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Plastics — Impact-resistant polystyrene (PS-I) moulding and extrusion materials —

Part 2: Preparation of test specimens and determination of properties

*Plastiques — Polystyrènes résistants au choc (PS-I) pour moulage et extrusion —
Partie 2: Préparation des éprouvettes et détermination des propriétés*

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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 shall be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation on 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 the following URL: 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 19063-2 cancels and replaces ISO 2897-2:2003, which has been technically revised.

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

- Updated the normative references to the latest version;
- Added terms and definitions(see 3);
- Revised the contents and structures of [table 3](#) and [table 4](#) according to the revised ISO 10350-1.

ISO 19063 consists of the following parts, under the general title Impact-resistant polystyrene(PS-I) moulding and extrusion materials:

- Part 1: Designation and specification
- Part2: Preparation of test specimens and determination of properties

A list of all parts in the ISO 19063 series can be found on the ISO website.

Plastics — Impact-resistant polystyrene (PS-I) moulding and extrusion materials —

Part 2: Preparation of test specimens and determination of properties

1 Scope

This part of ISO 19063 specifies the methods of preparation of test specimens and the test methods to be used in determining the properties of PS-I moulding and extrusion materials. Requirements for handling test material and for conditioning both the test material before moulding and the specimens before testing are given here.

Procedures and conditions for the preparation of test specimens and procedures for measuring properties of the materials from which these specimens are made are given. Properties and test methods which are suitable and necessary to characterize PS-I moulding and extrusion materials are listed.

The properties have been selected from the general test methods in ISO 10350-1. Other test methods in wide use for, or of particular significance to, these moulding and extrusion materials are also included in this part of ISO 19063, as are the designatory properties specified in Part 1.

In order to obtain reproducible and comparable test results, it is necessary to use the methods of specimen preparation and conditioning, the specimen dimensions and the test procedures specified herein. Values determined will not necessarily be identical to those obtained using specimens of different dimensions or prepared using different procedures.

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 62, *Plastics — Determination of water absorption*

ISO 75-1, *Plastics — Determination of temperature of deflection under load — Part 1: General test method*

ISO 75-2, *Plastics — Determination of temperature of deflection under load — Part 2: Plastics and ebonite*

ISO 178, *Plastics — Determination of flexural properties*

ISO 179, *Plastics — Determination of Charpy impact strength*

ISO 179-1, *Plastics — Determination of Charpy impact properties — Part 1: Non-instrumented impact test*

ISO 179-2, *Plastics — Determination of Charpy impact properties — Part 2: Instrumented impact test*

ISO 291, *Plastics — Standard atmospheres for conditioning and testing*

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*

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- ISO 294-3, *Plastics — Injection moulding of test specimens of thermoplastic materials — Part 3: Small plates*
- ISO 294-4, *Plastics — Injection moulding of test specimens of thermoplastic materials — Part 4: Determination of moulding shrinkage*
- ISO 306, *Plastics — Thermoplastic materials — Determination of Vicat softening temperature (VST)*
- ISO 489, *Plastics — Determination of refractive index*
- ISO 527-1, *Plastics — Determination of tensile properties — Part 1: General principles*
- ISO 527-2, *Plastics — Determination of tensile properties — Part 2: Test conditions for moulding and extrusion plastics*
- ISO 527-4, *Plastics — Determination of tensile properties — Part 4: Test conditions for isotropic and orthotropic fibre-reinforced plastic composites*
- ISO 899-1, *Plastics — Determination of creep behaviour — Part 1: Tensile creep*
- ISO 1133, *Plastics — Determination of the melt mass-flow rate (MFR) and the melt volume-flow rate (MVR) of thermoplastics*
- ISO 1133-1, *Plastics — Determination of the melt mass-flow rate (MFR) and melt volume-flow rate (MVR) of thermoplastics — Part 1: Standard method*
- ISO 1133-1, *Plastics — Determination of the melt mass-flow rate (MFR) and melt volume-flow rate (MVR) of thermoplastics — Part 1: Standard method*
- ISO 1183, *Plastics — Methods for determining the density and relative density of non-cellular plastics*
- ISO 1183-1, *Plastics — Methods for determining the density of non-cellular plastics -- Part 1: Immersion method, liquid pycnometer method and titration method*
- ISO 2561, *Plastics — Determination of residual styrene monomer in polystyrene (PS) and impact-resistant polystyrene (PS-I) by gas chromatography*
- ISO 2818, *Plastics — Preparation of test specimens by machining*
- ISO 2897-1:1997, *Plastics — Impact-resistant polystyrene (PS-I) moulding and extrusion materials — Part 1: Designation system and basis for specifications*
- ISO 3167, *Plastics — Multipurpose test specimens*
- ISO 4589, *Plastics — Determination of flammability by oxygen index*
- ISO 4589-2, *Plastics — Determination of burning behaviour by oxygen index — Part 2: Ambient-temperature test*
- ISO 6603-2, *Plastics — Determination of puncture impact behaviour of rigid plastics — Part 2: Instrumented impact testing*
- ISO 8256, *Plastics — Determination of tensile-impact strength*
- ISO 10350:1993, *Plastics — Acquisition and presentation of comparable single-point data*
- ISO 10350-1, *Plastics — Acquisition and presentation of comparable single-point data — Part 1: Moulding materials*
- ISO 11357-2, *Plastics — Differential scanning calorimetry (DSC) — Part 2: Determination of glass transition temperature*
- ISO 19063-1, *Plastics — Impact-resistant polystyrene (PS-I) moulding and extrusion materials — Part 1: Designation system and basis for specifications*

ISO 20753, *Plastics — Test specimens*

IEC 60093, *Methods of test for volume resistivity and surface resistivity of solid electrical insulating materials* (Replaced by IEC 62631-3-1 and IEC 62631-3-2)

IEC 60112, *Method for the determination of the proof and the comparative tracking indices of solid insulating materials* ~~Method for determining the comparative and the proof tracking indices of solid insulating materials under moist conditions~~

IEC 60243-1, *Electrical strength of insulating materials — Test methods — Part 1: Tests at power frequencies*

IEC 60250, *Recommended methods for the determination of the permittivity and dielectric dissipation factor of electrical insulating materials at power, audio and radio frequencies including metre wavelengths*

IEC 60296, *Fluids for electrotechnical applications — Unused mineral insulating oils for transformers and switchgear* ~~Specification for unused mineral insulating oils for transformers and switchgear~~

IEC 60695-11-10, *Fire hazard testing — Part 11-10: Test flames — 50 W horizontal and vertical flame test methods*

IEC 60695-11-20, *Fire hazard testing — Part 11-20: Test flames — 500 W flame test methods*

IEC 62631-2-1, *Dielectric and resistive properties of solid insulating materials-Part 2-1:Relative permittivity and dissipation factor-Technical frequencies (0,1 Hz to 10 MHz)-AC Methods*

IEC 62631-3-1, *Dielectric and resistive properties of solid insulating materials — Part 3-1: Determination of resistive properties (DC methods) — Volume resistance and volume resistivity — General method*

IEC 62631-3-2, *Dielectric and resistive properties of solid insulating materials — Part 3-2: Determination of resistive properties (DC methods) — Surface resistance and surface resistivity*

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 <https://www.iso.org/obp>

4 Preparation of test specimens

4.1 General

It is essential that specimens always be prepared by the same procedure (either injection moulding or compression moulding), using the same processing conditions. The procedure to be used for each test method is indicated in [Tables 3](#) and [4](#).

The material shall be kept in moisture-proof containers until it is required for use. The moisture content of filled or reinforced materials shall be expressed as a percentage of the total mass of the compound.

4.2 Treatment of the material before moulding

No pretreatment of the material sample is normally necessary before processing.

4.3 Injection moulding

Injection-moulded specimens shall be prepared in accordance with ISO 294-1 or ISO 294-3, under the conditions specified in [Table 1](#), in which the temperature values given are target values. It has been found that bar test specimens prepared in accordance with ISO 20753 give better precision than those injection-moulded directly to their final dimensions, and so the use of this geometry is preferable. (see ISO 294-1 or ISO 294-3 for tolerances).

Table 1 — Conditions for injection moulding of test specimens

Material	Melt temperature °C	Mould temperature °C	Average injection velocity mm/s
All grades	220	45	200 ± 100

NOTE :Flame-retardant grades may show discoloration if moulded at a melt temperature of 220 °C. In such cases, a melt temperature of 210 °C may be used.

4.4 Compression moulding

Compression-moulded sheets shall be prepared in accordance with ISO 293, using the conditions specified in [Table 2](#), in which the moulding temperature given is a target value (see ISO 293 for tolerances).

The test specimens required for the determination of the properties shall be machined from the compression-moulded sheets in accordance with ISO 2818 or stamped.

Table 2 — Conditions for compression moulding of test specimens

Material	Moulding temperature °C	Average cooling rate °C/min	Demoulding temperature °C	Full pressure MPa	Full pressure time min	Preheating time min
All grades	200	10	≤60	4±0,5	5±1	5±1

5 Conditioning of test specimens

Determination Test specimens shall be conditioned in accordance with ISO 291 for at least 16 h at (23 ± 2) °C and (50 ± 10) % relative humidity.

6 Determination of properties

In the determination of properties and the presentation of data, the standards, supplementary instructions and notes given in ISO 10350-1 shall be applied. All tests shall be carried out in the standard atmosphere of (23 ± 2) °C and (50 ± 10) % relative humidity, unless specifically stated otherwise in [Table 3](#).

[Table 3](#) is compiled from ISO 10350-1, and the properties listed are those which are appropriate to impact-resistant polystyrene moulding and extrusion materials. These properties are those considered useful for comparisons of data generated for different thermoplastics.

[Table 4](#) contains those properties, not found specifically in [Table 3](#), which are in wide use or of particular significance in the practical characterization of impact-resistant polystyrene moulding and extrusion materials.

Table 3 — General properties and test conditions (selected from ISO 10350-1)

Property	Sym- bol	Standard	Specimen type (dimensions in mm)	Specimen Prepara- tion ^a	Unit	Test conditions and supplementary in- structions			
1 Rheological Mechanical properties									
1.1	Melt mass-flow rate	<i>MFR</i>	ISO 1133-1	Moulding compound	-	Temperature 200 °C, load 5 kg			
1.2	Melt volume-flow rate	<i>MVR</i>					g/10min cm ³ /10min		
2 Mechanical properties									
2.1	Tensile modulus	E_t	ISO 527-1,	ISO 3167 ISO 20753 Type A1	M	MPa	Test speed 1 mm/min.		
2.2	Yield stress	σ_y	ISO 527-2,			MPa	Failure with yielding:		
2.3	Yield strain	ε_y	ISO 527-4			%	Test speed 50 mm/min.		
2.4	Nominal strain at break	ε_{tB}				MPa	Failure without yielding:		
2.5	Stress at 50 % strain	σ_{50}				%	$\varepsilon_b \leq 10$ %: test speed 5 mm/min.		
2.6	Stress at break	σ_B					$\varepsilon_b > 10$ %: test speed 50 mm/min.		
2.7	Strain at break	ε_B							
2.8	Tensile creep mod- ulus	E_{tc1}	ISO 899-1				MPa	At 1 h	Strain $\leq 0,5$ %.
2.9		E_{tc10^3}						At 1 000 h	
2.10	Flexural modulus	E_f	ISO 178				MPa	Test speed 2 mm/min	
2.11	Flexural strength	σ_{fM}							
2.12	Charpy impact strength	α_{cU}	ISO 179-1			80 × 10 × 4	kJ/m ²	Edgewise impact, meth- od 1eU. Also record type of failure	
2.13	Charpy notched impact strength	α_{cA}	or ISO 179-2			80 × 10 × 4 Mach- ined V-notch, r = 0,25		Edgewise impact, method 1eA. Also record type of failure.	
2.14	Tensile notched impact strength	α_{tN}	ISO 8256			80 × 10 × 4 Machined double V-notch, r = 1	kJ/m ²	Only to be quoted if frac- ture cannot be obtained with notched Charpy test.	
3 Thermal properties									
3.1	Glass transition tem- perature	T_g	ISO 11357-2	Moulding compound	—	°C	Record midpoint temperature. Use 10 K/min.		
^a M = Injection moulding ,Q= Compression moulding ^b The properties are generally affected by the relative humidity. Therefore they shall be measured in a standard atmosphere of 23 °C ± 2 °C and 50 % ± 10 % relative humidity.									