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**Plastics — Determination of ash —**  
**Part 1:**  
**General methods**

*Plastiques — Détermination du taux de cendres —*

*Partie 1: Méthodes générales*

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ISO 3451-1:1997

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## Foreword

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Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 3451-1 was prepared by Technical Committee ISO/TC 61, *Plastics*, Subcommittee SC 5, *Physical-chemical properties*.

This third edition cancels and replaces the second edition (ISO 3451-1:1981), which has been technically revised. The main change is the inclusion of a precision clause (clause 8).

ISO 3451 consists of the following parts, under the general title *Plastics — Determination of ash*:

- *Part 1: General methods*
- *Part 2: Polyalkylene terephthalates*
- *Part 3: Unplasticized cellulose acetate*
- *Part 4: Polyamides*
- *Part 5: Poly(vinyl chloride)*

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International Organization for Standardization  
Case postale 56 • CH-1211 Genève 20 • Switzerland  
Internet central@iso.ch  
X.400 c=ch; a=400net; p=iso; o=isocs; s=central

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# Plastics — Determination of ash —

## Part 1: General methods

### 1 Scope

This part of ISO 3451 specifies general methods, with suitable test conditions, for the determination of the ash of a range of plastics (resins and compounds). The particular conditions chosen may be included in the specifications for the plastic material in question.

Particular conditions applicable to plastics containing glass fibre reinforcement, fillers and/or certain additives are specified in further parts of ISO 3451 pertaining to specific types of plastics (see foreword).

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### 2 Principle

It is possible to determine the ash of an organic material by three main methods:

- a) Direct calcination, i.e. by burning the organic matter and heating the residue at high temperature until constant mass is reached (method A).
- b) Calcination after sulfation, which may be carried out by two different procedures:
  - With sulfuric acid treatment after burning, i.e. by burning the organic matter, transforming the inorganic residue into sulfates with concentrated sulfuric acid and heating the residue at high temperature until constant mass is reached. This is the common method of obtaining “sulfated ash” (method B).
  - With sulfuric acid treatment before burning, i.e. by heating the organic matter together with concentrated sulfuric acid up to temperatures where fuming and subsequent burning of the organic matter occur, and finally heating the residue at high temperature until constant mass is reached (method C). This procedure may be used if volatile metal halides are liable to evaporate during burning of the organic matter. It is not applicable to silicones or fluorine-containing polymers.

In each case, the final step of the procedure is calcination at 600 °C, 750 °C, 850 °C or 950 °C until constant mass is reached (see 5.2).

### 3 Reagents (for methods B and C only)

During the analysis, use only reagents of analytical grade and only distilled water or water of equivalent purity.

**3.1 Ammonium carbonate**, anhydrous.

**3.2 Ammonium nitrate**, approximately 10 % (m/m) solution.

**3.3 Sulfuric acid**,  $\rho = 1,84 \text{ g/cm}^3$ .

**WARNING — Care should be taken in handling.**

**3.4 Sulfuric acid**, 50 % (V/V) solution.

**WARNING — Care should be taken in handling.**

## 4 Apparatus

**4.1 Crucible**, made of silica, porcelain or platinum, inert to the material tested.

**4.2 Gas burner**, or other appropriate heat source.

**4.3 Muffle furnace or microwave furnace**, capable of being maintained at  $600 \text{ }^\circ\text{C} \pm 25 \text{ }^\circ\text{C}$ ,  $750 \text{ }^\circ\text{C} \pm 50 \text{ }^\circ\text{C}$ ,  $850 \text{ }^\circ\text{C} \pm 50 \text{ }^\circ\text{C}$  or  $950 \text{ }^\circ\text{C} \pm 50 \text{ }^\circ\text{C}$  as appropriate.

**4.4 Analytical balance**, accurate to 0,1 mg.

**4.5 Pipettes**, of suitable capacity (for methods B and C only).

**4.6 Desiccator**, containing an efficient desiccant which does not interact with the ash.

NOTE — In certain cases, the ash may have a greater affinity for water than some substances commonly used as desiccants.

**4.7 Weighing bottle.** <https://standards.iteh.ai/catalog/standards/sist/6cd107e9-31ef-410b-aebe-ea819c6d38a5/iso-3451-1-1997>

**4.8 Fume cupboard.**

## 5 Procedure

### 5.1 Test portion

Take a quantity of the test sample sufficient to yield 5 mg to 50 mg of ash. If the likely quantity of ash is unknown, carry out a preliminary determination.

Recommended test portion sizes are given in table 1.

**Table 1 — Recommended size of test portion**

Approximate ash (if known) %	Test portion g	Mass of ash obtained mg
$\leq 0,01$	200 min.	5 to 50
$> 0,01$ to 0,05	100	10 to 50
$> 0,05$ to 0,1	50	25 to 50
$> 0,1$ to 0,2	25	25 to 50
$> 0,2$	10 max.	20 to 50

For plastics yielding very low ash, it is necessary to use large test portions. When it is impossible to burn the whole of the test portion at one time, weigh the required quantity in a suitable weighing bottle and introduce it into the crucible (4.1) in convenient amounts for a succession of burnings until the whole of the test portion has been burnt.

## 5.2 Test conditions

Calcination shall be continued to constant mass as defined in 5.3.6, but the duration of the calcination in the muffle furnace (4.3) shall not exceed 3 h at the specified temperature.

The choice of the calcination temperature and the use of the sulfation method depend on the nature of the plastic and any additives it may contain. If a choice exists between different satisfactory conditions, choose those which allow the attainment of constant mass in less than 3 h. A higher temperature or the use of sulfation generally shortens the duration of the calcination.

Whichever method — A, B or C — is used, choose one of the following temperature ranges for the final (calcination) step, unless other temperatures are requested for special technical or commercial reasons:

600 °C ± 25 °C, 750 °C ± 50 °C, 850 °C ± 50 °C, 950 °C ± 50 °C

Use a fume cupboard for the ashing procedure.

## 5.3 Method A — Direct calcination

**5.3.1** Prepare the crucible (4.1) by heating it in the muffle furnace (4.3) at the test temperature until constant mass is reached. Allow to cool in the desiccator (4.6) to room temperature for 1 h, or until room temperature is reached, and weigh on the analytical balance (4.4) to the nearest 0,1 mg.

**5.3.2** Introduce into the tared weighing bottle (4.7) a test portion, predried as described in the corresponding material specification or with a known volatile-matter content, corresponding to 5 mg to 50 mg of ash. Weigh again to the nearest 0,1 mg or to 0,1 % of the mass of the test portion. If the crucible will accommodate the test portion corresponding to 5 mg to 50 mg of ash, this quantity may be placed directly into the crucible and weighed in it. The procedure described below assumes that this will not be the case, however. High-bulk materials may be compressed into tablets which may then be broken up into fragments of appropriate size.

**5.3.3** Introduce into the crucible enough of the test portion to half fill the crucible. Heat the crucible directly on the burner or other suitable heating device (4.2) to burn slowly. Burning shall not be too vigorous, to avoid loss of ash particles. Cool and add more of the test portion. Repeat the operations described above until the whole test portion has been burnt.

**5.3.4** Introduce the crucible into the muffle furnace preheated to the prescribed temperature and calcine for 30 min.

**5.3.5** Place the crucible in the desiccator, allow it to cool for 1 h, or until room temperature is reached, and weigh on the analytical balance (4.4) to the nearest 0,1 mg.

**5.3.6** Calcine again under the same conditions until constant mass is reached, i.e. until the results of two consecutive weighings do not differ from each other by more than 0,5 mg.

## 5.4 Method B — Calcination following sulfuric acid treatment after burning

**5.4.1** Proceed as specified in 5.3.1, 5.3.2 and 5.3.3.

**5.4.2** After cooling, add sulfuric acid solution (3.4) drop by drop with a pipette of suitable capacity (4.5) to moisten the residue completely and heat until fuming ceases, avoiding too vigorous boiling.

**5.4.3** If traces of carbonaceous materials remain after cooling, add 1 to 5 drops of ammonium nitrate solution (3.2) and heat until the evolution of white fumes ceases completely.

**5.4.4** In order to reconvert metal oxides formed during the preceding steps into sulfates, add, after cooling, about 5 drops of concentrated sulfuric acid (3.3) and heat until there is no further evolution of white fumes, avoiding vigorous boiling or the loss of ash by excessive fuming.

**5.4.5** After cooling, add 1 g to 2 g of solid ammonium carbonate (3.1) and heat, avoiding loss of ash, until the fuming has ceased. Then place the crucible in the muffle furnace preheated to the indicated temperature and proceed as specified in 5.3.4, 5.3.5 and 5.3.6.

## 5.5 Method C — Calcination following sulfuric acid treatment before burning

**5.5.1** This method shall never be used with silicones or fluorine-containing polymers.

**5.5.2** Proceed as specified in 5.3.1 and 5.3.2.

**5.5.3** Introduce into the crucible enough of the test portion to half fill the crucible. Add with a pipette (4.5) a sufficient amount of concentrated sulfuric acid (3.3) to moisten the material completely. Cover the crucible with a watch-glass. Heat the crucible directly on the burner over a low flame until the organic material begins to decompose.

Continue heating carefully, adjusting the watch-glass so as to allow the acid to be fumed off and making sure that no ash-containing material is lost. With plastics which have a tendency to lose ash-containing material, it is recommended that the crucible with its contents be placed into a holed board made of fireproof material (e.g. ceramic fibre) and heated with a low flame only so that the organic matter smoulders rather than burns. If the initial charge in the crucible was insufficient to yield an acceptable mass of ash, allow the crucible to cool, add more of the test portion and repeat the operations described above until the whole test portion has been burnt. Remove the watch-glass, making sure that no solid particles are adhering to it.

In cases where the sulfuric acid tends to creep over the lip of the crucible or where, despite precautions, some of the test portion tends to be lost by violent reaction (frequently in the case of PVC), the concentrated sulfuric acid may be replaced by a mixture of concentrated acetic and sulfuric acids. The use of these mixed acids shall be agreed between the interested parties and reference made to it in the test report.

**5.5.4** Proceed as specified in 5.4.3, 5.4.4 and 5.4.5.

## 6 Number of tests

The number of tests and the permissible scatter of results should normally be stated in the particular standard for each material. If such information is not available, carry out two determinations, repeating the test as necessary until the results of two successive determinations do not differ from each other by more than 10 % of their mean.

## 7 Expression of results

The ash or sulfated ash, expressed as a percentage by mass, is given by the formula

$$\frac{m_1}{m_0} \times 100$$

where

$m_0$  is the mass, in grams, of the dried test portion;

$m_1$  is the mass, in grams, of the ash obtained.

## 8 Precision

Precision data have been determined by collaborative testing involving eight laboratories and eight different materials. The results are summarized in table 2.

**Table 2 — Summary of precision data**

Material/filler	Mean ash %	$s_r$	$s_R$	$r$	$R$
HDPE/antiblock	0,015	0,003 8	0,005 2	0,010 7	0,014 6
LDPE/antiblock	0,149	0,004 7	0,005 4	0,013 2	0,015 1
LDPE/antiblock	0,437	0,004 7	0,005 9	0,013 1	0,016 5
LDPE/antiblock	1,00	0,009 0	0,009 0	0,025 3	0,025 3
PET/SiO <sub>2</sub>	3,18	0,044 8	0,044 8	0,125 3	0,125 3
PET/TiO <sub>2</sub>	12,46	0,046 1	0,051 5	0,129 2	0,144 1
PA/glass	33,16	0,271 5	0,282 2	0,760 2	0,790 2
PET/TiO <sub>2</sub>	44,81	0,370 7	0,400 0	1,037 9	1,120 1

NOTE —

$s_r$  is the repeatability standard deviation.  
 $s_R$  is the reproducibility standard deviation.  
 $r$  is the repeatability limit, i.e. the value below which the absolute difference between two single test results obtained under repeatability conditions (same operator, same apparatus, same laboratory and within a short interval of time) may be expected to lie with a probability of 95 %.  
 $R$  is the reproducibility limit, i.e. the value below which the absolute difference between two single test results obtained under reproducibility conditions (different operators, different apparatus, different laboratories) may be expected to lie with a probability of 95 %.

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## 9 Test report

The test report shall include the following particulars:

- a reference to this International Standard;
- all details necessary for complete identification of the material tested;
- the method used (A, B or C) and, if the acetic and sulfuric acid mixture was used, a statement to this effect (see 5.5.3, last paragraph);
- the calcining temperature used;
- the number of test portions used, and the mass of each;
- the results and their scatter.

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