

ISO 11443:2021-02 (E)

Plastics - Determination of the fluidity of plastics using capillary and slit-die rheometers

Contents		Page
Foreword		v
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	General principles	4
5	Apparatus	4
5.1	Test device	4
5.1.1	General	4
5.1.2	Rheometer barrel	5
5.1.3	Capillary dies (method A)	5
5.1.4	Slit dies (method B)	9
5.1.5	Piston	9
5.2	Temperature control	9
5.3	Measurement of temperature and calibration	10
5.3.1	Test temperature	10
5.3.2	Measurement of test temperature	10
5.3.3	Temperature calibration	10
5.4	Measurement of pressure and calibration	10
5.4.1	Test pressure	10
5.4.2	Pressure drop along the length of the slit die	11
5.4.3	Calibration	11
5.5	Measurement of the volume flow rate of the sample	11
6	Sampling	11
7	Procedure	11
7.1	Cleaning the test device	11
7.2	Selection of test temperatures	12
7.3	Preparation of samples	13
7.4	Preheating	13
7.5	Determination of the maximum permissible test duration	13
7.6	Determination of test pressure at constant volume flow rate: Method 2	14
7.7	Determination of volume flow rate at constant test pressure: Method 1	14
7.8	Waiting periods during measurement	14
7.9	Measurement of extrudate swelling	14
7.9.1	General	14
7.9.2	Measurement at room temperature	15
7.9.3	Measurement at the test temperature	15
8	Expression of results	15
8.1	Volume flow rate	15
8.2	Apparent shear rate	16
8.2.1	General	16
8.2.2	Method A: Capillary dies	16
8.2.3	Method B: Slit dies	16
8.3	Apparent shear stress	17

8.3.1	General	17
8.3.2	Method A: Capillary dies	17
8.3.3	Method B: Slit dies	17
8.4	True shear stress	17
8.4.1	General	17
8.4.2	Bagley correction for capillary dies (method A)	18
8.4.3	Bagley correction for slit dies (method B)	21
8.4.4	Direct determination using slit dies (method B)	22
8.5	True shear rate	22
8.5.1	General	22
8.5.2	Method A: Capillary dies	23
8.5.3	Method B: Slit dies	23
8.6	Viscosity	23
8.7	Determination of extrudate swelling	23
8.7.1	Measurement at room temperature	23
8.7.2	Measurement at the test temperature	24
9	Precision	24
10	Test report	25
10.1	General	25
10.2	Test conditions	25
10.3	Flow characteristics	26
10.3.1	General	26
10.3.2	Graphical representation	26
10.3.3	Individual values	27
10.4	Visual examination	27
Annex A (informative)	Method of correcting for the influence of H/B on the apparent shear rate.28	
Annex B (informative)	Measurement errors	30
Annex C (informative)	Uncertainties in the determination of shear viscosity by capillary extrusion rheometry testing	31
Bibliography	36