
Rubber — Vocabulary

Caoutchouc — Vocabulaire

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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).

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).

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

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.

This document was prepared by Technical Committee ISO/TC 45, *Rubber and rubber products*.

This seventh edition cancels and replaces the sixth edition (ISO 1382:2012), which has been technically revised.

The main changes compared to the previous edition are as follows:

- in [Clause 3](#), terms have been redefined and new terms have been added;
- separate entries for abbreviated terms and synonyms (admitted terms) have been removed and incorporated into the preferred terms as single entries following ISO 10241-1:2011, which is the reference document for the presentation of entries in a vocabulary;
- an alphabetical index of terms has been added.

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.

Introduction

This document is intended to be helpful to persons who are unfamiliar with the terminology of the rubber industry. However, it is also intended for use as a guide by the rubber industry itself in selecting appropriate recommended terms to minimize possible confusions and for use in other International Standards and other reports and publications on rubber.

The vocabulary is limited to those terms in general use in the industry. It does not define terms intended for particular products of rubber nor does it define terms that are generally understood or adequately defined in other readily available sources such as general dictionaries.

Many rubber product areas have also produced International Standards on vocabulary specific to their products and processes, and a list of some of these vocabulary standards is given in the Bibliography.

Attention is also drawn to ISO 472 and ISO 18064 because these contain many terms of common interest to the rubber and plastics industries.

For convenience, standards and other relevant sources referred to in this vocabulary are listed in the first section of the Bibliography. Vocabularies relating to finished rubber products are listed in the second section of the Bibliography.

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Rubber — Vocabulary

1 Scope

This document establishes a vocabulary of and is limited to those terms in general use throughout the rubber industry.

It does not define terms intended for particular rubber products, some of which are given in the vocabulary standards listed in the Bibliography.

It does not define terms that are generally understood or adequately defined in other readily available sources such as general dictionaries.

The terms are listed in the alphabetical order of the English terms, with an index to the corresponding English terms attached.

Symbols are included under their full descriptions.

2 Normative references

There are no normative references in this document.

3 Terms and definitions

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

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

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

3.1

abrasion

loss of material from a surface due to frictional forces

3.2

abrasion resistance

resistance to wear resulting from mechanical action upon a surface

Note 1 to entry: Abrasion resistance is often expressed by the *abrasion resistance index* (3.3).

3.3

abrasion resistance index

ratio of the loss in volume of a standard rubber due to frictional forces to the loss in volume of a test rubber measured under the same specified conditions and expressed as a percentage

Note 1 to entry: ISO 4649 contains a method for the determination of *abrasion resistance* (3.2) using a rotating drum device.

**3.4
accelerated ageing**

change in physical properties in a test environment intended to produce the effect of slow natural changes at an ambient temperature in a shorter period of time

Note 1 to entry: The rate of degradation is usually increased by raising the temperature, sometimes in combination with increased air or oxygen pressure, increased humidity and/or changes in other conditions.

**3.5
accelerator**

compounding ingredient (3.106) used in small amounts with a *vulcanizing agent* (3.543) to increase the speed of *vulcanization* (3.542) and/or enhance the physical properties of the *vulcanizate* (3.541)

**3.6
acrylonitrile-butadiene rubber
nitrile rubber
NBR**

oil-resistant rubber made by the *copolymerization* (3.115) of acrylonitrile and butadiene

Note 1 to entry: Oil resistance increases with the level of acrylonitrile, which in commercial nitrile rubber grades varies from 18 % to 49 %.

**3.7
activator**

compounding ingredient (3.106) used in small proportions to increase the effectiveness of an *accelerator* (3.5)

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**3.8
active zinc oxide**

fine-particle form of zinc oxide chemical *activator* (3.7) for accelerated sulfur *vulcanization* (3.542)

ISO 1382:2020

Note 1 to entry: It is more effective than general-purpose zinc oxide at the low concentrations needed for the production of transparent or translucent *vulcanizates* (3.541) or the production of vulcanizates containing reduced levels of zinc.

**3.9
addition polymerization**

monomers (3.301) are linked together to form chains, without water or other simple molecules being split off

Note 1 to entry: See also *polyaddition* (3.367).

Note 2 to entry: There are two major types of addition polymerization process, polymerization of unsaturated compounds, such as olefins and dienes, and *polymerization* (3.370) of certain ring *structures* (3.493), such as lactams and alkylene oxides, by an opening of the ring to make large molecules.

**3.10
additive**

substance that is added into rubber *compounds* (3.105) to improve mixing or to modify properties of cured rubber

**3.11
adhesion**

state in which two surfaces are held together by chemical or physical forces or both

**3.12
adhesion promoter**

compounding ingredient (3.106) added to *unvulcanized rubber* (3.534) to improve bonding of rubber to another material in the *compound* (3.105)

Note 1 to entry: See also *bonding agent* (3.63).

3.13**adhesion strength**

force required to cause separation at the interface of the bonded components of a *test piece* (3.517) or product

3.14**aftercure**

continuation of process of *vulcanization* (3.542) subsequent to removal of the energy source

3.15**ageing**

<the effect of, or act of> exposure to an environment for a period of time and the irreversible change of material properties during that time

3.16**agglomerate**

<carbon black and other dry filler particles> group of *particle* (3.341) aggregates that are separated by normal rubber processing

3.17**agglomeration**

<rubber latex> reversible or irreversible joining together of *latex* (3.270) *particles* (3.341)

3.18**aggregate**

<carbon black and other dry filler particles> rigid group of coalesced *particles* (3.341) which is the smallest entity that can be dispersed by normal rubber processing

3.19**air checks**

laking

surface markings or depressions that occur on a moulding due to air trapped between the rubber and the mould surface

3.20**air oven ageing**

exposure in an enclosure to circulating air at elevated temperature, at atmospheric pressure and in the absence of light

3.21**anisotropic**

exhibiting different physical properties in different directions

[SOURCE: ISO 24817:2017, 3.1]

3.22**anti-blocking agent**

material used to prevent, or reduce the risk of, unwanted adherence between rubber surfaces

3.23**anticoagulant**

<natural rubber latex> substance added to field, or other, *latex* (3.270) to retard bacterial action and acidification which would otherwise cause rapid *coagulation* (3.94) of the latex

3.24**antidegradant**

compounding ingredient (3.106) used to retard deterioration during ageing

Note 1 to entry: Antidegradant is a generic term for certain *additives* (3.10) such as antioxidants, antiozonants, waxes and other protective materials.

3.25

anti-flex-cracking agent

compounding ingredient (3.106) used to retard cracking caused by cyclic deformation

3.26

anti-foaming agent

<rubber latex> *compounding ingredient* (3.106) used to prevent the formation of air bubbles in a *latex* (3.270) *mix* (3.298) which might otherwise cause *blisters* (3.54) or *pinholes* (3.357) in the finished product

3.27

antioxidant

compounding ingredient (3.106) used to retard deterioration caused by oxidation

3.28

antiozonant

compounding ingredient (3.106) used to retard deterioration caused by ozone

3.29

antistatic agent

material which counteracts the tendency for an electrical charge to build up on the surface of a product

3.30

anti-webbing agent

<rubber latex> *compounding ingredient* (3.106) used in a *latex* (3.270) *mix* (3.298) to prevent the formation of *webbing* (3.548) between adjacent parts of a dipped product

Note 1 to entry: See also webbing.

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3.31

apparent hardness

stiffness measured on a *test piece* (3.517) of non-standard dimensions or on a curved surface

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3.32

applied skin

<cellular material> thin surface layer of *elastomeric* (3.169) material applied to a cellular product

3.33

aromatic oil

hydrocarbon *process oil* (3.389) usually containing at least 35 % by mass of aromatic hydrocarbons

3.34

artificial weathering

exposure of material to laboratory conditions that accelerate the effect of natural climate-induced effects

3.35

ash

residue from incineration of a material under specified conditions

3.36

asphalt rubber

blend of polymeric cement, and any combination of *recycled rubber* (3.400), *raw rubber* (3.394), rubber *compound* (3.105) and certain *additives* (3.10) in which the rubber component is at least 5 % of the total blend and has reacted in the hot cement sufficiently to cause *swelling* (3.501) of the rubber *particles* (3.341)

Note 1 to entry: The term is widely used in the asphalt road surfacing industry, but the product is not an *elastomer* (3.167).

3.37

autoclave

pressurized vessel used for vulcanizing rubber in a vapour or gas

3.38**average particle diameter**

<carbon black and other particulate filler> arithmetic mean of the diameters of several individual *particles* (3.341) measured by an electron microscope

3.39**back-rind****retracted spew**

defect in which the rubber adjacent to the *flash line* (3.205) shrinks below the level of the moulded product

3.40**bagging**

tendency of a band of rubber on a mixing *mill* (3.295) to sag and rotate beneath the mill *roll* (3.415) due to lack of grip to the roll

3.41**balata**

tough flexible thermoplastic substance containing approximately equal proportions of *trans*-polyisoprene and *resin* (3.409), obtained from the sap of various trees of the *Sapotaceae* family, especially *Mimusops globosa*

3.42**bale coating**

film applied to surfaces of *natural rubber* (3.319) bales which inhibits adhesion to other surfaces and facilitates marking

3.43**ball mill**

rotating drum, usually mounted horizontally, containing hard, loose balls which serve to pulverize coarse material

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3.44**bank**

accumulation of material at the opening between the *rolls* (3.415) of a *mill* (3.295) or *calender* (3.74) or at a *spreader bar* (3.470) or knife

3.45**bareness**

defect resulting from the failure of the rubber to fill out all the pattern detail of a mould

3.46**batch**

<compounding> product of one mixing operation

3.47**bay region hydrogen**

hydrogen in a characteristic three-sided concave area of a non-linear polyaromatic hydrocarbon with three or more fused rings

Note 1 to entry: For more information, see ISO 21461.

3.48**bench mark****reference mark**

mark of known separation applied to a *test piece* (3.517) and used to measure *strain* (3.486)

3.49**biobased content**

amount of biologically-derived component(s) in a product expressed by carbon percentage to total carbon or mass percentage to total product mass

3.50

biomass

material of biological origin excluding material embedded in geological formations and/or fossilized

3.51

black scorch

severe stiffening of a rubber *compound* (3.105) during processing, due to interactions between the polymer and carbon black

Note 1 to entry: The effect is similar to that of *scorch* (3.431) and can be a particular problem in *extrusion* (3.189) processes. The effect is most common in EPDM compounds.

3.52

blank

piece of rubber *compound* (3.105) of suitable shape and volume to fill the mould

3.53

bleeding

exudation of a liquid *compounding ingredient* (3.106) or material to the surface of a rubber

Note 1 to entry: See also *blooming* (3.60).

Note 2 to entry: The term is also used for the migration of liquid and solid *colourants* (3.100).

3.54

blister

defect in a *rubber product* (3.426) evidenced by a *crater* (3.120) or sac that deforms the surface

3.55

block

portion of a polymer molecule, comprising many constitutional units, that has at least one constitutional or configurational feature not present in adjacent portions

Note 1 to entry: The term is sometimes preceded by the word "soft" for an *elastomeric* (3.169) phase and by the word "hard" for a glassy or crystalline phase.

[SOURCE: IUPAC]

3.56

block copolymer

polymer containing sections of more than one constitutional *monomer* (3.301) type

3.57

block polymer

polymer whose disparate *monomers* (3.301) in sequence are connected linearly

[SOURCE: IUPAC]

3.58

blocking

unintentional adherence between materials

3.59

bloom

liquid or solid material which has migrated to the surface of a rubber

Note 1 to entry: Bloom changes the surface appearance of the rubber.

3.60

blooming

migration of liquid or solid material to the surface of a rubber

Note 1 to entry: See also *bleeding* (3.53).

3.61**blowing agent**

compounding ingredient (3.106) used to produce gas by chemical and/or thermal action in the manufacture of hollow or cellular products

3.62**blowing down**

<rubber latex> removal of excess ammonia from *latex* (3.270) by stirring the latex while passing a stream of air across the surface

3.63**bonding agent**

substance, usually in liquid form, coated onto another material and used to produce a good bond between the material and rubber

Note 1 to entry: See also *chemical bonding* (3.85) and *adhesion promoter* (3.12).

3.64**bound monomer**

individual molecule that is combined or reacted with itself or other types of molecules in a *polymerization* (3.370) reaction to form a polymer

Note 1 to entry: This term is used with reference to *synthetic rubber* (3.502), and the bound monomer is usually expressed as a percentage of the total polymer.

3.65**bound rubber**

portion of the *elastomer* (3.167) in a *mix* (3.298) which is so closely associated with the *filler* (3.196) as to be unextractable by the usual rubber solvents

3.66**bowl**

two or more cylinders forming the rotating members of a *calender* (3.74)

3.67**branched polymer**

molecules connected together having a branched *structure* (3.493), chainlike between branch junctions and between each chain end and a branch junction

3.68**bridge**

two-spoked member supporting the centre of the head of an *extruder* (3.187)

Note 1 to entry: See also *spider* (3.466).

3.69**brittleness temperature**

lowest temperature below which all of a *set* (3.440) of *test pieces* (3.517) fractures due to low-temperature embrittlement when tested under specified conditions

Note 1 to entry: ISO 812 contains a method for the determination of brittleness temperature.

3.70**buffing**

<recycling> particulate *vulcanized rubber* (3.541) obtained from abrading rubber articles, especially during tyre retreading operations

3.71**bulk density**

mass per unit volume of a material, including any *voids* (3.539) present

Note 1 to entry: The term is applicable to cellular materials as well as to particulate materials.

3.72

bumping

breathing

release of pressure on a mould for a very short time at an early stage in the process of *vulcanization* (3.542) to allow the escape of gas or vapour

3.73

butyl rubber

isobutylene rubber

isobutylene-isoprene rubber

isobutene-isoprene rubber

IIR

high damping, low permeability rubber made by the *copolymerization* (3.115) of isobutylene and a small amount of isoprene

Note 1 to entry: The isoprene content allows sulfur *vulcanization* (3.542).

3.74

calender

machine with two or more essentially parallel *rolls* (3.415), operating at selected surface speeds, *nips* (3.224) and temperatures, for such operations as *sheeting* (3.446), laminating, *skim coating* (3.445) (topping) and *friction coating* (3.219) of a product to a controlled thickness and/or controlled surface characteristics

3.75

carbon black

compounding ingredient (3.106) consisting essentially of more than 95 % elemental carbon in the form of near-spherical *particles* (3.341) with major diameters less than 1 µm, generally coalesced into aggregates

Note 1 to entry: Carbon black is produced by incomplete burning or thermal decomposition of hydrocarbons.

3.76

carbon black aggregate

discrete, rigid colloidal entity that is the smallest dispersible unit in a suspension

Note 1 to entry: It is composed of extensively coalesced *particles* (3.341).

[SOURCE: ISO 15825:2017, 3.1.1]

3.77

casting

process in which a fluid material is poured or otherwise introduced into a mould or on to a prepared surface and is allowed to solidify without the use of external pressure

3.78

cavity

<mould> space within a mould to be filled to form the moulded product

3.79

cell

<cellular material> single small cavity surrounded partially or completely by walls

3.80

cellular polymeric flexible material

soft material having many *voids* (3.539) or *cells* (3.79) (open, closed or both) dispersed throughout its mass, made of rubber, *polyurethane* (3.371) or another plastics material

3.81**cellular striation**

layer within a material containing *cells* (3.79) that differs greatly from the characteristic cell structure (3.493)

3.82**centrifuged latex**

rubber *particle* (3.341) emulsion, the rubber concentration of which has been increased by the removal of *serum* (3.439) by centrifugal force

3.83**chalking**

<industry> formation of a powdery residue on the surface of a rubber, resulting from surface degradation

3.84**chemical antiozonant**

compounding ingredient (3.106) that confers ozone resistance through a chemical reaction at the rubber surface

3.85**chemical bonding**

adhesion of rubber to metal, textile or plastics by applying a chemical admixture to the substrate before placing it in contact with the rubber; the bond being developed usually during or after *vulcanization* (3.542)

Note 1 to entry: See also *bonding agent* (3.63).

3.86**chip rubber**

<recycling> vulcanized pieces produced by a mechanical process

Note 1 to entry: Rubber chips are usually between 10 mm and 50 mm in size.

Note 2 to entry: See also *elongated fibre-like rubber particles* (3.170), *fine powdered rubber* (3.199), *granulated rubber* (3.237) and *ground vulcanized rubber* (3.241).

3.87**chloroprene rubber****polychloroprene****CR**

ageing and weathering-resistant polymer made by the polymerization of 2-chloro-1,3-butadiene

3.88**closed cell**

cell (3.79) totally enclosed by its walls and hence non-interconnecting with other cells

3.89**closed-cell cellular material**

solidified foam in which practically all the *voids* (3.539) are non-interconnecting

3.90**cloth mark**

impression left on rubber by a fabric

3.91**coagent**

compounding ingredient (3.106) used in low concentrations to increase the *crosslinking* (3.129) efficiency of certain *non-sulfur vulcanizing systems* (3.328) or to modify the properties achieved by such systems

Note 1 to entry: The term is usually identified with *additives* (3.1) used to modify *vulcanization* (3.542) by organic peroxides.