

ISO 294-1:2017-05 (E)

Plastics - Injection moulding of test specimens of thermoplastic materials - Part 1: General principles, and moulding of mult ipurpose and bar test specimens

Contents		Page
Foreword		iv
Introduction		v
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	Apparatus	6
4.1	Moulds	6
4.1.1	ISO (multi-cavity) moulds	6
4.1.2	Single-cavity moulds	9
4.2	Injection-moulding machine	10
4.2.1	General	10
4.2.2	Moulding volume	10
4.2.3	Control system	10
4.2.4	Screw	10
4.2.5	Clamping force	11
4.2.6	Thermometers	11
5	Procedure	11
5.1	Conditioning of material	11
5.2	Injection moulding	12
5.3	Measurement of mould temperature	13
5.4	Measurement of the melt temperature	13
5.5	Post-moulding treatment of test specimens	13
6	Report on test-specimen preparation	13
Annex A (informative)	Examples of runner configurations	15
Annex B (informative)	Standardized injection-moulding mould components	16
Annex C (informative)	Example of an injection mould	17
Annex D (informative)	Methods for setting the injection moulding parameters	18
Annex E (informative)	Methods of determining the hold pressure and hold time	23
Bibliography		29