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Contents

Forewordv

Introductionvii

1 Scopeviii

2 Normative references1

3 Terms and definitions2

4 Symbols2

5 Preparation of test specimens2

5.1 General2

5.2 Injection moulding of test specimens3

5.3 Compression moulding of test specimens3

5.4 Preparation of test specimens by machining3

6 Types of test specimen and their dimensions4

6.1 Types of test specimen4

6.2 Tensile test specimens with parallel-sided central section6

6.2.1 Tensile test specimens type A1 and type A26

6.2.2 Reduced-scale test specimens7

6.3 Bar test specimens (type B)8

6.3 Small tensile specimens (type C)8

6.4 Square-plate specimens (type D)11

6.5 Rectangular-plate specimens (type F)11

7 Report on preparation of test specimens12

Annex A (informative) Recommended applications for multipurpose test specimens or parts thereof13

Annex B (normative) Designation system for test specimens15

Bibliography18

Forewordv

Introductionvii

1 Scope1

2 Normative references1

3 Terms and definitions2

4 Symbols2

5 Preparation of test specimens2

5.1 General2

5.2 Injection moulding of test specimens3

5.3 Compression moulding of test specimens3

5.4 Preparation of test specimens by machining3

6 Types of test specimen and their dimensions4

Formatted: Font: Bold

6.1	Types of test specimen	4
6.2	Tensile test specimens with parallel-sided central section	6
6.2.1	Tensile test specimens type A1 and type A2	6
6.2.2	Reduced-scale test specimens	7
6.3	Bar test specimens (type B)	8
6.4	Small tensile specimens (type C)	8
6.5	Square plate specimens (type D)	11
6.6	Rectangular plate specimens (type F)	11
7	Report on preparation of test specimens	12
Annex A (informative)	Recommended applications for multipurpose test specimens or parts thereof	13
Annex B (normative)	Designation system for test specimens	15
Bibliography		18

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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~~ ISO draws attention to the possibility that some of the elements implementation of this document may be involve the subject of (a) patent(s). ISO takes no position concerning the evidence, validity or applicability of any claimed patent rights in respect thereof. As of the date of publication of this document, ISO had not received notice of (a) patent(s) which may be required to implement this document. However, implementers are cautioned that this may not represent the latest information, which may be obtained from the patent database available at www.iso.org/patents. 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-61, *Plastics*, Subcommittee SC-2, *Mechanical behavior*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC-249, *Plastics*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This third edition cancels and replaces the second edition (ISO 20753:2018), which has been technically revised.

The main changes are as follows:

- Clarified overview of dimensions for reduced-scale dumb bell specimen type A.
 - That it contains the harmonizing harmonization of all tolerances for radii, widths and lengths, calculation of the total tolerance for l_2 (the length l_1 including radii), ~~now~~ which now includes the summary of tolerances of the single dimensions.
 - That dimension l_2 is most important for a testing lab, as it needs to be observed to ensure distance between grips at tensile test.

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— ~~Change of dimension of test specimen type CP. The dimension is now consistent with type 3 of ISO-8256. The former dimension refers to type 2 of ISO-8256. ~~But~~However, the new dimension tends to be used for high-speed tensile tests for crash simulation.~~

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.

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Introduction

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The holder of this patent right has assured ISO that he/she is willing to negotiate licences under reasonable and non-discriminatory terms and conditions with applicants throughout the world. In this respect, the statement of the holder of this patent right is registered with ISO. Information may be obtained from the patent database available at www.iso.org/patents.

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Plastics — Test specimens

1 Scope

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 of other frequently used specimens.

The following types of test specimen are specified:

- A — Tensile specimen, multipurpose or reduced-scale
- B — Bar specimen
- C — Small tensile specimen
- D — Square plate specimen
- F — Rectangular plate specimen

- A Tensile specimen, multipurpose or reduced-scale
- B Bar specimen
- C Small tensile specimen
- D Square plate specimen
- F Rectangular plate specimen

NOTE 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

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

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_3	overall length of the type A and type C test specimens
l_2	distance between the broad parallel-sided sections (tabs) of the type A and type CP test specimens
l_1	length of the narrow parallel-sided section (central section) of the type A and type CP test specimens, length of the type B bar specimen and length of the type D (square) and type F (rectangular) plate specimens
r_A	radius of the shoulder region of the type A and type C test specimens
b_2	width of the broad parallel-sided sections (tabs) of the type A and type C test specimens
b_1	width of the narrow parallel-sided section (central section) of the type A test specimen, minimum width of the type C test specimen and the width of the type D (square) and type F (rectangular) plate specimens
h_A	thickness of the test specimen

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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](#)–[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.