

# ISO 294-4:2018-12 (E)

## Plastics - Injection moulding of test specimens of thermoplastic materials - Part 4: Determination of moulding shrinkage

---

<b>Contents</b>		<b>Page</b>
Foreword .....		iv
Introduction .....		v
1	Scope .....	1
2	Normative references .....	1
3	Terms and definitions .....	1
4	Apparatus .....	2
5	Procedure .....	3
5.1	Conditioning of material .....	3
5.2	Injection moulding .....	3
5.3	Measurement of mould temperature .....	4
5.4	Measurement of melt temperature .....	4
5.5	Treatment of test specimens after demoulding .....	4
5.6	Measurement of moulding shrinkage .....	5
5.7	Treatment following measurement of moulding shrinkage .....	5
5.8	Measurement of post-moulding shrinkage .....	5
6	Expression of results .....	6
6.1	Moulding shrinkage .....	6
6.2	Post-moulding shrinkage .....	6
6.3	Total shrinkage .....	6
7	Precision .....	7
8	Test report .....	7
Annex A (informative) Reference points for length and width measurement .....		8
Bibliography .....		9