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## Plastics — Test specimens

*Plastiques — Éprouvettes*

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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 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 2, *Mechanical behaviour*.

This second edition cancels and replaces the first edition (ISO 20753:2008) which has been technically revised.

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

- updating and amending the normative references in [Clause 2](#);
- introducing the plate with dimensions 120 mm × 80 mm × 2 mm.

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).

## Introduction

Information on plastics test specimens has been specified in several different locations: in test method standards (e.g. ISO 527-2), in ISO 3167 (for multipurpose test specimens) and in ISO 294-1, ISO 294-2, ISO 294-3 and ISO 294-5 (for moulding conditions). The aim of this document is to give the designations and dimensions of test specimens used for the acquisition of comparable data, and also of other frequently used specimens, in one document for ease of reference. Other International Standards that have hitherto used different designations for the same specimen type will also be revised to bring the designations into line with those in this document.

ISO 3167 is intended to be withdrawn after reference to ISO 3167 in International Standards is gradually replaced with the appropriate test specimen defined in this document.

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# Plastics — Test specimens

## 1 Scope

This document specifies dimensional requirements relating to test specimens prepared from plastics materials intended for processing by moulding, as well as to test specimens prepared by machining from sheets or shaped articles. It compiles the designations and dimensions of test specimens used for the acquisition of comparable data and also of other frequently used specimens.

The following types of test specimen are specified:

- a) Type A1 and type A2 specimens (1 = injection moulded, 2 = machined from a sheet or shaped article)

These are tensile test specimens from which, with simple machining, specimens for a variety of other tests can be taken (see [Annex A](#)).

The type A1 specimen is a multipurpose test specimen. The principal advantage of a multipurpose test specimen is that it allows all the test methods mentioned in [Annex A](#) to be carried out by all test laboratories on the basis of comparable mouldings. Consequently, the properties measured are coherent as all are measured using similar specimens prepared in the same way. In other words, it can be expected that test results for a given set of specimens will not vary appreciably due to unintentionally different moulding conditions. On the other hand, if desired, the influence of moulding conditions and/or different states of the specimens can be assessed without difficulty for all of the properties measured.

Also described are reduced-scale test specimens designated type A<sub>x</sub>y, where *x* is the number indicating the method of specimen preparation (1 = injection moulded, 2 = machined from a sheet or shaped article) and *y* is a number indicating the scale factor (1:*y*). These can be used e.g. when full-sized test specimens are not convenient or when sample material exists in small quantities only.

- b) Type B specimens

These are bar specimens which can be directly moulded or can be machined from the central section of type A1 specimens or from sheets or shaped articles.

- c) Type C specimens

These are small tensile test specimens which can be directly moulded or machined, e.g. from plates (Type D or type F specimens), from the central section of type A1 specimens or from sheets or shaped articles.

- d) Type D1 and type D2 specimens

These are square plates of thickness 1 mm and 2 mm, respectively.

- e) Type F specimens

These are rectangular plates intended for use in the analysis of mechanical anisotropy.

If a particular type of test specimen is not mentioned in this document, this does not mean that there is any intention to exclude the use of the specimen. Additional specimen types can be added in future if they are commonly used.

## 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 293, *Plastics — Compression moulding of test specimens of thermoplastic materials*

ISO 294-1, *Plastics — Injection moulding of test specimens of thermoplastic materials — Part 1: General principles, and moulding of multipurpose and bar test specimens*

ISO 294-2, *Plastics — Injection moulding of test specimens of thermoplastic materials — Part 2: Small tensile bars*

ISO 294-3, *Plastics — Injection moulding of test specimens of thermoplastic materials — Part 3: Small plates*

ISO 294-5, *Plastics — Injection moulding of test specimens of thermoplastic materials — Part 5: Preparation of standard specimens for investigating anisotropy*

ISO 295, *Plastics — Compression moulding of test specimens of thermosetting materials*

ISO 2818, *Plastics — Preparation of test specimens by machining*

ISO 10350-1, *Plastics — Acquisition and presentation of comparable single-point data — Part 1: Moulding materials*

ISO 10350-2, *Plastics — Acquisition and presentation of comparable single-point data — Part 2: Long-fibre-reinforced plastics*

ISO 10724-1, *Plastics — Injection moulding of test specimens of thermosetting powder moulding compounds (PMCs) — Part 1: General principles and moulding of multipurpose test specimens*

ISO 11403-1, *Plastics — Acquisition and presentation of comparable multipoint data — Part 1: Mechanical properties*

ISO 11403-2, *Plastics — Acquisition and presentation of comparable multipoint data — Part 2: Thermal and processing properties*

ISO 11403-3, *Plastics — Acquisition and presentation of comparable multipoint data — Part 3: Environmental influences on properties*

## 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:

— ISO Online browsing platform: available at <https://www.iso.org/obp>

— IEC Electropedia: available at <http://www.electropedia.org/>

## 4 Symbols

$l_1$	length of the narrow parallel-sided section (central section) of the type A and type CP tensile test specimens, length of the type B bar specimen and length of the type D (square) and type F (rectangular) plate specimens
$l_2$	distance between the broad parallel-sided sections (tabs) of the type A and type CP tensile test specimens
$l_3$	overall length of the type A and type C tensile test specimens



$b_1$	width of the narrow parallel-sided section (central section) of the type A tensile test specimen, minimum width of the type C test specimen and the width of the type D (square) and type F (rectangular) plate specimens
$b_2$	width of the broad parallel-sided sections (tabs) of the type A and type C tensile test specimens
$r$	radius of the shoulder region of the type A and type C tensile test specimens
$h$	thickness of the test specimen

## 5 Preparation of test specimens

### 5.1 General

Test specimens shall be prepared in accordance with the relevant material specification. When none exists, specimens shall be either directly compression or injection moulded from the material in accordance with ISO 293, ISO 294-1, ISO 294-2, ISO 294-3, ISO 294-5, ISO 295 or ISO 10724-1, as appropriate, or machined in accordance with ISO 2818 from sheets that have been compression or injection moulded from the compound, extruded from the compound or polymerized and cast.

Strict control of all the specimen preparation conditions is essential to ensure that all test specimens in a set are in the same state.

All surfaces of the test specimens shall be free from visible flaws, scratches or other imperfections. With moulded specimens, any flash present shall be completely removed, taking care not to damage the moulded surface.

The broad sides of multipurpose test specimens shall be suitably marked, for injection-moulded specimens to distinguish between the sides formed by the cavity plate and the fixed plate of the mould (see ISO 294-1 or ISO 10724-1), for compression-moulded and machined specimens to identify any asymmetry resulting from the underlying moulding process.

For injection-moulded specimens, the sides can be identified by the impressions of the ejection pins and by the draft angle. Compression-moulded and machined specimens shall be marked at their shoulders. ISO bars taken from the central section of multipurpose test specimens shall be marked outside their central 64 mm section, which is loaded during flexural testing.

Asymmetry with respect to thickness may influence the flexural properties, including the temperature of deflection under load (see [Annex A](#)).

### 5.2 Injection moulding of test specimens

Test specimens shall be injection moulded as specified in ISO 294-1, ISO 294-2, ISO 294-3, ISO 294-5 or ISO 10724-1, as appropriate, and under the conditions defined in the relevant International Standard for the material under examination or, if no such standard exists, as recommended by the manufacturer of the material or as agreed upon between the interested parties.

### 5.3 Compression moulding of test specimens

Test specimens shall be compression moulded as specified in ISO 293 or ISO 295, as appropriate, and under the conditions defined in the relevant International Standard for the material under examination or, if no such standard exists, as recommended by the manufacturer of the material or as agreed upon between the interested parties.

### 5.4 Preparation of test specimens by machining

**5.4.1** Preparation of test specimens by machining shall be performed either as specified in ISO 2818 or as agreed upon by the interested parties, using suitably processed injection- or compression-moulded sheets or shaped articles.

5.4.2 Bar test specimens having a width of 10 mm shall be cut symmetrically from the central parallel-sided section of a type A1 or type A2 test specimen.

The surface of the central parallel-sided section of the test specimens shall remain as moulded:

- The width of the machined sections of the specimen shall be not less than that of the central parallel-sided section, but may exceed the width of the latter by not more than 0,2 mm.
- During the machining operation, care shall be taken to avoid any damage to the moulded surfaces of the central parallel-sided section.

For the preparation, from type A1 or type A2 test specimens, of parallel-sided test specimens

- longer than 80 mm in the case of type A1 test specimens, or
- longer than 60 mm in the case of type A2 test specimens,

the broad ends of the specimen shall be machined to the width of the central parallel-sided section.

When machining test specimens from sheets or plates of which the history is not known, machine the specimens from locations that appear appropriate or as agreed between the interested parties. Record this information in the test specimen preparation report.

## 6 Types of test specimen and their dimensions

### 6.1 Types of test specimen

[Table 1](#) gives an overview of the types of test specimen that shall be used for the acquisition of comparable data in accordance with ISO 10350-1 or ISO 10350-2 or in accordance with ISO 11403-1, ISO 11403-2 or ISO 11403-3. Where applicable, type A1 specimens and specimens machined from the central section of the type A1 specimen shall always be used.

[Annex B](#) specifies the designation system used for ISO test specimens.

NOTE It has been shown that, for some materials, the results of tests using directly moulded 80 mm × 10 mm × 4 mm bars differ from those obtained using 80 mm × 10 mm × 4 mm bars machined from the central section of the multipurpose test specimen. For this reason, ISO 10350-1 recommends that the central section of the multipurpose test specimen be used. For licensees of the CAMPUS<sup>®1)</sup> database, this is mandatory.

**Table 1 — Types of test specimen to be used for acquisition of comparable data**

Shape	Other details	Designation	Comments
Tensile specimen (with narrow parallel-sided section and tabs)	Multipurpose (see <a href="#">6.2.1</a> )	Type A1	Identical with type A of ISO 3167:2014 and with type 1A of ISO 527-2:2012, injection moulded
Bar specimen	See <a href="#">6.3</a>	Type B2	Rectangular bar, machined from central section of type A1
Small tensile specimen	See <a href="#">6.4</a>	Type CW13	Identical with type 4 of ISO 8256:2004, injection moulded
Square plate specimen	See <a href="#">6.5</a>	Type D12	Thickness 2 mm, injection moulded
Rectangular plate specimen	See <a href="#">6.6</a>	Type F12	Thickness 2 mm, injection moulded

[Table 2](#) gives an overview of additional types of test specimen.

1) CAMPUS is the trademark of a product supplied by CWFG. This information is given for the convenience of users of this document and does not constitute an endorsement by ISO of the product named. Equivalent products may be used if they can be shown to lead to the same results.

Table 2 — Additional types of test specimen

Shape	Other details	Designation	Comments
Tensile specimen (with narrow parallel-sided section and tabs)		Type A2	Identical with type B of ISO 3167:2014 and with type 1B of ISO 527-2:2012, machined from sheets prepared by any method
	Reduced-scale (see 6.2.2)	Type A12, A22	Identical with type 1BA of ISO 527-2:2012, scale factor 1:2, injection moulded or machined
		Type A13, A23	Injection moulded or machined from type D1 or D2 or F11 or F12 plate specimens, scale factor 1:3
		Type A14, A24	Like type A1, scale factor 1:4, longer ends, injection moulded or machined
		Type A15, A25	Identical with type 1BB of ISO 527-2:2012, scale factor 1:5, injection moulded or machined
		Type A18, A28	Like type A1, scale factor 1:8, longer ends, injection moulded or machined
Bar	See 6.3	Type B1	Rectangular bar, injection moulded
		Type B3	Rectangular bar, machined from sheets (prepared by any method) or compression moulded
Small tensile specimen	See 6.4	Type CW21, Type CW22	Identical with type 4 of ISO 8256:2004 and type S of ASTM D 1822-13, machined from type D1 or D2 or F11 or F12 plate specimens
		Type CP1z, Type CP2z	Identical with type 2 of ISO 8256:2004, injection moulded or machined, thickness z mm
Square plate	See 6.5	Type D1x, D2x	Injection moulded or machined, thickness x mm
Rectangular plate	See 6.6	Type F1x	Injection moulded, thickness x mm

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## 6.2 Tensile test specimens with parallel-sided central section

### 6.2.1 Tensile test specimens type A1 and type A2

The general design of tensile test specimens is shown in Figure 1. Table 3 gives details of the dimensions of and acceptable tolerances for type A1 and type A2 specimens.

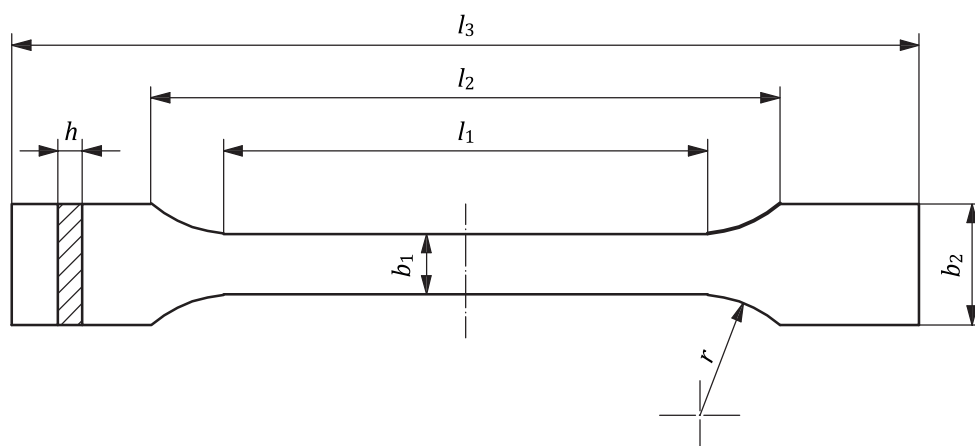


Figure 1 — General design of tensile test specimens

NOTE The type A1 specimen can be made suitable for a variety of tests by simple cutting, because the length  $l_1$  of the narrow parallel-sided section is  $80 \text{ mm} \pm 2 \text{ mm}$ . It is therefore also referred to as multipurpose test specimen.