
**Rubber, unvulcanized —
Determinations using a shearing-
disc viscometer —**

**Part 1:
Determination of Mooney viscosity**

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*Caoutchouc non vulcanisé — Déterminations utilisant un
consistomètre à disque de cisaillement —
Partie 1: Détermination de l'indice consistométrique Mooney*

ISO 289-1:2015

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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 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 45, *Rubber and rubber products*, Subcommittee SC 2, *Testing and analysis*.

This fourth edition cancels and replaces the third edition (ISO 289-1:2014), which has been technically revised to improve the calibration schedule.

ISO 289 consists of the following parts, under the general title *Rubber, unvulcanized — Determinations using a shearing-disc viscometer*:

- *Part 1: Determination of Mooney viscosity*
- *Part 2: Determination of pre-vulcanization characteristics*
- *Part 3: Determination of the Delta Mooney value for non-pigmented, oil-extended emulsion-polymerized SBR*
- *Part 4: Determination of the Mooney stress-relaxation rate*

Rubber, unvulcanized — Determinations using a shearing-disc viscometer —

Part 1: Determination of Mooney viscosity

WARNING — Persons using this part of ISO 289 should be familiar with normal laboratory practice. This part of ISO 289 does not purport to address all of the safety problems, if any, associated with its use. It is the responsibility of the user to establish appropriate safety and health practices and to ensure compliance with any national regulatory conditions.

1 Scope

This part of ISO 289 specifies a method using a shearing-disc viscometer for measuring the Mooney viscosity of uncompounded or compounded rubbers.

2 Normative references

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 1795, *Rubber, raw natural and raw synthetic — Sampling and further preparative procedures*

ISO 2393, *Rubber test mixes — Preparation, mixing and vulcanization — Equipment and procedures*

ISO 6508-1, *Metallic materials — Rockwell hardness test — Part 1: Test method*

ISO/TR 9272, *Rubber and rubber products — Determination of precision for test method standards*

ISO 18899:2013, *Rubber — Guide to the calibration of test equipment*

ISO 23529, *Rubber — General procedures for preparing and conditioning test pieces for physical test methods*

3 Principle

The torque which has to be applied under specified conditions in order to rotate a metal disc in a cylindrical chamber formed from mating dies filled with rubber is measured. The resistance offered by the rubber to this rotation is expressed in arbitrary units as the Mooney viscosity of the test piece.

4 Apparatus

4.1 Typical shearing-disc viscometer

A typical shearing-disc viscometer (see [Figure 1](#)), consisting of

- a) two dies to form a cylindrical cavity,
- b) a rotor,
- c) a means for maintaining the dies at a constant temperature,
- d) a means for maintaining a specified closure pressure,

- e) a means for rotating the rotor at constant angular velocity, and
 f) a means for indicating the torque required to rotate the rotor.

The rotor and die cavity have the dimensions shown in [Table 1](#).

Table 1 — Dimensions of essential parts of the apparatus

Part	Dimension mm
Rotor diameter	38,10 ± 0,03
Rotor thickness	5,54 ± 0,03
Die cavity diameter	50,9 ± 0,1
Die cavity depth	10,59 ± 0,03

NOTE Normally, a rotor with these dimensions is called a large rotor.

It is permissible to use a smaller rotor where high viscosity makes this necessary. This small rotor shall have the same dimensions as the large rotor except that the diameter shall be 30,48 mm ± 0,03 mm. Results obtained with the small rotor are not identical with those obtained using the large rotor.

4.2 Dies

The two dies forming the cavity shall be formed from non-deforming unplated hardened steel of minimum Rockwell hardness 60 HRC (see ISO 6508-1). The dimensions of the cavity are given in [Figure 1](#) and shall be measured from the highest surfaces. For good heat transfer, each die should preferably be made from only one piece of steel. The flat surfaces shall have radial V-grooves to prevent slippage. The grooves shall be spaced radially at 20° intervals and shall extend from an outer circle of diameter 47 mm to an inner circle of diameter 7 mm for the upper die and to within 1,5 mm of the hole in the lower die. Each groove shall form a 90° angle in the die surface with the bisector of the angle perpendicular to the surface and shall be 1,0 mm ± 0,1 mm wide at the surface (see [Figure 2](#)).

4.3 Rotor

The rotor shall be fabricated from non-deforming unplated hardened steel of minimum Rockwell hardness 60 HRC. The rotor surfaces shall have rectangular-section grooves 0,80 mm ± 0,02 mm wide, of uniform depth 0,30 mm ± 0,05 mm, and spaced 1,60 mm ± 0,04 mm apart (distance between central axes). The flat surfaces of the rotor shall have two sets of such grooves at right angles to each other (see [Figure 3](#)). The edge of the rotor shall have vertical grooves of the same dimensions. The large rotor shall have 75 vertical grooves and the small rotor shall have 60. The rotor is fastened at right angles to a shaft having a diameter of 10 mm ± 1 mm and a length such that, in the closed die cavity, the clearance above the rotor does not differ from that below by more than 0,25 mm. The rotor shaft shall bear on the spindle which turns the rotor shaft not on the wall of the die cavity. The clearance at the point where the rotor shaft enters the cavity shall be small enough to prevent the rubber from leaving the cavity. A grommet, O-ring, or other sealing device can be used as a seal at this point.

The eccentricity or runout of the rotor while turning in the viscometer shall not exceed 0,1 mm.

The angular velocity of the rotor shall be 0,209 rad/s ± 0,002 rad/s (2,00 r/min ± 0,02 r/min).

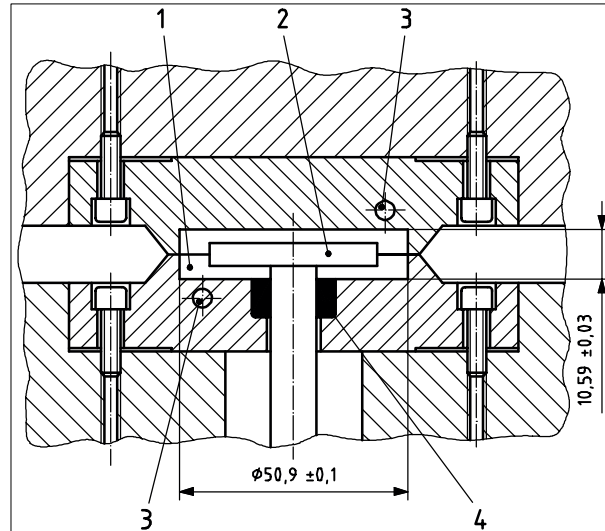
4.4 Heating device

The dies are mounted on, or form part of, platens equipped with a heating device capable of maintaining the temperature of the platens and that of the dies to within ±0,5 °C of the test temperature. After

insertion of the test piece, the devices shall be capable of returning the temperature of the dies to within $\pm 0,5$ °C of the test temperature within 4 min.

NOTE Older machines might not comply with these requirements and might give less reproducible results.

Dimensions in millimetres



Key

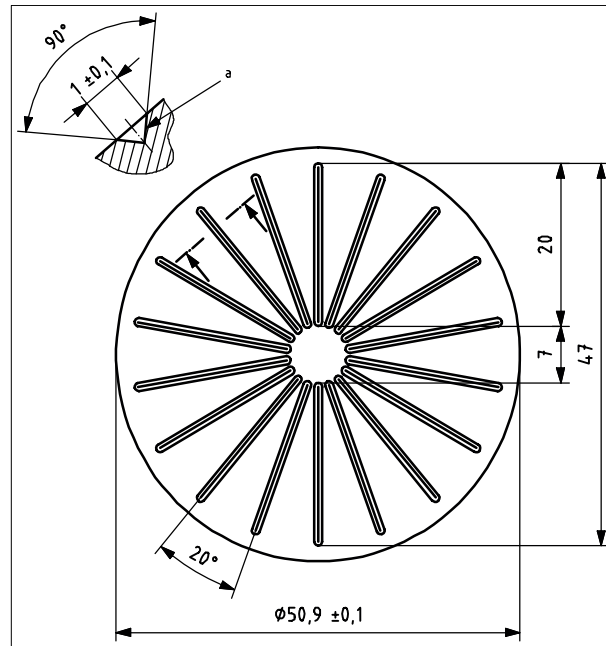
- 1 die cavity
- 2 rotor
- 3 temperature sensor
- 4 sealing device

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Figure 1 — Typical shearing-disc viscometer

Dimensions in millimetres

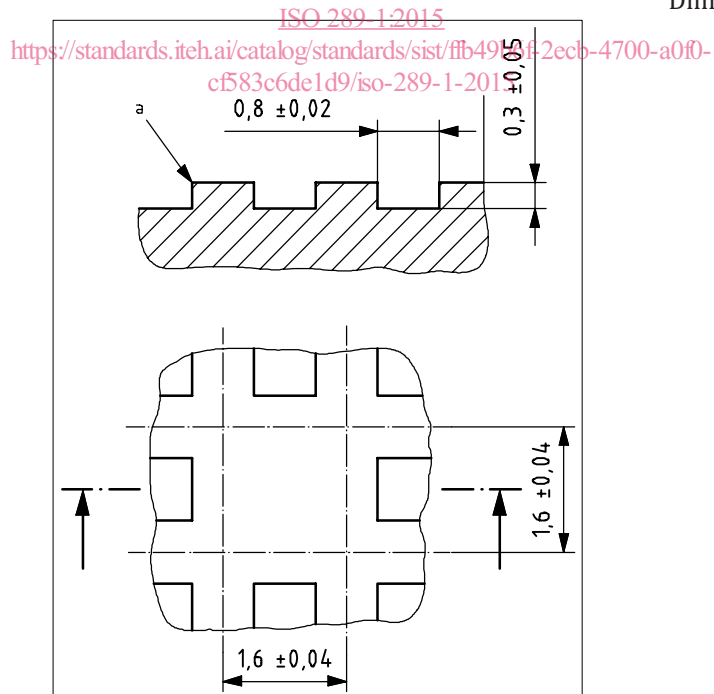


Key

- a Section through groove.

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Figure 2 — Die with radial V-grooves
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Dimensions in millimetres



Key

- a R at edge of groove ≤ 0,1 mm.

Figure 3 — Rotor with rectangular-section grooves

4.5 Temperature-measurement system

4.5.1 The test temperature is defined as the steady-state temperature of the closed dies with the rotor in place and the cavity empty. This temperature is measured by two thermocouple measurement probes which can be inserted into the cavity for this purpose as shown in [Figure 4](#). These measurement probes are also used to check the temperature of the test piece as described in [7.2](#).

4.5.2 In order to control the supply of heat to the dies, a temperature sensor shall be present in each die to measure the die temperature. The sensor shall be located for the best possible heat contact with the dies, i.e. heat gaps and other heat resistance shall be excluded. The axes of the sensors shall be at a distance of 3 mm to 5 mm from the working surface of the dies and 15 mm to 20 mm from the rotational axis of the rotor (see [Figure 1](#)).

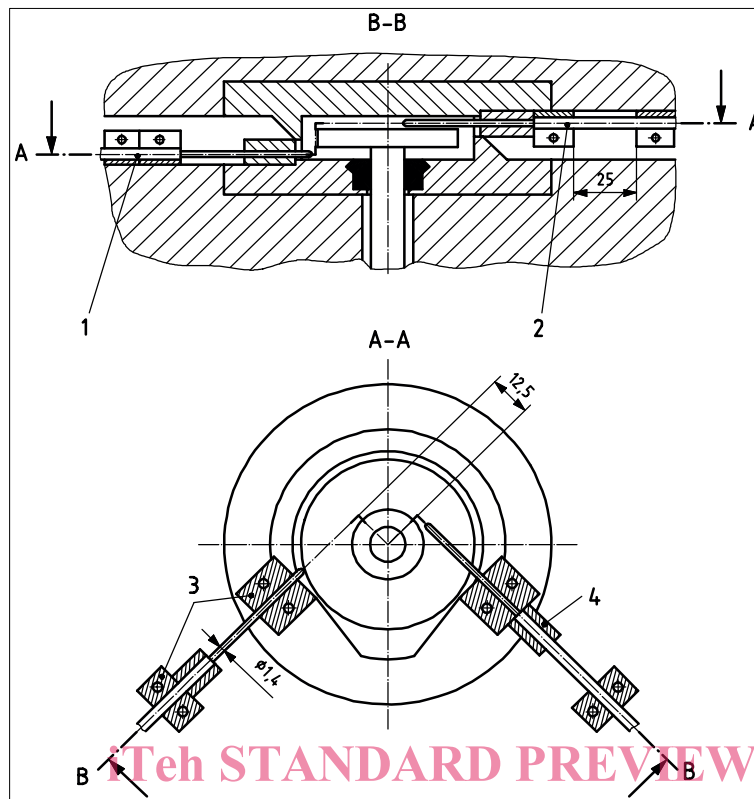
4.5.3 Both the thermocouple measurement probes and the temperature sensors shall be capable of indicating temperature to an accuracy of $\pm 0,25$ °C.

4.6 Die-closure system

The dies could be closed and held closed by hydraulic, pneumatic, or mechanical means. A force of $11,5 \text{ kN} \pm 0,5 \text{ kN}$ shall be maintained on the dies during the test.

A greater force can be required to close the dies when rubbers of high viscosity are tested. At least 10 s before starting the viscometer, the force shall be reduced in such cases to $11,5 \text{ kN} \pm 0,5 \text{ kN}$ and maintained at this level throughout the test.

For all types of closing device, a piece of soft tissue paper not thicker than 0,04 mm placed between the mating surfaces shall show a continuous pattern of uniform intensity when the dies are closed. A non-uniform pattern indicates incorrect adjustment of the die closure, worn or faulty mating surfaces, or distortion of the dies. Any of these conditions might result in leakage and erroneous results.



Key

- 1 measurement probe, withdrawn
- 2 measurement probe, inserted
- 3 stop connected to apparatus
- 4 stop connected to measurement probe

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Figure 4 — Measurement-probe design

4.7 Torque-measurement device and calibration of the device

The torque required to turn the rotor is recorded or indicated on a linear scale graduated in Mooney units. The reading shall be zero when the machine is run empty and $100 \pm 0,5$ when a torque of $8,30 \text{ N}\cdot\text{m} \pm 0,02 \text{ N}\cdot\text{m}$ is applied to the rotor shaft. Therefore, a torque of $0,083 \text{ N}\cdot\text{m}$ is equivalent to one Mooney unit. The scale shall be capable of being read to 0,5 Mooney units. Variation from zero shall be less than $\pm 0,5$ Mooney units when the machine is running with the rotor in place and the dies closed and empty.

If the viscometer is equipped with a rotor-ejection spring, the zero calibration shall be made with the dies open so that the rotor is not pressing against the upper die.

The viscometer shall be calibrated while the machine is running at the test temperature. A suitable method for the calibration of most machines is as follows.

The scale is calibrated to a reading of 100 by applying certified masses fastened with flexible wire to an appropriate rotor. During calibration, the rotor is turned at $0,209 \text{ rad/s}$ and the platens are at the specified test temperature.

NOTE In order to check linearity, intermediate masses can be used to give scale readings of 25 Mooney units, 50 Mooney units, and 75 Mooney units, respectively. In addition, a sample of butyl rubber of certified Mooney viscosity can be used to check whether or not the machine is working correctly. Measurement can be carried out at $100 \text{ }^\circ\text{C}$ or $125 \text{ }^\circ\text{C}$ for 8 min.

5 Preparation of test piece

For uncompounded rubbers, the test piece shall be prepared in accordance with ISO 1795 and the material standard relevant to the rubber. For compounded rubbers which are to be tested for referee purposes, the test piece shall be taken from a compound prepared in accordance with ISO 2393 and the material standard relevant to the rubber.

The test piece shall be allowed to rest at standard laboratory temperature (see ISO 23529) for at least 30 min before testing is carried out. Testing shall be commenced not later than 24 h after homogenization.

The Mooney viscosity is affected by the manner in which the rubber is prepared and the conditions of storage. Accordingly, the prescribed procedure in methods for evaluating a particular rubber shall be followed rigorously.

The test piece shall consist of two discs of rubber, of diameter about 50 mm, and of thickness approximately 6 mm sufficient to fill completely the die cavity of the viscometer. The rubber discs shall be as free as possible from air and from pockets that could trap air against the rotor and die surfaces. A hole is pierced or cut through the centre of one disc to permit the insertion of the rotor shaft.

6 Temperature and duration of test

Carry out the test at $100\text{ °C} \pm 0,5\text{ °C}$ for 4 min unless otherwise specified in the appropriate material standard.

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7 Procedure

7.1 Heat the dies and rotor to the test temperature and allow them to reach a steady-state. Open the dies, insert the rotor shaft through the hole in the pierced disc of the test piece, and place the rotor in the viscometer. Place the unpierced disc of the test piece centrally on the rotor and close the dies as quickly as possible.

NOTE A heat-stable film, for example, of polyester of thickness between 0,02 mm and 0,03 mm, can be inserted between the rubber and die surfaces to facilitate removal after test of low-viscosity or sticky materials. The use of such film could affect the test results (see [Annex B](#)).

7.2 Note the time at which the dies are closed and allow the rubber to preheat for 1 min. Start the rotor; the running time shall be as indicated in [Clause 6](#). If the viscosity is not recorded continuously, observe the scale during the 30 s interval preceding the specified reading time and report the minimum value to the nearest 0,5 units as the viscosity. For reference purposes, take readings at 5 s intervals from 1 min before to 1 min after the specified time. Draw a smooth curve through the minimum points of the periodic fluctuations or through all the points if there are no fluctuations. Take the viscosity as the point where the curve passes through the time specified. If a recorder is used, take the viscosity from the curve in the same manner as specified for the plotted curve.

To check if the temperature of the test piece is at the test temperature at the test time, two thermocouple measurement probes can be inserted into the test piece as shown in [Figure 4](#). In a preliminary test with the test piece, the rotor is stopped after a running time of 3,5 min and immediately after the resulting standstill, the two measurement probes are inserted and after 4 min, the two mean test piece temperatures are read off. The temperature tolerance shall be between $+1,0\text{ °C}$ and $-1,0\text{ °C}$.

The temperature gradients in the test piece and the rate of heat transfer vary between viscometers, particularly if different types of heating are employed. Therefore, the values obtained with different viscometers can be expected to be more comparable after the rubber has attained the test temperature. Usually, this condition is reached within 10 min after the die cavity is closed.