

ISO 1133-1:2022-06 (E)

Plastics - Determination of the melt mass-flow rate (MFR) and melt volume-flow rate (MVR) of thermoplastics - Part 1: Standard method

Contents		Page
Foreword		v
Introduction		vi
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	Principle	2
5	Apparatus	3
5.1	Extrusion plastometer	3
5.2	Accessory equipment	7
5.2.1	General	7
5.2.2	Equipment for procedure A (see Clause 8)	8
5.2.3	Equipment for procedure B (see Clause 9): Piston displacement transducer/ timer	8
6	Test sample	8
6.1	Sample form	8
6.2	Conditioning	9
7	Temperature verification, cleaning and maintenance of the apparatus	9
7.1	Verification of the temperature control system	9
7.1.1	Verification procedure	9
7.1.2	Material used during temperature verification	10
7.2	Cleaning the apparatus	10
7.3	Vertical alignment of the instrument	10
8	Procedure A: mass-measurement method	10
8.1	Selection of temperature and load	10
8.2	Cleaning	11
8.3	Selection of sample mass and charging the cylinder	11
8.4	Measurements	12
8.5	Expression of results	13
8.5.1	General	13
8.5.2	Expression of results: standard die	13
8.5.3	Expression of results: half size die	13
9	Procedure B: displacement-measurement method	14
9.1	Selection of temperature and load	14
9.2	Cleaning	14
9.3	Minimum piston displacement distance	14
9.4	Selection of sample mass and charging the cylinder	14
9.5	Measurements	14
9.6	Expression of results	15
9.6.1	General	15
9.6.2	Expression of results: standard die	15
9.6.3	Expression of results: half size die	16

10	Flow rate ratio	16
11	Precision	17
12	Test report	17
	Annex A (normative) Test conditions for MFR and MVR determinations	19
	Annex B (informative) Conditions specified in International Standards for the determination of the melt flow rate of thermoplastic materials	21
	Annex C (informative) Device and procedure for performing a compacted charge of material by compression	22
	Annex D (informative) Precision data for polypropylene obtained from an intercomparison of MFR and MVR testing	25
	Bibliography	26