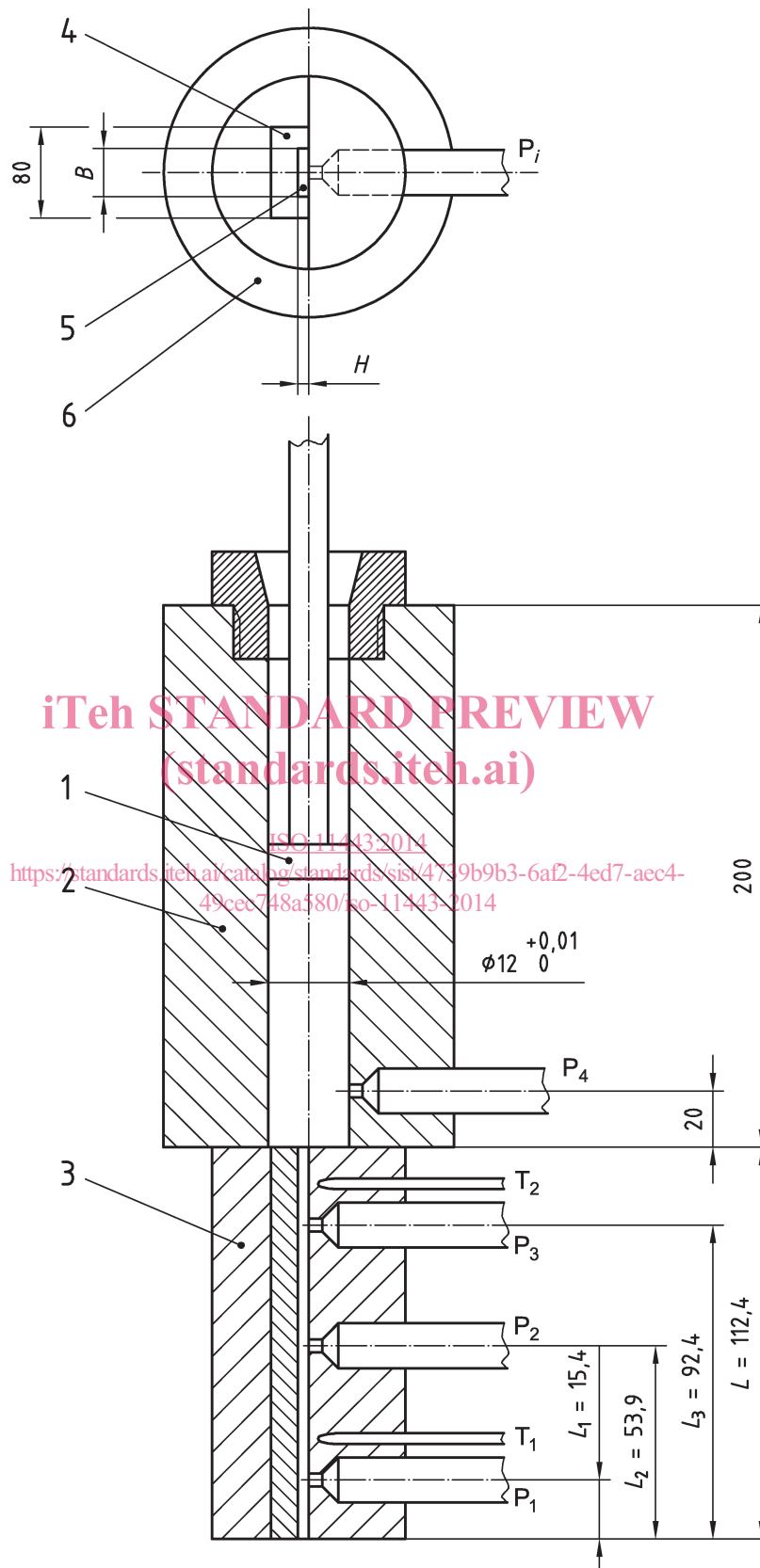


Key

- | | | | |
|---|------------------------------------|----|------------------------------------|
| 1 | applied force or constant velocity | 7 | capillary die |
| 2 | thermal insulation | 8 | die-retaining nut |
| 3 | piston | 9 | optical sensor |
| 4 | barrel | 10 | temperature-controlled air chamber |
| 5 | heating coil | 11 | thermometer |
| 6 | pressure transducer | 12 | inlet angle |

Figure 1 — Typical example of an extrusion rheometer used with a capillary die

Dimensions in millimetres



Key

1 piston	3 die	5 channel	P _i = pressure transducers
2 barrel	4 exchangeable part	6 electrical heater	T _i = thermometers

Figure 2 — Typical example of an extrusion rheometer used with a slit die

5.1.3.2 To determine the apparent shear rate $\dot{\gamma}_{\text{ap}}$ and the apparent shear stress τ_{ap} with one capillary die, the ratio L/D of the length L to the diameter D of the capillary die shall be at least 16 and its inlet angle shall be 180° , unless otherwise specified by the referring International Standard. Only data obtained with capillaries of the same inlet angle ($\pm 1^\circ$), length ($\pm 0,025$ mm), and diameter ($\pm 0,007$ mm) shall be compared. The inlet angle is defined in [Figure 1](#).

It is recommended that a die of length either 16 mm or 20 mm, diameter of 1 mm, and entry angle of 180° be used (see Note 1). Options for the die diameter of 0,5 mm, 2 mm, or 4 mm are permitted when the recommended value is not appropriate, for example for heavily filled materials. For dies of diameter other than 1 mm, the recommended ratio of length to diameter (L/D) shall be the same, where possible, as that of the 1-mm-diameter die used in that instrument.

NOTE 1 Die lengths of 16 mm and 20 mm are most commonly used, the choice often being dependent on, and limited by, the design of the instrument.

NOTE 2 For a given value of the apparent shear rate, the effect of shear heating of the melt is reduced by use of smaller diameter capillary dies.

5.1.3.3 To determine the true shear rate $\dot{\gamma}$ and the true shear stress τ , capillary dies of the same diameter ($\pm 0,007$ mm) and inlet angle ($\pm 1^\circ$) and having at least two different L/D ratios selected from the recommended series $L/D = 0,25$ to 1, 5, 10, 16, 20, 30, and 40 (see also [8.4.2](#)) are required, provided the following conditions are met.

The use of only two dies, of the same diameter ($\pm 0,007$ mm) and inlet angle ($\pm 1^\circ$), of $L/D \leq 5$ and $L/D \geq 16$ is permitted where the test conditions are such that the resultant Bagley plot is not significantly nonlinear, i.e. these conditions having been established in advance for each class of sample, by using additional dies (see [8.4](#)). When using only two dies, the difference in the L/D ratios of the two dies shall be at least 15.

It is recommended that, when using only two dies to determine shear viscosity corrected for entrance pressure drop effects, a short die of length-to-diameter (L/D) ratio in the range 0,25 to 1, and a long die of length-to-diameter (L/D) ratio in the range 16 to 20, both dies having a diameter of 1 mm and an entry angle of 180° , be used. Options for the die diameter, of 0,5 mm, 2 mm, or 4 mm, shall be permitted when the recommended value of 1 mm is not appropriate, for example for heavily filled materials. For dies of diameter other than 1 mm, the recommended ratios of length to diameter (L/D) shall be the same as that specified for the 1-mm-diameter dies.

NOTE The procedure for correction for entrance pressure drop effects (see [8.4](#)) is based on an extrapolation of data to a die length of zero, rather than by making the approximation that the short die yields the entrance pressure drop value.

5.1.4 Slit dies (method B)

5.1.4.1 The entire length of the slit die shall be machined to an accuracy of $\pm 0,007$ mm for the thickness, $\pm 0,01$ mm for the width, and $\pm 0,025$ mm for the length. As applicable, the distance between the centres of the pressure transducers and the exit plane shall be determined to $\pm 0,05$ mm. (See Note 3 to [5.1.3.1](#).)

The die shall be manufactured using techniques and materials that produce a Vickers hardness preferably of at least 800 HV 30 (see ISO 6507-1 and Note 1 to [5.1.2](#)) and a surface roughness of less than $R_a = 0,25$ μm (average arithmetic discrepancy, see ISO 4287).

NOTE For slit die materials, see Note 1 to [5.1.2](#) and Note 2 to [5.1.3.1](#).

5.1.4.2 To determine the apparent shear rate $\dot{\gamma}_{\text{ap}}$ and the apparent shear stress τ_{ap} , unless otherwise specified by the referring International Standard, the slit die shall have a ratio H/B of the thickness H to the width B of at most 0,1 and shall have an inlet angle of 180° . Only data obtained with slit dies of the

same inlet angle ($\pm 1^\circ$), thickness ($\pm 0,007$ mm), width ($\pm 0,01$ mm), and length ($\pm 0,025$ mm) shall be compared.

5.1.4.3 To determine the true values of shear rate $\dot{\gamma}$ and shear stress τ , slit dies conforming to the specification given in 5.1.4.1 and 5.1.4.2 can be used in exactly the same way as capillary dies, i.e. using the Bagley correction method modified accordingly (see 8.4). Alternatively, a slit die with pressure transducers positioned along the length of its channel can be used to determine true shear stress values.

5.1.5 Piston

If a piston is used, its diameter shall be $0,040$ mm \pm $0,005$ mm smaller than the barrel-bore diameter. It can be equipped with split or whole sealing rings in order to reduce melt backflow past the land of the piston. The hardness of the piston shall be less than that of the barrel, but not less than 375 HV 30 (see ISO 6507-1).

5.2 Temperature control

For all temperatures that can be set, the barrel temperature control shall be designed such that, within the range of the capillary die or slit die, as applicable, and the permissible filling height of the barrel, the temperature differences and variations measured at the wall do not exceed those given in Table 2 for the duration of the test.

Table 2 — Maximum allowable temperature differences as a function of distance and as a function of time

Test temperature, θ °C	Temperature difference from the set temperature as a function of distance ^a °C	Temperature variation as a function of time ^a °C
≤ 200	$\pm 1,0$	$\pm 0,5$
$200 < \theta \leq 300$	$\pm 1,5$	$\pm 1,0$
> 300	$\pm 2,0$	$\pm 1,5$

^a For all positions within the range of the capillary die or slit die, as applicable, and the permissible filling height of the barrel, for the duration of the test.

The test device shall be designed so that the test temperature can be set in steps of 1°C or less.

5.3 Measurement of temperature and calibration

5.3.1 Test temperature

5.3.1.1 Method A: Capillary dies

When capillary dies are used, the test temperature shall be either the temperature of the melt in the barrel near the capillary inlet or, if this is not possible, the temperature of the barrel wall near the capillary inlet. It is preferable that the test temperature is measured at a position not more than 10 mm above the capillary inlet. (See also 5.3.2.)

5.3.1.2 Method B: Slit dies

When slit dies are used, the die wall temperature shall be measured and taken as the test temperature. This temperature shall be equal to the test temperature measured in the barrel to within the distance-related and time-related temperature tolerances given in Table 2. (See also 5.3.1.1 and 5.3.2.)