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**Plastics — Injection moulding of  
test specimens of thermoplastic  
materials —**

**Part 4:  
Determination of moulding shrinkage**

*Plastiques — Moulage par injection des éprouvettes de matériaux  
thermoplastiques —*

*Partie 4: Détermination du retrait au moulage*

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# Contents

	Page
<b>Foreword</b> .....	<b>iv</b>
<b>Introduction</b> .....	<b>v</b>
<b>1 Scope</b> .....	<b>1</b>
<b>2 Normative references</b> .....	<b>1</b>
<b>3 Terms and definitions</b> .....	<b>1</b>
<b>4 Apparatus</b> .....	<b>2</b>
<b>5 Procedure</b> .....	<b>3</b>
5.1 Conditioning of material.....	3
5.2 Injection moulding.....	3
5.3 Measurement of mould temperature.....	4
5.4 Measurement of melt temperature.....	4
5.5 Treatment of test specimens after demoulding.....	4
5.6 Measurement of moulding shrinkage.....	5
5.7 Treatment following measurement of moulding shrinkage.....	5
5.8 Measurement of post-moulding shrinkage.....	5
<b>6 Expression of results</b> .....	<b>6</b>
6.1 Moulding shrinkage.....	6
6.2 Post-moulding shrinkage.....	6
6.3 Total shrinkage.....	6
<b>7 Precision</b> .....	<b>7</b>
<b>8 Test report</b> .....	<b>7</b>
<b>Annex A (informative) Reference points for length and width measurement</b> .....	<b>8</b>
<b>Bibliography</b> .....	<b>9</b>

[ISO 294-4:2018](https://standards.iteh.ai/standards/iso/fb4ef3fa-7403-4fe5-854c-8ad6b7dcc2ab/iso-294-4-2018)

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## Foreword

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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 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](http://www.iso.org/iso/foreword.html).

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

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](http://www.iso.org/members.html).

This third edition cancels and replaces the second edition (ISO 294-4:2001), of which it constitutes a minor revision to update the reference in [Clause 2](#). It also incorporates the Technical Corrigendum ISO 294-4:2001/Cor.1:2007.

A list of all parts in the ISO 294 series can be found on the ISO website.

## Introduction

See ISO 294-1.

In the injection moulding of thermoplastics, the difference between the dimensions of the mould cavity and those of the moulded articles produced from it can vary with the design and operation of the mould. Such differences can depend on the size of the injection-moulding machine, the shape and dimensions of mouldings including any restrictive action this can have on the shrinkage, the degree and direction of flow or movement of the material in the mould, the sizes of the nozzle, sprue, runner and gate, the cycle on which the machine is operated, the temperature of the melt and the mould, and the magnitude and duration of the hold pressure. Moulding and post-moulding shrinkage are caused by crystallization, volume relaxation and orientation relaxation of the material and by thermal contraction of both the thermoplastic material and the mould. Post-moulding shrinkage can also be influenced by humidity uptake.

The measurement of moulding and post-moulding shrinkage is useful in making comparisons between thermoplastics and in checking uniformity of manufacture.

The method is not intended as a source of data for design calculations of components. Information on the typical behaviour of a material can be obtained, however, by carrying out measurements at different melt and mould temperatures, injection velocities and hold pressures, as well as at different values of other injection-moulding parameters. The information thus obtained is important in establishing the suitability of the moulding material for the production of moulded articles with accurate dimensions.

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