
**Plastics — Acquisition and presentation of
comparable single-point data —**

**Part 1:
Moulding materials**

*Plastiques — Acquisition et présentation des caractéristiques intrinsèques
comparables —*

Partie 1: Matériaux pour moulage



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.

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 10350-1 was prepared by Technical Committee ISO/TC 61, *Plastics*, Subcommittee SC 2, *Mechanical properties*.

Together with part 2, this part of ISO 10350 cancels and replaces ISO 10350:1993, which has been technically revised.

ISO 10350 consists of the following parts, under the general title *Plastics — Acquisition and presentation of comparable single-point data*:

- *Part 1: Moulding materials*
- *Part 2: Reinforced plastics*

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Introduction

ISO 10350 has been prepared because users of plastics find that available data cannot always be readily used to compare the properties of similar materials, especially when the data have been supplied by different sources. Even when the same standard tests have been used, they often allow the adoption of a wide range of alternative test conditions, and the data obtained are not necessarily comparable. The purpose of ISO 10350 is to identify specific methods and conditions of test to be used for the acquisition and presentation of data in order that valid comparisons between materials can be made.

ISO 10350 is concerned with tests employed to present "single-point" data on the limited range of properties commonly included in data sheets and used for the preliminary selection of materials. Such data represent the most basic approach to the specification of properties of materials and the standard thus facilitates the first steps towards more efficient selection and use of plastics in the many applications to which they are suited.

Complementary International Standards (ISO 11403, parts 1, 2 and 3)¹⁾ are concerned with the standardized acquisition and presentation of multi-point data, to demonstrate how properties vary with important factors such as time, temperature and the presence of particular natural and chemical environments. In these standards, some additional properties are included. Their use will provide a more substantial database than one containing only single-point data, and so will enable improved assessment of the fitness of a material for any particular application. In addition, ISO 11403-1, which deals with mechanical properties, assists predictions of the performance of components and ISO 11403-2, covering thermal and processing properties, aids predictions of melt-flow behaviour during manufacturing. ISO 11403-3 is concerned with environmental influences on properties, and other parts may be prepared to cover additional properties.

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1) ISO 11403-1:1994, *Plastics — Acquisition and presentation of comparable multipoint data — Part 1: Mechanical properties.*

ISO 11403-2:1995, *Plastics — Acquisition and presentation of comparable multipoint data — Part 2: Thermal and processing properties.*

ISO 11403-3 (to be published), *Plastics — Acquisition and presentation of comparable multipoint data — Part 3: Environmental influences on properties.*

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Plastics — Acquisition and presentation of comparable single-point data

Part 1: Moulding materials

1 Scope

ISO 10350 identifies specific test procedures for the acquisition and presentation of comparable data for certain basic properties of plastics. In general, each property is specified by a single experimental value, although in certain cases properties are represented by two values obtained under different test conditions. The properties included are those presented conventionally in manufacturers' data sheets. This part of ISO 10350 applies predominantly to unreinforced and reinforced thermoplastic and thermosetting materials that may be injection- or compression-moulded or prepared as sheets of specified thickness. Part 2 deals specifically with long- or continuous-fibre-reinforced plastics. For the purposes of ISO 10350, long-fibre-reinforced plastics are considered to have fibre lengths greater than 7,5 mm prior to moulding.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 10350. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 10350 are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 62:—²⁾, *Plastics — Determination of water absorption.*

ISO 75-2:1993, *Plastics — Determination of temperature of deflection under load — Part 2: Plastics and ebonite.*

ISO 178:1993, *Plastics — Determination of flexural properties.*

ISO 179-1:—³⁾, *Plastics — Determination of Charpy impact properties — Part 1: Non-instrumented impact test.*

ISO 179-2:1997, *Plastics — Determination of Charpy impact properties — Part 2: Instrumented impact test.*

ISO 291:1997, *Plastics — Standard atmospheres for conditioning and testing.*

ISO 293:1986, *Plastics — Compression moulding test specimens of thermoplastic materials.*

ISO 294-1:1996, *Plastics — Injection moulding of test specimens of thermoplastic materials — Part 1: General principles and moulding of multipurpose and bar test specimens.*

ISO 294-3:1996, *Plastics — Injection moulding of test specimens of thermoplastic materials — Part 3: Small plates.*

2) To be published. (Revision of ISO 62:1980)

3) To be published. (Revision of ISO 179:1993)

- ISO 294-4:1997, *Plastics — Injection moulding of test specimens of thermoplastic materials — Part 4: Determination of moulding shrinkage.*
- ISO 295:1991, *Plastics — Compression moulding of test specimens of thermosetting materials.*
- ISO 306:1994, *Plastics — Thermoplastic materials — Determination of Vicat softening temperature.*
- ISO 527-1:1993, *Plastics — Determination of tensile properties — Part 1: General principles.*
- ISO 527-2:1993, *Plastics — Determination of tensile properties — Part 2: Test conditions for moulding and extrusion plastics.*
- ISO 899-1:1993, *Plastics — Determination of creep behaviour — Part 1: Tensile creep.*
- ISO 1133:1997, *Plastics — Determination of the melt mass-flow rate (MFR) and the melt volume-flow rate (MVR) of thermoplastics.*
- ISO 1183:1987, *Plastics — Methods for determining the density and relative density of non-cellular plastics.*
- ISO 1210/IEC 60695-11-10:—⁴⁾, *Determination of the burning behaviour of horizontal and vertical specimens in contact with a small-flame (50 W) ignition source.*
- ISO 2577:1984, *Plastics — Thermosetting moulding materials — Determination of shrinkage.*
- ISO 2818:1994, *Plastics — Preparation of test specimens by machining.*
- ISO 3167:1993, *Plastics — Multipurpose test specimens.*
- ISO 4589-2:1996, *Plastics — Determination of burning behaviour by oxygen index — Part 2: Ambient-temperature test.*
- ISO 6603-2:—⁵⁾, *Plastics — Determination of puncture impact behaviour of rigid plastics — Part 2: Instrumented puncture test.*
- ISO 8256:1990, *Plastics — Determination of tensile-impact strength.*
- ISO 10351/IEC 60695-11-20:—⁶⁾, *Determination of the burning behaviour of specimens using a 500 W flame source.*
- ISO 10724-1:1998, *Plastics — Injection moulding of test specimens of thermosetting materials — Part 1: General principles and moulding of multipurpose test specimens.*
- ISO 10724-2:1998, *Plastics — Injection moulding of test specimens of thermosetting materials — Part 2: Small plates.*
- ISO 11357-2:—⁷⁾, *Plastics — Differential scanning calorimetry (DSC) — Part 2: Determination of glass transition temperature.*
- ISO 11357-3:—⁷⁾, *Plastics — Differential scanning calorimetry (DSC) — Part 3: Determination of temperature and enthalpy of melting and crystallization.*
- ISO 11359-2:—⁷⁾, *Plastics — Thermomechanical analysis (TMA) — Part 2: Determination of coefficient of linear thermal expansion and glass transition temperature.*

4) To be published. (Revision of ISO 1210:1992)

5) To be published. (Revision of ISO 6603-2:1989)

6) To be published. (Revision of ISO 10351:1992)

7) To be published.

IEC 60093:1980, *Methods of test for volume resistivity and surface resistivity of solid electrical insulating materials.*

IEC 60112:1979, *Method for determining the comparative and the proof tracking indices of solid insulating materials under moist conditions.*

IEC 60243-1:1998, *Electrical strength of insulating materials — Test methods — Part 1: Tests at power frequencies.*

IEC 60250:1969, *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 60296:1982, *Specification for unused mineral insulating oils for transformers and switchgear.*

3 Definition

For the purposes of this part of ISO 10350, the following definition applies.

3.1

single-point data

data characterizing a plastics material by means of those property tests in which important aspects of performance can be described with single-value results.

4 Specimen preparation and conditioning

In the preparation of specimens by injection moulding or compression moulding, the procedures described in ISO 293, ISO 294-1 and -3, ISO 295 or ISO 10724-1 and -2 shall be used. The moulding method and the conditions will depend upon the material being moulded. If these conditions are specified in the International Standard appropriate to the material, then they shall be adopted for the preparation of every specimen on which data are obtained using this part of ISO 10350. For those plastics for which moulding conditions have not yet been standardized, the conditions employed shall be within the range recommended by the polymer manufacturer and shall, for each of the processing methods, be the same for every specimen.

Where moulding conditions are not stipulated in any International Standard, the values used for the parameters in table 1 shall be recorded with the single-point data for that material. Where specimens are prepared by machining from compression-moulded sheet, the machining shall be performed in accordance with ISO 2818 and the dimensions of the specimen shall comply with those for the appropriate specimen in table 2.

For materials that have properties that are not significantly sensitive to any absorbed water, specimens shall be conditioned in accordance with the International Standard appropriate to the material concerned. If no materials standard is available, condition test specimens at $23\text{ °C} \pm 2\text{ °C}$ and $(50 \pm 10)\text{ \% RH}$ for a minimum length of time of 88 h (see ISO 291).

For those materials having properties that are significantly dependent upon the concentration of any absorbed water, data shall be presented both for material that is dry and also for material that is in equilibrium with an atmosphere of 50 % RH at 23 °C but with the following exceptions (see table 2).

Rheological properties 1.1 to 1.6	-	dry only
Creep modulus 2.8 and 2.9	-	50 % RH only
Thermal properties 3.1 to 3.8	-	dry only
Surface resistivity and comparative tracking index 4.6 and 4.9	-	50 % RH only

For these materials, consult the relevant materials standard for procedures for conditioning specimens to achieve material that is dry or in equilibrium under 50 % RH. Following such conditioning, all test specimens shall be stored at $23\text{ °C} \pm 2\text{ °C}$ for a minimum of 16 h before testing. The storage atmosphere shall then be either dry or at 50 % RH, depending upon the condition of the specimen.

Table 1 — Moulding parameters

Moulding-material type	Moulding method and standard (where applicable)	Moulding parameters
Thermoplastic	Injection ISO 294-1 and -3	Melt temperature Mould temperature Injection velocity ¹⁾ Cavity pressure at hold ²⁾
	Compression ISO 293	Moulding temperature Moulding time Cooling rate Demoulding temperature
Thermosetting	Injection ISO 10724-1 and -2	Injection temperature Mould temperature Injection velocity Cure time
	Compression ISO 295	Mould temperature Mould pressure Cure time

1) Values specified in materials standards refer to the preparation of the multipurpose test specimen only (ISO 294-1, mould type A). For the preparation of standard specimens of the 80 mm × 10 mm × 4 mm bar (ISO 294-1, mould type B) and of the plate (ISO 294-3, mould types D1 and D2), values for the injection velocity shall be chosen to give an injection time comparable to that achieved with the multipurpose test specimen.

2) Only to be recorded for the 60 mm × 60 mm × 2 mm plate specimen in ISO 294-3 and -4 when used for the determination of moulding shrinkage.

5 Test requirements

The test methods, test conditions and units specified in table 2 shall be used when determining data.

6 Presentation of results

The presentation of data shall be as shown in table 2, and the data shall be preceded by information that identifies the material together with the information required by clause 4 where appropriate. Indicate also whether the specimens tested were dry, in equilibrium with an atmosphere of 50 % RH at 23 °C or whether properties are insensitive to the presence of water.

Test the minimum number of specimens that is specified for each property in the associated test method standard (see note). Record the mean value for each property (or the central value if this is stipulated in the test method standard) in the "value" column.

NOTE — In order that the value recorded for each property is as representative as possible of the material being tested, it is recommended that test specimens are prepared from at least three samples of the material taken from the production of the material over an extended timescale.

Table 2 — Test conditions and format for the presentation of single-point data (see note 1)

Property	Symbol	Standard	Specimen type (dimensions in mm)	Value	Unit	Test conditions and supplementary instructions
1 Rheological properties (for properties 1.1 to 1.6, see statement in clause 4)						
1.1 Melt mass-flow rate	MFR	ISO 1133	Moulding compound		g/10 min	Use and record test conditions for temperature and load specified in the appropriate materials standard
1.2 Melt volume-flow rate (see note 2)	MVR				cm ³ /10 min	
1.3 Moulding shrinkage of thermosetting polymers	S_{Mp} S_{Mn}	ISO 2577			%	Parallel Normal See note 3
1.4						
1.5 Moulding shrinkage of thermoplastics	S_{Mp} S_{Mn}	ISO 294-4	60 × 60 × 2 ISO 294-3 type D2 (see note 4)		%	Parallel Normal See note 3
1.6						
2 Mechanical properties (for properties 2.8 and 2.9, see statement in clause 4)						
2.1 Tensile modulus	E_t				MPa	Test speed 1 mm/min
2.2 Yield stress	σ_y					
2.3 Yield strain	ϵ_y				%	
2.4 Nominal strain at break	ϵ_B	ISO 527-1 and 527-2				See note 6 and figure 1
2.5 Stress at 50 % strain	σ_{50}		ISO 3167 (see note 5)		MPa	Failure without yielding $\epsilon_B \leq 10\%$: test speed 5 mm/min $\epsilon_B > 10\%$: test speed 50 mm/min (see note 8)
2.6 Stress at break	σ_B					
2.7 Strain at break	ϵ_B				%	
2.8 Tensile creep modulus	E_{tc1} $E_{tc} 10^3$	ISO 899-1			MPa	At 1 h At 1 000 h Strain < 0,5 %
2.9						
2.10 Flexural modulus	E_f	ISO 178	80 × 10 × 4 (see note 5)		MPa	Test speed 2 mm/min Optional extra information for brittle materials (see note 9)
2.11 Flexural strength	σ_{fM}					
2.12 Charpy impact strength	a_{cU}	ISO 179-1 or ISO 179-2	80 × 10 × 4 (see note 5)			Edgewise impact Also record type of failure (see note 10)
2.13 Charpy notched impact strength	a_{cA}		Machined V-notch, $r = 0,25$		kJ/m ²	
2.14 Tensile-impact strength	a_{t1}	ISO 8256	80 × 10 × 4 (see note 5) Machined double V-notch, $r = 1$			

Table 2 — Test conditions and format for the presentation of single-point data (see note 1) (continued)

Property	Symbol	Standard	Specimen type (dimensions in mm)	Value	Unit	Test conditions and supplementary instructions
2.15	F_M				N	Striker velocity 4,4 m/s Striker diameter 20 mm Lubricate the striker (see note 11) Clamp the specimen sufficiently to prevent any out of plane movement of its outer regions
2.16	W_P	ISO 6603-2	60 × 60 × 2 (see note 4)		J	Puncture energy at 50 % decrease in force after the maximum
3 Thermal properties (for properties 3.1 to 3.8, see statement in clause 4)						
3.1	T_m	ISO 11357-3	Moulding compound		°C	Record peak melting temperature Use 10 °C/min
3.2	T_g	ISO 11357-2			°C	Record midpoint temperature Use 10 °C/min
3.3	T_f 1,8					1,8
3.4	T_f 0,45	ISO 75-2	80 × 10 × 4 (see note 5)		°C	Use 1,8 MPa and one other value Use flatwise loading
3.5	T_f 8,0					8
3.6	T_V 50/50	ISO 306	≥ 10 × 10 × 4 (see note 13)		°C	Heating rate 50 °C/h Load 50 N
3.7	α_p	ISO 11359-2	Prepared from ISO 3167 (see note 13)		°C ⁻¹	Record the secant value over the temperature range 23 °C to 55 °C (see note 3)
3.8	α_n					Transverse
3.9	B50/3	ISO 1210	125 × 13 × 3			Record one of the classifications V-0, V-1, V-2, HB40 or HB75
3.10	B50/h		Greater thickness h			
3.11	B500/3	ISO 10351	≥ 150 × ≥ 150 × 3			
3.12	B500/h		Greater thickness h			Record classification 5VA, 5VB or N (see note 14)
3.13		ISO 4589-2	80 × 10 × 4 (see note 5)		%	Use procedure A (top surface ignition)

Table 2 — Test conditions and format for the presentation of single-point data (see note 1) (concluded)

Property	Symbol	Standard	Specimen type (dimensions in mm)	Value	Unit	Test conditions and supplementary instructions
4 Electrical properties (for properties 4.6 and 4.9, see statement in clause 4)						
4.1	Relative permittivity	IEC 60250	ϵ_r 100			100 Hz
4.3	Dissipation factor	IEC 60250	$\geq 60 \times \geq 60 \times 2$ (see note 4)			1 MHz
4.4	$\tan \delta$ 1M	IEC 60250	$\geq 60 \times \geq 60 \times 2$ (see note 4)			1 MHz
4.5	Volume resistivity	IEC 60093			$\Omega \cdot m$	1-minute value
4.6	Surface resistivity	IEC 60093			Ω	Use contacting line electrodes 1 mm to 2 mm wide, 50 mm long and 5 mm apart
4.7	Electric strength	IEC 60243-1	$\geq 60 \times \geq 60 \times 1$ (see notes 4 and 15)			kV/mm
4.8	E_B 2	IEC 60243-1	$\geq 60 \times \geq 60 \times 2$ (see notes 4, 15 and 16)			Use a voltage application rate of 2 kV/s
4.9	Comparative tracking index	IEC 60112	$\geq 15 \times \geq 15 \times 4$ (see note 17)			Use solution A
5 Other properties						
5.1	Water absorption	ISO 62	Thickness ≥ 1 (see note 4)			%
5.2	w_H	ISO 62	Thickness ≥ 1 (see note 4)			Equilibrium value at 23 °C, 50 % RH
5.3	Density	ISO 1183	For injection-moulded specimens, use part of the centre of the multipurpose test specimen			kg/m ³ See note 18

Notes to table 2

- 1 Use of the parameters in table 2 is essentially for the comparison of data, and certain of the instructions listed may not be appropriate for all plastics.
- 2 The ratio of melt mass-flow rate to melt volume-flow rate gives an estimate of the melt density.
- 3 Where specimens are prepared by injection moulding, record property values both parallel and normal to the direction of flow into the mould.
- 4 For test specimens prepared by injection moulding, use mould type D1 for specimens of 1 mm thickness and type D2 for specimens of 2 mm thickness (see ISO 294-3 for thermoplastics and ISO 10724-2 for thermosets). Refer to the appropriate materials standard for details of the moulding conditions for this specimen. Where these are not given, use the conditions specified for preparing the ISO 3167 multipurpose specimen but employing an injection velocity that gives the same injection time as that obtained with the multipurpose specimen.
- 5 ISO 3167 describes two types of specimen for tensile tests. The type A specimen has a lower value for the radius of the shoulders of 20 mm to 25 mm which thereby enables a central region to be obtained of length at least 80 mm. The standard ISO bar having dimensions 80 mm × 10 mm × 4 mm can thus be cut from the central region of this type of test specimen which is therefore recommended for directly moulded specimens. The type B specimen has a larger shoulder radius of > 60 mm and is recommended for machined specimens.
- 6 The data to be recorded for the properties in 2.1 to 2.7 are intended to give a fair impression of the nature of the stress-strain curve to failure (see figure 1).
- 7 If the specimen shows yielding when tested at a speed of 50 mm/min, then the test speed for data acquisition shall be 50 mm/min and the values for yield stress and strain and the nominal strain at break shall be recorded. If rupture occurs above 50 % nominal strain, record either the measured value of the nominal strain at break or simply record "> 50".

The determination of the nominal strain is based upon the initial and final grip separations instead of extensometer measurements.
- 8 If the specimen has a breaking strain beyond 10 % when tested at a speed of 50 mm/min but does not show a yield point below 50 % strain, record the stress and strain at break. If rupture occurs above 50 % strain, record the stress at 50 % strain and either the measured strain at break or "> 50" for this value. If the specimen shows rupture without yielding and has a strain at break of less than or equal to 10 % when tested at a speed of 50 mm/min, then the test speed for data acquisition shall be 5 mm/min and the values for stress and strain at break shall be recorded.
- 9 The flexure test generates a non-uniform stress across the cross-section of the specimen. For materials that show essentially non-linear behaviour up to failure, the derived flexural-strength value will thus depend upon the thickness of the specimen. This test is therefore not recommended for these materials. For materials that show predominantly linear behaviour up to failure, the inclusion of data using this test is optional. However, it should be noted that, for injection-moulded or reinforced materials, where the structure often varies through the cross-section of the specimen, values for flexural properties may be different from those obtained in tension.
- 10 After testing, classify test results according to the three types of failure defined in ISO 179-1 and -2:
 - C — complete break or hinge break;
 - P — partial break;
 - N — no break.

Select the test results for the type of failure that occurs most frequently and record the mean value of the impact strength and the corresponding failure type C, P or N.