



**SLOVENSKI STANDARD**  
**oSIST prEN ISO 20028-1:2018**  
**01-november-2018**

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**Polimerni materiali - Materiali za oblikovanje in ekstrudiranje iz plastomernih poliestrov - 1. del: Sistem označevanja in podlage za specifikacije (ISO/DIS 20028-1:2018)**

Plastics - Thermoplastic polyester (TP) moulding and extrusion materials - Part 1: Designation system and basis for specifications (ISO/DIS 20028-1:2018)

Kunststoffe - Thermoplastische Polyester (TP)-Werkstoffe - Teil 1: Bezeichnungssystem und Basis für Spezifikationen (ISO/DIS 20028-1:2018)

Plastiques - Matériaux polyesters thermoplastiques (TP) pour moulage et extrusion - Partie 1: Système de désignation et base de spécification (ISO/DIS 20028-1:2018)

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

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

*Plastiques — Matériaux polyesters thermoplastiques (TP) pour moulage et extrusion —  
Partie 1: Système de désignation et base de spécification*

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ISO copyright office  
CP 401 • Ch. de Blandonnet 8  
CH-1214 Vernier, Geneva  
Phone: +41 22 749 01 11  
Fax: +41 22 749 09 47  
Email: [copyright@iso.org](mailto:copyright@iso.org)  
Website: [www.iso.org](http://www.iso.org)

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## ISO/DIS 20028-1:2018(E)

### 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 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 [4.1](#)).

### 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*

## ISO/DIS 20028-1:2018(E)

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	Data block 5

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 <a href="#">Annex A</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 <a href="#">Annex A</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).