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**Plastics — Thermoplastic polyester  
(TP) moulding and extrusion  
materials —**

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

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*Plastiques — Matériaux polyesters thermoplastiques (TP) pour  
moulage et extrusion —*

*Partie 1: Système de désignation et base de spécification*

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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)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

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 World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document was prepared by Technical Committee ISO/TC 61, *Plastics*, Subcommittee SC 9, *Thermoplastic materials*.

This first edition of ISO 20028-1 cancels and replaces ISO 7792-1:2012, which has been technically revised to introduce a new designation system.

The revised designation system is published under a new ISO number, as many existing documents refer to ISO 7792-1. If the existing ISO 7792-1 would be replaced by the new designation system, these documents would refer to the incorrect designation system.

In order to give users time to switch from ISO 7792-1 to ISO 20028-1, any designation system according to ISO 7792-1 is to be phased out in 5 to 10 years.

A list of all parts in the ISO 20028 series can be found on the ISO website.

## Introduction

ISO 7792-1 is complex and does not fit with daily practice anymore. In practice, ISO 1043 and ISO 11469 are, in combination, “improperly” being used as a designation system for, for example, marking. The aim of this revision is to simplify the data block system and to connect more to ISO 1043 and ISO 11469, where the first two blocks are used for generic identification and marking of products.

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# Plastics — Thermoplastic polyester (TP) moulding and extrusion materials —

## Part 1: Designation system and basis for specifications

### 1 Scope

This document establishes a system of designation for thermoplastic polyester (TP) material, which can be used as the basis for specifications. It covers polyester homopolymers for moulding and extrusion based on poly(ethylene terephthalate) (PET), poly(butylene terephthalate) (PBT), poly(cyclohexylenedimethylene terephthalate) (PCT), poly(ethylene naphthalate) (PEN), poly(butylene naphthalates) (PBN) and other TP-types and copolyesters of various compositions for moulding and extrusion.

The types of thermoplastic polyester are differentiated from each other by a classification system based on appropriate levels of the designatory properties:

- a) viscosity number;
- b) tensile modulus of elasticity;

and on information about the intended application and/or method of processing, important properties, additives, colorants, fillers and reinforcing materials.

This designation system is applicable to thermoplastic polyester homopolymers and copolymers. It applies to materials ready for normal use in the form of powder, granules or pellets, unmodified or modified by colorants, fillers and other additives. This document does not apply to the saturated polyester/ester and polyether/ester thermoplastic elastomers covered by ISO 20029.

It is not intended to imply that materials having the same designation give necessarily the same performance. This document does not provide engineering data, performance data or data on processing conditions which can be required to specify a material. If such additional properties are required, they are intended to be determined in accordance with the test methods specified in ISO 20028-2, if suitable.

In order to designate a thermoplastic polyester material to meet particular specifications, the requirements are to be given in data block 5 (see 3.1).

### 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 1043-1, *Plastics — Symbols and abbreviated terms — Part 1: Basic polymers and their special characteristics*

ISO 1043-2, *Plastics — Symbols and abbreviated terms — Part 2: Fillers and reinforcing materials*

ISO 1628-5, *Plastics — Determination of the viscosity of polymers in dilute solution using capillary viscometers — Part 5: Thermoplastic polyester (TP) homopolymers and copolymers*

ISO 20028-2, *Plastics — Thermoplastic polyester (TP) moulding and extrusion materials — Part 2: Preparation of test specimens and determination of properties*

ASTM D5927, *Standard Classification System for and Basis for Specifications for Thermoplastic Polyester (TPES) Injection and Extrusion Materials Based on ISO Test Methods*

### 3 Terms and definitions

No terms and definitions are listed in this document.

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

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

### 4 Designation system

#### 4.1 General

The designation system for thermoplastics is based on the following standardized pattern.

Designation					
Description Block (optional)	Identity block				
	International Standard number block	Individual item block			
		Data block 1	Data block 2	Data block 3	Data block 4

The designation consists of an optional description block, reading “Thermoplastics”, and an identity block comprising the International Standard number and an individual-item block. For unambiguous designation, the individual-item block is subdivided into five data blocks comprising the following information.

- Data block 1: Identification of the plastic by its symbol PET, PBT, PCT, PEN, PBN or TP for all such polyesters and copolyesters in general, in accordance with ISO 1043-1 (see 4.2).
- Data block 2: Position 1: Fillers or reinforcing materials and their nominal content (see 4.3).  
Position 2: Declaration of recyclate (REC) plastics and their contents if desired.
- Data block 3: Position 1: Intended application and/or method of processing (see 4.4).  
Positions 2 to 8: Important properties, additives and supplementary information (see 4.4).
- Data block 4: Designatory properties (see 4.5).
- Data block 5: For the purpose of specifications, a fifth data block contains appropriate information (see 4.6).

The first character of the individual item block shall be a hyphen. The five data blocks shall be separated from each other by a comma. If a data block is not used, this shall be indicated by doubling the separation sign, i.e. by two commas (,,). Terminal commas may be omitted.

NOTE Data blocks 1 and 2, when separated by a hyphen, form the part marking symbol

#### 4.2 Data block 1

In this data block, after the hyphen, thermoplastic polyesters are identified using the symbols and designations listed in Table 1 and Table 2.



**Table 1 — Symbols indicating the chemical structure of polyester materials in data block 1**

Symbol <sup>a</sup>	Name and chemical identification
PET, TP 2T	Poly(ethylene terephthalate): polyester based on ethylene glycol and terephthalic acid (or its ester).
PTT, TP 3T	Poly(trimethylene terephthalate): polyester based on 1,3-propanediol and terephthalic acid (or its ester).
PBT, TP 4T	Poly(butylene terephthalate): polyester based on 1,4-butanediol and terephthalic acid (or its ester).
PCT, TP CHT	Poly(cyclohexylenedimethylene terephthalate): polyester based on cyclohexanedimethanol and terephthalic acid (or its ester).
PEN, TP 2N	Poly(ethylene naphthalate): polyester based on ethylene glycol and 2,6-naphthalenedicarboxylic acid (or its ester).
PBN, TP 4N	Poly(butylene naphthalate): polyester based on 1,4-butanediol and 2,6-naphthalenedicarboxylic acid (or its ester).
TP 26	Poly(ethylene adipate): polyester based on ethylene glycol and adipic acid.
TP 4I	Poly(butylene isophthalate): polyester based on 1,4-butanediol and isophthalic acid.
TP CH10	Polyester based on cyclohexanedimethanol and sebacic acid.

<sup>a</sup> See [Annex A](#) (Designation of thermoplastic polyesters).

**Table 2 — Symbols indicating the chemical structure of copolyester materials in data block 1 (examples)**

Symbol <sup>a</sup>	Chemical identification
TP 6I/6T	Copolyester based on hexanediol, isophthalic acid and terephthalic acid.
TP BAI/BAT	Copolyester based on bisphenol A, isophthalic acid and terephthalic acid.
TP 2T/CHT	Copolyester based on ethylene glycol, cyclohexanedimethanol and terephthalic acid (or its derivatives).
TP 2T/2I	Copolyester based on ethylene glycol, terephthalic acid and isophthalic acid (or its ester).
TP 2/6/NG// T/I/6	Copolyester based on ethylene glycol, 1,6-hexanediol, neopentyl glycol, terephthalic acid, isophthalic acid and adipic acids.
The following two designations include an indication of the mass content ratio:	
TP 2T/26 (90/10)	Copolyester based on 90 % ( <i>mass by mass</i> ) ethylene glycol and terephthalic acid and 10 % ( <i>mass by mass</i> ) ethylene glycol and adipic acid.
TP NGT/6I (75/25)	Copolyester based on 75 % ( <i>mass by mass</i> ) neopentyl glycol and terephthalic acid and 25 % ( <i>mass by mass</i> ) 1,6-hexanediol and isophthalic acid.

<sup>a</sup> See [Annex A](#) (Designation of thermoplastic polyesters).

Blends of thermoplastic polyesters or thermoplastic polyesters with other polymers are identified using the symbols for the basic polymers separated by a plus sign.

EXAMPLE PBT + ASA for a blend of poly(butylene terephthalate) and acrylonitrile/styrene/acrylate.

### 4.3 Data block 2

In this data block, the type of filler and/or reinforcing material is represented by a single code-letter in position 1 and its physical form by a second code-letter in position 2, the code-letters being as specified in [Table 3](#). Subsequently (without a space), the actual content may be given by a two-figure code-number in positions 3 and 4.

Mixtures of materials and/or forms may be indicated by combining the relevant codes using the sign “+” and placing the whole between parentheses followed by the total filler content.

EXAMPLE 1 A mixture of 25 % (mass by mass) of glass fibres (GF) and 10 % (mass by mass) mineral powder (MD) would be indicated by (GF25+MD10).

In the second position of this data block, recycle declaration is represented by symbol “REC” and by following the content between parentheses, if desirable.

EXAMPLE 2 A mixture of 50% (mass by mass) of recycle would be indicated by REC(50).

**Table 3 — Code-letters for fillers and reinforcing materials in data block 2**

Code-letter	Material	Code-letter	Form
<b>B</b>	Boron	<b>B</b>	Beads, spheres, balls
<b>C</b>	Carbon <sup>a</sup>	<b>D</b>	Powder
<b>G</b>	Glass	<b>F</b>	Fibre
<b>K</b>	Calcium carbonate	<b>G</b>	Ground
<b>M</b>	Mineral <sup>a</sup> , metal <sup>b</sup>	<b>H</b>	Whiskers
<b>S</b>	Synthetic, organic <sup>a</sup>	<b>X</b>	Not specified
<b>T</b>	Talc	<b>Z</b>	Others
<b>X</b>	Not specified		
<b>Z</b>	Others <sup>a</sup>		

<sup>a</sup> These materials may be further defined after position 4 of the data block by their chemical symbol, for example, or additional symbols defined in ISO 1043-2 or by additional symbols agreed between the interested parties.

<sup>b</sup> Metal fillers shall be identified by their chemical symbol (in capital letters) after the mass content. For example, 5 % steel whiskers may be designated “MH05FE”.

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**4.4 Data block 3**

In this data block, information about intended application and/or method of processing is given in position 1 and information about important properties, additives and colour in positions 2 to 8. The code-letters used are specified in Table 4.

If information is presented in positions 2 to 8 and no specific information is given in position 1, the letter X shall be inserted in position 1.

**Table 4 — Code-letters used in data block 3**

Code-letter	Position 1	Code-letter	Positions 2 to 8
<b>A</b>	Adhesive	<b>A</b>	Processing stabilized
<b>B</b>	Blow moulding	<b>B</b>	Antiblocking
<b>C</b>	Calendering	<b>C</b>	Coloured
<b>D</b>	Disc manufacture	<b>D</b>	Powder
<b>E</b>	Extrusion	<b>E</b>	Expandable
<b>F</b>	Extrusion of films	<b>F</b>	Special burning characteristics
<b>G</b>	General use	<b>G</b>	Granules
<b>H</b>	Coating	<b>H</b>	Heat-ageing stabilized
<b>K</b>	Cable and wire coating	<b>L</b>	Light or weather stabilized
<b>L</b>	Monofilament extrusion	<b>M</b>	Nucleated
<b>M</b>	Injection moulding	<b>N</b>	Natural (no colour added)
<b>R</b>	Rotational moulding	<b>P</b>	Impact modified
<b>S</b>	Sintering	<b>R</b>	Mould release agent
<b>X</b>	No indication	<b>S</b>	Lubricated

Table 4 (continued)

Code-letter	Position 1	Code-letter	Positions 2 to 8
		<b>T</b>	Transparent
		<b>W</b>	Stabilized against hydrolysis
		<b>Z</b>	Antistatic

## 4.5 Data block 4

### 4.5.1 General

In this data block, the range of designatory property 1 is represented by a two-figure code-number (see 4.5.2), the range of designatory property 2 by a three-figure code-number (see 4.5.3). The code-numbers are separated from each other by hyphens.

If a property value falls on or near a range limit, the manufacturer shall state which range will designate the material. If subsequent individual test values lie on, or on either side of, the limit because of manufacturing tolerances, the designation is not affected.

NOTE Not all the combinations of the values of the designatory properties are provided by currently available polymers.

### 4.5.2 Viscosity number

The viscosity number shall be determined in accordance with ISO 1628-5, using 50/50 phenol/1,2-dichlorobenzene for PET and *m*-cresol for PBT.

The possible values of viscosity number are divided into 8 ranges, each represented by a two-figure code-number as specified in Table 5.

Table 5 — Code-numbers used for viscosity number in data block 4

Code-number	Range of viscosity number ml/g
<b>03</b>	≤40
<b>05</b>	>40 but ≤60
<b>07</b>	>60 but ≤80
<b>09</b>	>80 but ≤100
<b>11</b>	>100 but ≤120
<b>13</b>	>120 but ≤140
<b>15</b>	>140 but ≤160
<b>17</b>	>160 but ≤180

NOTE 1 Viscosity numbers determined in other solvents can be converted into viscosity numbers determined in phenol/1,2-dichlorobenzene using the following formulae.

For phenol/1,1,2,2-tetrachloroethane (50/50):  $x = 0,93y + 1,87$

For phenol/1,1,2,2-tetrachloroethane (60/40):  $x = 1,20y - 13,34$

For *o*-chlorophenol:  $x = 1,22y - 10,24$

For dichloroacetic acid:  $x = 1,20y - 18,07$

where

$x$  is the viscosity number in phenol/1,2-dichlorobenzene (50/50);