
Plastics — Determination of drawing characteristics of thermoplastics in the molten state

Plastiques — Détermination des caractéristiques d'étirage des thermoplastiques à l'état fondu

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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 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).

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 5, *Physical-chemical properties*.

This second edition cancels and replaces the first edition (ISO 16790:2005), which has been technically revised.

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

- the normative references have been updated;
- the figure keys have been completed;
- the test procedure and parameters have been revised.

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.

Plastics — Determination of drawing characteristics of thermoplastics in the molten state

1 Scope

This document specifies a method for determining the drawing and break characteristics of molten plastics. The method involves the measurement of the force generated in deforming a molten filament under defined extrusion temperature and drawing conditions.

Data is generated under non-isothermal and non-homogeneous deformation conditions. However, it is useful for the interpretation of polymer behaviour in extensional flow.

The method is suitable for thermoplastics moulding and extrusion materials that can be extruded using a capillary extrusion rheometer, or an extruder with capillary rod die or other extrusion devices and have sufficient melt strength to be handled without difficulty.

The method is applicable to chemically stable materials that produce a uniform extrudate free from heterogeneities, bubbles, unmelted impurities, etc.

This method can provide information on

- processability for all extrusion techniques,
- the effect of mechanical and thermal history, and
- the effect of chemical structure, such as branching, entanglements and molecular mass.

This technique is one of a number of techniques that can be used to measure the extensional flow behaviour of a material. This method of measurement does not necessarily reproduce the drawing conditions to which thermoplastics are subjected to during their processing.

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

ISO 11443, *Plastics — Determination of the fluidity of plastics using capillary and slit-die rheometers*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

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/>

3.1

drawing

process of stretching a filament of polymer melt that is being continuously formed by a capillary extrusion rheometer or extruder or other extrusion device

**3.2
melt strength**

F_b
value of the melt tension at break of the extrudate

Note 1 to entry: Also known as the force to break.

Note 2 to entry: It is expressed in newtons.

**3.3
draw ratio at break
DR**

ratio of the *drawing velocity* (3.7) of the material at break to the *mean velocity* (3.4) of the material flowing from the die

**3.4
mean velocity**

v_m
average velocity of the extrudate at the die exit, determined as the ratio of volume flow rate to die cross-sectional area

Note 1 to entry: It is expressed in metres per second.

**3.5
initial diameter**

D_i
maximum diameter the extrudate attains after swelling on exiting from the die, the extrudate not yet having been subjected to significant drawing

Note 1 to entry: Initial diameter is expressed in metres.

Note 2 to entry: If no swelling of the extrudate occurs after exiting the die, the initial diameter is taken as the diameter of the die.

Note 3 to entry: This method can be unsuitable for testing materials that do not exhibit swelling of the extrudate after exiting the die as such materials will be difficult to handle in drawing off and will exhibit small *drawing forces* (3.8).

**3.6
initial velocity**

v_i
velocity of the extrudate near the die exit after swelling, the extrudate not yet having been subjected to significant *drawing* (3.1)

Note 1 to entry: It is determined at the position of the initial diameter of the extrudate.

Note 2 to entry: It is expressed in metres per second.

**3.7
drawing velocity**

v_t
velocity imposed on the lower end of the extrudate by the drawing unit

Note 1 to entry: It is expressed in metres per second.

**3.8
drawing force**

F_t
force exerted on the extrudate by the drawing unit

Note 1 to entry: It is expressed in newtons.

3.9 drawing length

 l_e

distance between the die exit and the point where the extrudate first contacts the drawing unit's rotating wheels

Note 1 to entry: It is expressed in metres.

3.10 drawing acceleration

 a

rate of increase in the *drawing velocity* (3.7)

Note 1 to entry: It is expressed in metres per square second.

3.11 drawing velocity at break

 v_b

velocity recorded at break when a constant *drawing acceleration* (3.10) is used

Note 1 to entry: It is expressed in metres per second.

4 Principle

Molten polymer is extruded from a capillary rheometer, extruder or other extrusion device at a specified temperature. The extrudate is drawn from the die by take-off wheels. Two techniques are used.

- a) A series of take-off wheel velocities is used to determine the drawing force as a function of the drawing velocity.
- b) A constant rate of acceleration of the take-off wheels is used to determine the melt strength (force to break) of the extrudate.

5 Apparatus

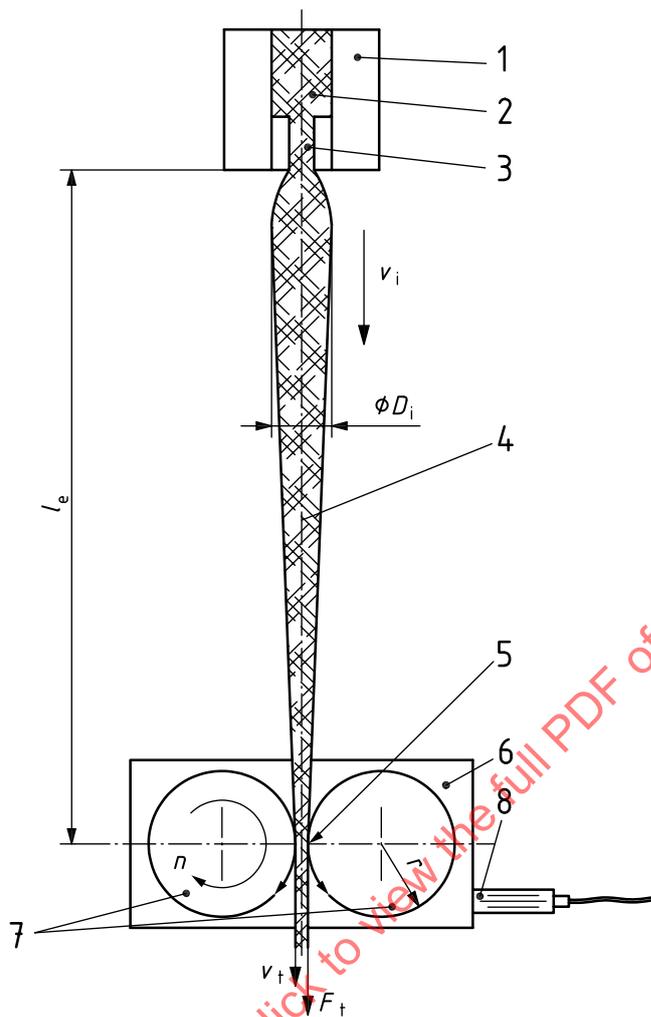
5.1 Apparatus for heating the polymer and forming the extrudate

5.1.1 General

The device to supply the molten polymer at a controlled temperature and flow rate shall consist of a heatable barrel [either a capillary extrusion rheometer (5.1.2) or an extruder (5.1.3)], the bore of which is closed at the bottom end by a die (see Figure 1). The test pressure shall be exerted on the melt contained in the barrel by a piston, a screw or pressurized gas.

5.1.2 Capillary extrusion rheometer

If a capillary extrusion rheometer is used, it shall have capillary dies, a piston, a temperature-measuring device and a pressure-measuring device meeting the requirements of ISO 11443.



Key

- 1 rheometer or extruder
- 2 melt (temperature, T)
- 3 capillary (diameter, D ; length, l)
- 4 axis
- 5 extrudate/roller contact
- 6 drawing bench
- 7 drive rollers (radius, r ; rotational speed, n)
- 8 data acquisition (drawing force, F_t)
- D_i initial diameter
- l_e drawing length
- v_i initial velocity
- v_t drawing velocity ($= 2\pi rn$)

Figure 1 — Drawing unit — Direct drawing by two take-off rollers

5.1.3 Extruder

5.1.3.1 General

If an extruder is used, it shall be a small extruder with a screw diameter of 25 mm or less. This unit shall be equipped with a rod die and temperature-measuring device.

5.1.3.2 Melt pump

If available, a melt pump may be used to provide a uniform flow of material from the extruder to the die. If a melt pump is used, an extruder with a screw diameter larger than 25 mm may be used.

5.1.3.3 Dies

The die, of known dimensions, shall be angled vertically downwards to allow gravity to act on the extrudate.

For determining the apparent shear rate $\dot{\gamma}_{ap}$ and the apparent shear stress, τ_{ap} with one capillary die, in accordance with ISO 11443, the ratio l/D of the length, l , to the diameter, D , of the die shall be at least 16:1 and its inlet angle shall be 180° .

5.1.3.4 Temperature-measuring device

To measure the temperature of the molten polymer (see 6.2), thermocouples or platinum resistance sensors are preferred, but thermometers may be used.

5.2 Apparatus for drawing the polymer extrudate

5.2.1 Drawing unit

5.2.1.1 The drawing unit shall draw the extrudate over a specified length (the drawing length) at a controlled drawing velocity and measure the resulting drawing force.

5.2.1.2 The drawing unit shall have take-off wheels to draw the extrudate.

5.2.1.3 The drawing unit shall have controllers for the speed and acceleration of the take-off wheels.

5.2.1.4 The drawing unit shall have a force sensor to measure the drawing force exerted on the extrudate.

5.2.2 Drawing unit design

Drawing may be carried out directly under the die using two rollers to take off the extrudate without excessive slippage or pinching (see [Figure 1](#)). Alternatively, it may be carried out, after the extrudate passes around the groove of one or more free-return pulley(s), by a set of two rollers that pinch and take off the extrudate without excessive slippage ([Figure 2](#) shows a possible design: other designs are applicable). Drawing can also be done by winding up the extrudate onto a single wheel. In all cases, the axis of the extrudate in contact with the rollers (see [Figure 1](#)), the first return pulley (see [Figure 2](#)) or the take-off wheel shall coincide with the capillary die axis.

Where the extrudate passes over a return roller, drawing is considered to occur only in the section between the die exit and the initial point of contact between the extrudate and the pulley groove. In this case, the speed and drawing force of the first return pulley should preferably be measured.

The return pulley may be cooled in order to prevent any sticking of the molten polymer. The same precaution may be taken for the drawing rollers. In both cases, it is important to ensure that these devices do not have a significant influence on the measurement of the drawing force due to frictional or inertial effects or on the drawing velocity and drawing acceleration due to slippage and pinching.

5.3 Data-acquisition system

The data-acquisition system shall be capable of continuously monitoring the drawing force, the drawing velocity, the temperature of the molten material, and the pressure of the melt at the entrance to the die throughout the test.

6 Calibration

6.1 General

The extruder or the rheometer shall be calibrated with respect to the measured variables and parameters, such as temperature, pressure, volume flow rates and capillary dimensions, in accordance with the procedures described in ISO 11443.

6.2 Test temperature

When capillary dies are used, the test temperature shall be either the temperature of the melt in the barrel near the capillary inlet or, if this is not possible, the temperature of the barrel wall near the capillary inlet. This also pertains to the rod die of the extruder. When the barrel wall temperature is measured, thermally conductive fluids may be used in the thermometer well to improve conduction.

The temperature-measuring device used during the test shall have a resolution of 0,1 °C and be calibrated to an accuracy of $\pm 0,5$ °C by a method traceable to certified reference standard(s).

No liquids that can contaminate the die and barrel and influence the ensuing measurements (e.g. silicone oil) shall be used as heat-transfer media during calibration. Woods metal has been found to be a suitable thermal conductor.

6.3 Capillary or rod die

The dimensions of the die shall be measured to an accuracy of $\pm 0,007$ mm for the diameter, D , and $\pm 0,025$ mm for the length, l .

For comparisons between laboratories, a die having an l to D ratio of 16 to 1 and with a 180° inlet angle shall be used.

6.4 Drawing-force transducer

Calibration of the drawing-force transducer shall be carried out in accordance with the manufacturer's recommendations. The accuracy of the force measurement system shall have a maximum permissible error of ± 1 % of full scale.

6.5 Drawing velocity and drawing acceleration

The drawing velocity and drawing acceleration shall both have a maximum permissible error of ± 1 % of full scale. The apparatus may be calibrated with respect to these parameters by measuring the time for a known length of (non-stretchable) material, e.g. paper, to traverse the drawing rollers with and without acceleration, or from measurement of the rotational speed of the drawing rollers.

6.6 Drawing length

This is measured using a device such as a ruler or tape measure. The distance shall be measured to an accuracy of within ± 5 %.

For comparisons between laboratories, the drawing length shall be 100 mm \pm 10 mm.

NOTE This short drawing length minimizes the cooling of the extrudate and thus maintains a more uniform temperature range over the entire length of the extrudate.

7 Sampling

A representative sample shall be taken from the product for use as the test sample. Any conditioning of the sample shall be as described in the material specification standard, if available, or by agreement between the interested parties, or in accordance with ISO 291.

8 Procedure

8.1 Cleaning the apparatus

Before each measurement, ensure that the barrel, pressure transducer bores (where applicable), piston and capillary die are free of foreign matter. Make a visual examination to check for cleanliness.

If solvents are used for cleaning, ensure that no contamination of the barrel, piston or capillary die has occurred that might influence the test results.

NOTE 1 For the purpose of cleaning, circular brushes made of copper/zinc alloy (brass) and linen cloths have proven satisfactory. However, the use of copper-containing materials can accelerate degradation of the polymer when testing polyethylene and polypropylene. Cleaning can also be performed by cautious burning out.

NOTE 2 Using graphite on threads facilitates their unlocking after testing.

WARNING — The operating conditions chosen can entail partial decomposition of the material under test and any materials used for cleaning purposes, or cause them to release dangerous volatile substances. Also, both the instrument and extrudate are likely to be very hot and present the risk of contact burns. The user of this document is therefore responsible for keeping him- or herself informed of possible risks of accident and for providing the appropriate means of protection.

8.2 Rheometer or extruder preparation

Assemble the capillary rheometer or the extruder with the appropriate capillary or rod die. Allow the assembled apparatus to reach thermal equilibrium at the test temperature before applying the final torque on the die (where applicable).

It is recommended that a 2 mm diameter die be used for high-viscosity materials and a 1 mm diameter die for low-viscosity materials, although selection of the die diameter should depend on the extrudability of the material.

When using an extruder, adjust the temperature of the equipment and the rotational speed of the extruder to obtain the desired melt temperature and material flow rate from the die.

Conditions for the test should be set based on the ability to handle the extrudate during take-off.

Typical test temperature ranges for several materials are given in [Table 1](#) (see Note). [Table 1](#) also includes a temperature that should be used to allow comparisons between laboratories as a quality control check.

NOTE The most useful data are generally obtained at temperatures, shear stresses and shear rates used in processing of the material.

Table 1 — Typical test temperatures

Material	Temperature range	Temperature for comparison
	°C	°C
Polyacetal	190 to 220	190
Polyacrylate	140 to 300	230
Acrylonitrile/butadiene/styrene (ABS)	200 to 280	220
Cellulose esters	190 to 210	190
Polyamide	190 to 300	235
Polybutylene	160 to 250	190
Poly(chlorotrifluoroethylene)	185 to 310	265
Polyethylene and ethylene copolymers and terpolymers	150 to 250	190
Polycarbonate	260 to 300	300
Polypropylene	180 to 270	230
Polystyrene and styrene copolymers	180 to 280	200
Poly(vinyl chloride)	170 to 210	175
Poly(butylene terephthalate)	245 to 270	250
Poly(ethylene terephthalate)	275 to 300	285
PMMA and copolymers	180 to 300	230
Poly(vinylidene fluoride)	195 to 240	230
Poly(vinylidene chloride)	150 to 170	150
Ethylene/vinyl alcohol copolymer	190 to 230	190
Polyetheretherketone	340 to 380	372
Polyethersulfone	330 to 380	372

8.3 Loading the capillary rheometer barrel

To avoid air inclusions in the capillary rheometer, introduce the sample into the barrel in separate small quantities, performing intermediate compactions by means of a piston. Fill the barrel to within approximately 12,5 mm of the top. Accomplish charging in a maximum of 2 min.

8.4 Preheating

For the capillary rheometer, immediately after charging the barrel, start the preheat timer. Extrude a small portion of the charge out of the barrel. Stop the extrusion and wait until a preheat time of at least 5 min is completed, unless otherwise specified by the referring standard.

Check that the preheat time used is sufficient to obtain thermal equilibrium of the test sample throughout the volume of the barrel for each material to be tested. This can be done by ensuring that on increasing the preheat time the measured quantity (e.g. pressure) at constant test conditions does not change by more than $\pm 5\%$, or by inserting a thermometer into the sample in the barrel and ensuring that the temperature is equal to the specified test temperature within the tolerance for the distance- and time-related temperature differences given in [Table 2](#).

Then extrude a small quantity of the substance under test, stop the piston, wait for 1 min and perform the measurement.

Table 2 — Maximum allowable temperature differences as a function of distance and as a function of time

Test temperature, T °C	Temperature differences °C	
	As a function of distance ^a	As a function of time ^b
≤200	±1,0	±0,5
200 < T ≤ 300	±1,5	±1,0
>300	±2,0	±1,5

^a Over the distance of 10 mm to 75 mm above the die.
^b Measured at 10 mm above the die.

8.5 Running the extruder

Progressively bring the screw rotational speed up to the speed at which the test will be run. After approximately 15 min, check that the extrusion is stable by monitoring the variation in the melt pressure and the melt temperature for a minimum of 30 s. The melt pressure shall vary by no more than ±5 % and the temperature by no more than ±1 °C. If the melt pressure shows higher than normal variation, a melt pump shall be used to reduce the variation, or an alternative acceptable extruder shall be used.

8.6 Preliminary checks of the extrudates

8.6.1 Absence of defects

8.6.1.1 If there is a homogeneity defect (particles, bubbles, non-melting impurities, etc.), investigate the potential external causes (e.g. contamination of the material), modify the material preconditioning (e.g. drying) or adjust the extrusion conditions to remove the defect.

8.6.1.2 If there are surface finish defects (melt fracture, etc.), modify the test conditions (material temperature, flow rate, capillary diameter, etc.) that influence the flow of the extrudate to remove the defect.

8.6.2 Check on drawing down under gravity

8.6.2.1 Check that the extrudate flowing freely from the die does not stretch significantly under its own weight, nor shrink significantly due to material relaxation. Shrinkage can be detected by shortening of the extrudate upon stopping the flow. A tendency to stretch is demonstrated by a reduction in the diameter of the extrudate just after exiting from the capillary. The degree of diameter reduction can be determined as described in [8.6.2.2](#) to [8.6.2.6](#).

8.6.2.2 Allow the extrudate to flow onto a plate positioned below the capillary at a vertical distance equal to the drawing length, l_e .

8.6.2.3 Then cut the extrudate for the first time roughly 30 mm from the capillary exit. Allow the extrudate to flow until its length reaches 60 mm and cut it a second time at the capillary exit (see [Figure 3](#)).

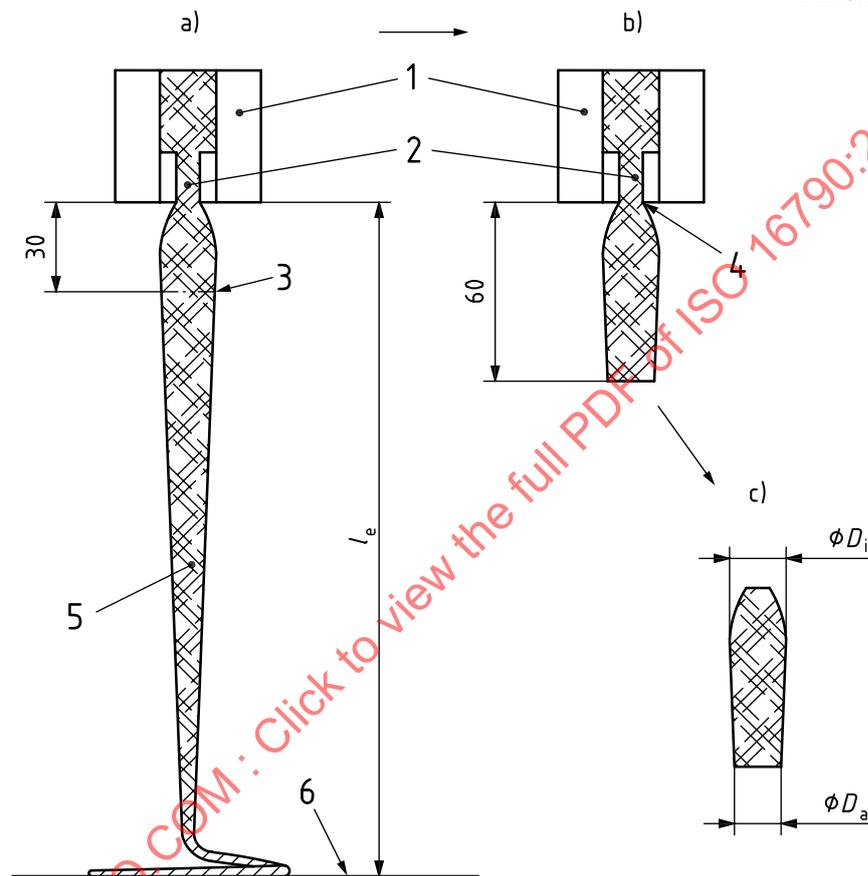
8.6.2.4 Carefully seize this extrudate with tongs, taking care not to damage the cut ends, and allow it to cool down to room temperature.

8.6.2.5 Compare the diameter, D_a , at a point just above the first cut to the maximum diameter, D_i , just below the end of the extrudate where the second cut was made (see [Figure 3](#)). The smaller diameter, D_a , is a result of extrudate draw-down.

8.6.2.6 If the ratio of the diameters D_a/D_i is less than 0,9, the extrudate is considered to be susceptible to stretching under the sole effect of its weight. If the ratio is less than 0,9, modify the extrusion conditions by reducing the melt temperature or increasing the extrusion rate until a ratio of at least 0,9 is obtained. If this is not possible, set the extrusion conditions to get the ratio as close as possible to 0,9. If the ratio remains less than 0,9, record this in the test report.

NOTE The factor of 0,9 is significant in that if the ratio is below this value it means that gravity is playing a significant role in the measurement and the true force of the drawing is not being measured.

Dimensions in millimetres



Key

- 1 rheometer or extruder
- 2 capillary (diameter, D ; length, l)
- 3 first cut
- 4 second cut
- 5 strand
- 6 plate
- D_i initial diameter (maximum diameter of extrudate)
- D_a diameter at lower end of extrudate
- l_e drawing length

Figure 3 — Extrusion of an extrudate without drawing — Verification of non-elongation of the extrudate

8.7 Determination of the extrudate behaviour

8.7.1 Determination of the mean velocity

When using a screw extruder, with the extrusion parameters set and stable conditions attained, measure the mass flow rate Q by weighing the quantity of material extruded from the die in 1 min. Weigh the extrudate to an accuracy of ± 1 g.

NOTE 1 The mass flow rate Q corresponds to the mean velocity, v_m , of the extrudate flow exiting from the die. This mean velocity is normally slightly higher than the initial velocity, v_i , which takes into account the extrudate swelling near the die exit.

NOTE 2 Do not confuse the mass flow rate Q with the melt mass-flow rate (MFR) obtained using ISO 1133-1 or ISO 1133-2.

The mean velocity is given by [Formula \(1\)](#):

$$v_m = Q / (\rho_T \times S_T) \quad (1)$$

where

v_m is the mean velocity, expressed in metres per second;

Q is the extrudate mass flow rate, expressed in kilograms per second;

ρ_T is the melt density at temperature, T , expressed in kilograms per cubic metre;

S_T is the capillary cross-sectional area at temperature, T , expressed in square metres.

When using a piston-driven extruder, determine the mass flow rate Q from the piston speed and diameter and the density of the melt.

NOTE 3 When using a piston-driven extruder, the mean velocity can be determined from the piston speed and the diameters of the piston and die, without recourse to the melt density.

8.7.2 Determination of the drawing force as a function of the drawing velocity

8.7.2.1 Position the drawing unit underneath the capillary exit at the prescribed drawing length and engage the extrudate. A suitable drawing velocity for start-up is 0,012 5 m/s, although this will vary from material to material and from temperature to temperature.

8.7.2.2 Start recording the drawing force and drawing velocity.

8.7.2.3 Increase the drawing velocity until it is equal to the initial velocity of the extrudate. For an extrudate which is drawing down under its own weight, the velocity at the drawing unit will be higher than the initial velocity and thus material will build up at the drawing unit. Increase the speed until the wheel speed matches the extrudate speed at the wheel. This is referred to as the minimum drawing velocity. If there is material shrinkage, the drawing velocity shall be set to the initial velocity.

8.7.2.4 After the extrudate has stabilized and baseline signals have been recorded for these conditions, increase the drawing velocity so as to show a measurable force on the drawn extrudate, by observing the indications of the force transducer.

8.7.2.5 In systems where the take-off system has two take-off wheels (see [Figure 1](#)), it is necessary to keep the amount of material below the take-off to a minimum to eliminate post-tensioning effects.

8.7.2.6 Wait for a minimum of 30 s for the applied drawing force to stabilize. Record the drawing force, F_v and the drawing velocity, v_v for this first stage of measurement.

8.7.2.7 Continue to make additional measurements by increasing the drawing velocity in successive increments, waiting a minimum of 30 s for the resultant load to stabilize for each measurement.

8.7.2.8 Continue to increase the drawing velocity until extrudate break occurs. Velocity increases shall be made such that at least six force measurements are made at different velocities before break occurs.

8.7.2.9 Repeat the procedure a minimum of two additional times to determine the repeatability of the measurement.

8.7.3 Measurement of melt strength

8.7.3.1 Set the drawing velocity of the take-off wheels to a value slightly below the minimum drawing velocity observed in the initial study of drawing force versus drawing velocity (see 8.7.2.3). Insert the melt strand between the drive rollers, and then close the rollers to firmly grip the melt strand. A suitable drawing velocity for start-up is 0,012 5 m/s, although this will vary from material to material and from temperature to temperature.

NOTE Very low mean velocities and drawing velocities can lead to solidification of the extrudate. Therefore, proper selection of the mean velocity and the drawing velocity is important to prevent even partially solidified extrudate (skin formation) that can falsify the melt strength results.

8.7.3.2 Start recording the drawing force and drawing velocity.

8.7.3.3 Increase the drawing velocity until it is equal to the minimum drawing velocity.

8.7.3.4 After the extrudate has stabilized and baseline signals have been recorded for these conditions, start the constant acceleration. Note when acceleration is applied.

A suitable starting value for the acceleration is 0,000 6 m/s², although this setting is material- and temperature-dependent.

In case a capillary rheometer is being used to supply the molten polymer, the combination of a high mean velocity, v_m , with a low drawing acceleration a may lead to the barrel being emptied before the ultimate value of the melt strength is achieved. In addition, the choice of the drawing acceleration needs to take into account both the time interval until breakage of the filament for proper data acquisition, and likewise prevention of solidification of the extrudate during the melt strength determination (see also NOTE in 8.7.3.1). Preferably, the drawing acceleration chosen does not lead to pronounced draw resonance of the extruded filament.

For polyolefins at test temperatures around 200 °C, values from 0,02 m/s² up to 0,12 m/s² have been found to be a good compromise in day-to-day testing.

Lower values of 0,000 8 m/s², 0,001 0 m/s² and 0,001 2 m/s² have been likewise recommended in the past.

The initial velocity and acceleration values used are dependent on the elasticity of the material being tested. If the material exhibits very low elasticity, as indicated by breakage of the extrudate early on in the test, then reduce the acceleration.

8.7.3.5 Once the melt strand has broken and the force has returned to zero, disengage the take-off wheels.

8.7.3.6 Record the time to break, the melt strength and the draw ratio at break.

8.7.3.7 A minimum of three determinations are recommended to determine the data repeatability.