



Designation: D5857 – 17

# Standard Specification for Polypropylene Injection and Extrusion Materials Using ISO Protocol and Methodology<sup>1</sup>

This standard is issued under the fixed designation D5857; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

## INTRODUCTION

This material specification is intended to provide a call out system for polypropylene utilizing specimen preparation procedures and test method based on ISO standards.

This specification is not intended for the determination of the suitability of performance of materials in the final application. Selection of these materials is to be made by personnel with expertise in the plastics field in which the environment, inherent properties of the materials, performance of the parts, part design, manufacturing process, and economics are considered.

### 1. Scope\*

1.1 This specification covers polypropylene materials suitable for injection molding and extrusion. Polymers consist of polypropylene homopolymers, polypropylene copolymers, and polypropylene-elastomer compounds produced with or without the addition of impact modifiers (ethylene-propylene rubber, polyisobutylene rubber, and butyl rubber, and so forth), colorants, stabilizers, lubricants, fillers, or reinforcements.

1.2 This specification allows for the use of those polypropylene materials that can be recycled, reconstituted, and reground, provided that the following conditions are met:

1.2.1 The requirements as stated in this specification and other ISO guidelines pertaining to these types of materials are met, and

1.2.2 The material has not been modified in any way to alter its conformance to food contact regulations or similar requirements.

1.3 The proportions of recycled, reconstituted, and regrind material used, as well as the nature and the amount of any contaminant, cannot be practically covered in this specification. It is the responsibility of the supplier and buyer of recycled, reconstituted, and regrind materials to ensure compliance.

1.4 The properties included in this classification system are those required to identify the compositions covered. Other requirements necessary to identify particular characteristics

important to specialized applications can be specified by using the suffixes as given in Section 5 and those in Classification System D4000.

1.5 This classification system and specification are intended to provide a means of calling out polypropylene materials used in the fabrication of end items or parts. It is not intended for the selection of materials. Material selection can be made by those having expertise in the plastic field only after careful consideration of the design and the performance required of the part, the environment to which it will be exposed, the fabrication process to be employed, the costs involved, and the inherent properties of the material other than those covered by this specification.

1.6 The values stated in SI units are to be regarded as the standard.

1.7 The following precautionary caveat pertains only to the test methods portion, Section 13, of this specification: *This specification does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this specification to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

NOTE 1—This specification is similar to both ISO 1873-1 and ISO 1873-2, but to different degrees. This specification resembles ISO 1873-1 in title only. The content is significantly different. This specification and ISO 1873-2 differ in approach or detail; data obtained using either are technically equivalent.

1.8 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.15 on Thermoplastic Materials.

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\*A Summary of Changes section appears at the end of this standard

## 2. Referenced Documents

### 2.1 *ASTM Standards*:<sup>2</sup>

- D618 Practice for Conditioning Plastics for Testing
- D883 Terminology Relating to Plastics
- D1600 Terminology for Abbreviated Terms Relating to Plastics
- D1999 Guide for Selection of Specimens and Test Parameters from ISO/IEC Standards (Withdrawn 2000)<sup>3</sup>
- D3763 Test Method for High Speed Puncture Properties of Plastics Using Load and Displacement Sensors
- D3892 Practice for Packaging/Packing of Plastics
- D4000 Classification System for Specifying Plastic Materials
- D7209 Guide for Waste Reduction, Resource Recovery, and Use of Recycled Polymeric Materials and Products (Withdrawn 2015)<sup>3</sup>
- E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

### 2.2 *ISO Standards*:<sup>4</sup>

- ISO 62 Plastics—Determination of Water Absorption
- ISO 75-1 Plastics—Determination of Temperature of Deflection Under Load, Part 1: General Test Method
- ISO 75-2 Plastics—Determination of Temperature of Deflection Under Load, Part 2: Plastics and Ebonite
- ISO 105 Textiles—Tests for Color Fastness
- ISO 178 Plastics—Determination of Flexural Properties of Rigid Plastics
- ISO 179 Plastics—Determination of Charpy Impact Strength of Rigid Materials
- ISO 180 Plastics—Determination of Izod Impact Strength of Rigid Materials
- ISO 293 Plastics—Compression Moulding Test Specimens of Thermoplastic Material
- ISO 294 Plastics—Injection Moulding of Test Specimens of Thermoplastic Material
- ISO 306 Plastics—Thermoplastic Materials—Determination of Vicat Softening Temperature
- ISO 527-1 Plastics—Determination of Tensile Properties, Part 1: General Principles
- ISO 527-2 Plastics—Determination of Tensile Properties, Part 2: Test Conditions for Molding and Extrusion Plastics
- ISO 537 Plastics—Testing with Torsional Pendulum
- ISO 604 Plastics—Determination of Compressive Properties
- ISO 868 Plastics and Ebonite—Determination of Indention Hardness by Means of a Durometer (Shore Hardness)
- ISO 877 Plastics—Methods of Exposure to direct Weathering, to Weathering Using Glass-Filtered Daylight, and to Intensified Weathering by Daylight Using Fresnel Mirrors
- ISO 899 Plastics—Determination of Tensile Creep

- ISO 974 Plastics—Determination of the Brittleness Temperature by Impact
- ISO 1133 Plastics—Determination of Melt Flow Rate of Thermoplastics
- ISO 1183A Plastics—Methods for Determining the Density and Relative Density of Non-Cellular Plastics
- ISO 1191 Plastics—Polyethylene and Polypropylenes in Dilute Solutions—Determination of Viscosity Number and of Limiting Viscosity Number
- ISO 1628-3 Plastics—Determination of Viscosity Number and Limiting Viscosity Number, Part 3: Polyethylene and Polypropylene Resins
- ISO 1873-1 Plastics—Propylene and Propylene-Copolymer Thermoplastics, Part 1: Designation
- ISO 1873-2 Plastics—Polypropylene (PP) and Propylene-Copolymer Thermoplastics, Part 2: Preparation of Test Specimens and Determination of Properties
- ISO 2039-1 Plastics—Determination of Hardness, Part 1: Ball Indention Method
- ISO 2039-2 Plastics—Determination of Hardness, Part 2: Rockwell Hardness
- ISO 2818 Plastics—Preparation of Test Specimens by Machining
- ISO 3451-1 Plastics—Determination of Ash, Part 1: General Methods
- ISO 3795 Road Vehicles, and Tractors and Machinery for Agriculture and Forestry—Determination of Burning Behavior of Interior Materials
- ISO 4582 Plastics—Determination of Changes in Colour and Variations in Properties after Exposure to Daylight Under Glass, Natural Weathering or Artificial Light
- ISO 4589 Plastics—Determination of Flammability by Oxygen Index
- ISO 4892-1 Methods of Exposure to Laboratory Light Sources, Part 1: General Guidance
- ISO 4892-2 Plastics—Methods of Exposure to Laboratory Light, Part 2: Xenon Arc Exposure
- ISO 4892-3 Plastics—Methods of Exposure to Laboratory Light, Part 3: Fluorescent UV Lamps
- ISO 6427 Plastics—Determination of Matter Extractable by Organic Solvents (Conventional Methods)
- ISO 6602 Plastics—Determination of Flexural Creep by Three-Point Loading
- ISO 6603-1 Plastics—Determination of Multiaxial Impact Behavior of Rigid Plastics, Part 1: Falling Dart Method
- ISO 6603-2 Plastics—Determination of Multiaxial Impact Behavior of Rigid Plastics, Part 2: Instrumented Puncture Test
- ISO 8256 Plastics—Determination of Tensile Impact Properties
- ISO 9113 Plastics—Polypropylene (PP) and Propylene-Copolymer Thermoplastics—Determination of Isotactic Index
- ISO 10350 Plastics—Acquisition and Presentation of Comparable Single-Point Data
- ISO 11357-3 Plastics—Differential Scanning Calorimetry (DSC), Part 3: Determination of Temperature and Enthalpy of Melting and Crystallization

<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

<sup>3</sup> The last approved version of this historical standard is referenced on [www.astm.org](http://www.astm.org).

<sup>4</sup> Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

**ISO 11403-1** Plastics—Acquisition and Presentation of Comparable Multi-Point Data, Part 1: Mechanical Properties

**ISO 11403-2** Plastics—Acquisition and Presentation of Comparable Multi-point Data—Part 3: Environmental Influences on Properties

**ISO 20753** Plastics—Test Specimens

2.3 *IEC Standards:*<sup>4</sup>

**IEC 93** Recommended Methods of Test for Volume and Surface Resistivities of Electrical Insulation Materials

**IEC 112** Recommended Method for Determining the Comparative Tracking Index of Solid Insulation Materials Under Moist Conditions

**IEC 243-1** Recommended Methods of Test for Electric Strength of Solid Insulating Materials at Power Frequencies

**IEC 250** Recommended Methods for the Determination of the Permittivity and Dielectric Dissipation Factor of Electrical Insulation Materials at Power, Audio, and Radio Frequencies Including Metre Wavelengths

**IEC 296** Specification for Unused Mineral Insulating Oils for Transformers and Switchgear

**IEC 60695-11-10** Fire Hazard Testing-Part 11-10: Test Flames-50 W Horizontal and Vertical Test Methods

2.4 *SAE Standards:*<sup>5</sup>

**SAE J1545** Instrumental Color Difference Measurement for Exterior Finishes, Textiles and Color Trim

**SAE J1767** Instrumental Color Difference Measurement for Colorfastness of Automotive Interior Trim Materials

**SAE J1976** Outdoor Weathering of Exterior Materials

**SAE J2412** Accelerated Exposure of Automotive Interior Trim Components Using a Controlled Irradiance Xenon-Arc Apparatus

**SAE J2527** Performance Based Standard for Accelerated Exposure of Automotive Exterior Materials Using a Controlled Irradiance Xenon-Arc Apparatus

3.2.5 *ductile brittle transition temperature, n*—the temperature at which a minimum of 80 % of the specimens exhibit ductile failure.

3.2.6 *ductile failure, n*—one where the specimen deforms plastically before fracturing such that the cracks do not radiate more than 10 mm beyond the center of the impact point.

3.2.7 *injection pressure, n*—the constant pressure that is applied to the end of the screw, causing the melted material to fill the mold.

3.2.7.1 *Discussion*—The injection pressure along with the injection speed determines the volumetric fill rate of the mold.

3.2.8 *injection time, n*—the time during which a constant specified pressure is applied to the melted material.

3.2.9 *injection velocity, n*—the average velocity of the melt as it passes through the cross-sectional area of a cavity of a single- or multi-cavity mold at the position that forms the critical portion of the test specimen.

3.2.10 *melt temperature, n*—the temperature of the material as it is being injected into the mold, measured by a pyrometer.

3.2.11 *mold open time, n*—the time beginning when the mold is opened and ending when the mold is closed.

3.2.12 *mold temperature, n*—the temperature of the mold during the molding cycle, measured in all mold cavities and on both platens.

3.2.13 *polypropylene (PP)*—a propylene plastic prepared by the polymerization of propylene or propylene with other alpha olefins (see also *PP-H*, *PP-R*, and *PP-B*).

3.2.14 *polypropylene heterophasic copolymers (PP-B)*—a propylene plastic consisting of two or more separate phases. These include *PP+EPR*, *PP+EPDM*, *PP+IIR*, *PP+BR*, and so forth.

3.2.14.1 *Discussion*—The phases consist of a polypropylene homopolymer (*PP-H*) or a polypropylene random copolymer (*PP-R*) matrix containing a dispersed olefinic elastomer having no other functional group, added in situ or physically blended into the polypropylene matrix.

3.2.15 *polypropylene homopolymer (PP-H)*—a propylene plastic prepared by the polymerization of propylene only.

3.2.16 *polypropylene random copolymer (PP-R)*—a propylene plastic containing another olefinic monomer (or monomers) having no functional group other than the olefinic group copolymerized with propylene.

3.2.16.1 *Discussion*—Polypropylene random copolymers containing more than one additional monomer are often called terpolymers.

## 4. Classification

4.1 Unreinforced polypropylene materials are classified into groups in accordance with basic composition. These groups are subdivided into classes and grades, as shown in Table PP.

NOTE 2—An example of this classification system is as follows. The designation PP0113 would indicate: PP = polypropylene, as found in Terminology **D1600**, 01 (group) = homopolymer, 1 (class) = general purpose, and 3 (grade) = with requirements given in Table PP.

## 3. Terminology

3.1 *Definitions*—Definitions of terms and abbreviations applying to this specification appear in Terminologies **D883** and **D1600** and Guide **D7209**.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *back pressure, n*—the constant pressure that is applied to the end of the screw while the screw is rotating and retracting to prepare for the next injection.

3.2.2 *brittle failure, n*—one where the specimen test area is broken into two or more pieces, with sharp edges, and shows almost no plastic flow.

3.2.3 *cooling time, n*—the time during which the material is in the closed mold with no pressure applied.

3.2.4 *cycle time, n*—the time required to complete a full injection molding cycle, including injection time, cooling time, and mold open time.

<sup>5</sup> Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, <http://www.sae.org>.

4.1.1 The values in Table PP are based on testing that was conducted 40 to 96 h after molding. Testing was conducted in a standard laboratory atmosphere of  $23 \pm 2^\circ\text{C}$  and  $50 \pm 5\%$  relative humidity

4.1.2 To facilitate the incorporation of future or special materials not covered by Table PP, the other/unspecified category (0) for group, class, and grade is indicated on the table with the basic properties to be obtained from Table B or Table H, as it applies.

4.1.3 Specific requirements for unreinforced polypropylene homopolymers not covered by Table PP shall be shown by a six-character designation. The designation shall consist of the letter B and the five digits comprising the cell numbers for the property requirements in the order in which they appear in Table B.

NOTE 3—An example of a special material using this classification system is as follows. The designation PP0110B55143 would indicate the following with the material requirements from Table B:

PP0110 = General purpose polypropylene homopolymer,  
 B = Table B property requirements,  
 5 = 25 MPa tensile strength, min,  
 5 = 1000 MPa flexural modulus (1 % secant, min),  
 1 = 1.6 kJ/m<sup>2</sup> Charpy impact, min,  
 4 = 80°C deflection temperature, min, and  
 3 = >1.0 to 3.0 nominal flow rate.

4.1.4 Specific requirements for unreinforced impact-modified polypropylene and polypropylene copolymers are shown in Table H. The designation will consist of the letter H and five digits comprising the cell numbers for the property requirements in the order in which they appear in Table H. Table H has been incorporated into this specification to improve the call-out of random copolymers and impact copolymers. Though Table H uses five digits, one digit is unspecified, so it has a reduced number of property callouts based on flexural modulus, Charpy impact, and two multiaxial impact ductile-brittle transition temperatures. If more properties are required to properly call out a material, use Table B.

NOTE 4—An example of a polypropylene copolymer material using Table H would be as follows. The designation PP0600H58540 would indicate the material with the following requirements:

PP0600 = Copolymer or impact modified,  
 H = Table H property requirements,  
 5 = 950 MPa flexural modulus, min,  
 8 = Non-break failure mode, no value reported Charpy impact resistance, min,  
 5 = <-30°C ductile-brittle transition temperature at 2.2 m/s,  
 4 = <-20°C ductile-brittle transition temperature at 6.6 m/s,  
 0 = Unspecified.

4.1.5 Table PP was developed using data generated from natural color materials. However, Table PP can be used to specify black or other color polypropylenes if the compounded materials meet the requirements found in the table.

4.2 Reinforced versions of the polypropylene materials are classified in accordance with Tables PP, A, C, G, and T, Tables C, G, and T are used when the filler or reinforcement is known to be either calcium carbonate, talc, or glass. Table A is used

when the material cannot be classified by Tables PP, C, G, or T. These tables specify the properties after the addition of reinforcements, or fillers for mechanical properties improvement, at the nominal level indicated (see 4.2.1).

4.2.1 *Fillers and Reinforcing Materials*—A symbol (single letter) shall be used for the major reinforcement or combinations thereof (see Table 1), along with two numbers that indicate the nominal percentage of addition by mass (see Table 2).

NOTE 5—This part of the system uses the type and percentage of additive to designate modification of the base material. To facilitate this designation, the type and percentage of additive may be shown on the supplier's technical data sheet, unless it is proprietary in nature. If necessary, additional requirements shall be indicated by the use of the suffix part of the system, as given in Section 5.

4.2.2 Specific requirements for reinforced, or filled polypropylene materials shall be shown by a six-character designation. The designation shall consist of the letter A, C, G, or T and the five digits comprising the cell numbers for the property requirements in the order in which they appear in Tables A, C, G, or T.

4.2.3 When the grade of the basic materials is not known or is not important, the use of 0 grade classification shall be used for reinforced materials in this system (see Note 6).

NOTE 6—An example of this classification system for a reinforced polypropylene material is as follows. The designation PP0110T20T65150 would indicate the following, with the material requirements for Table T:

PP0110 = general purpose polypropylene homopolymer from Table PP,  
 T20 = Talc filled, 20 %,   
 T = Table T property requirements,  
 6 = 30 MPa tensile strength, min,  
 5 = 2100 MPa flexural modulus, min,  
 1 = 2.0 kJ/m<sup>2</sup>, Charpy Impact, min,  
 5 = 56°C deflection temperature, min,  
 0 = Unspecified.

If no properties are specified, the designation would be PP0110T20T00000.

4.3 Although the values listed for both filled, reinforced, and unfilled polypropylenes are necessary to include the range of properties available in existing materials, not every possible combination of the properties exists or can be obtained

## 5. Suffixes

5.1 When additional requirements are needed for the materials covered in this specification that are not covered in Tables PP, A, B, C, G, H, or T those requirements shall be designated through the use of suffixes. The primary suffix list can be found in Classification System D4000, Section 7, Suffix Requirements. Other suffixes that pertain only to the material requirements in this specification are listed below. In general, the suffix letter indicates the requirement needed; the first number (digit) indicates the test condition, and the second number (digit) indicates the specimen requirement.

NOTE 7—Suffixes from Classification System D4000 contain two letters followed by three numbers, while suffixes from Specification D5857 contain a single letter followed by two or three numbers. An example would be weatherability. A designation of WA510 would indicate that it is a Classification System D4000 suffix.



**Suffixes:**

E = electrical requirements as designated by the following digits:

First Digit

0 = to be specified.

1 = specimens preconditioned 40 h at 23°C and 50 % relative humidity, then 14 days in distilled water at 23 ± 1°C.

2 = specimens preconditioned 88 h at 23°C and 50 % relative humidity, then 14 days in distilled water at 23 ± 1°C.

Second Digit

0 = to be specified.

1 = insulation resistance, dielectric constant, and dissipation factor meet property limits as shown below. These are electrical limits usually applied to unreinforced polypropylene when control of their electrical properties is required. Specimen size and thickness shall be in accordance with Guide **D1999**.

*Electrical Properties:*

Dielectric constant, max	IEC 250	2.3
Dissipation factor, max	IEC 250	0.0005
Volume resistance, min, ohm-cm	IEC 93	1 × 10 <sup>15</sup>
Water immersion stability	IEC 250	A

<sup>A</sup>Shall meet the dielectric constant and dissipation factor requirements.

W = weatherability requirements as designated by the following digits:

First Digit

1 = specimens exposed in a xenon arc test apparatus to conditions specified in SAE J2527 for exterior applications.

2 = specimens exposed in a xenon arc test apparatus to conditions specified in SAE J2412 for interior applications.

3 = Natural weathering in accordance with ISO 877, for interior applications.

4 = Natural weathering in accordance with ISO 877 for exterior applications.

5 = Specimens exposed in a xenon arc test apparatus to conditions specified in ISO 4892-2 for interior applications.

6 = Specimens exposed in a xenon arc test apparatus to conditions specified in ISO 4892-2 for exterior applications.

7 = Specimens exposed in a fluorescent UV/condensation test apparatus to conditions specified in ISO 4892-3.

8 = Natural weathering in accordance with SAE J1976 for exterior applications.

Second Digit

0 = to be specified.

1 = 200 h exposure.

2 = 500 h exposure.

3 = 1000 h exposure.

4 = 2000 h exposure.

5 = 1240.8 kJ/(m<sup>2</sup>.nm) at 340 nm.

6 = 2500 kJ/(m<sup>2</sup>.nm) at 340 nm.

7 = 225.6 kJ/(m<sup>2</sup>.nm) at 340 nm.

8 = 601.6 kJ/(m<sup>2</sup>.nm) at 340 nm.

NOTE 8—Conversion from hours to kilojoules (kJ) varies with irradiance and the light/dark cycle. Conversion to kJ from actual light hours is based on the following relation:

$$kJ = \text{Irradiance in Watts} \times 3.6 \text{ kJ/h} \times \text{hours of light}$$

Thus, at an irradiance level of 0.55 W/(m<sup>2</sup>.nm) at 340 nm, the multiplication factor for converting light hours to kJ is 1.98 (0.55 × 3.6).

Therefore, 100 light hours is equivalent to 396 kJ/(m<sup>2</sup>. nm) at 340 nm at this irradiance level.

Third Digit

0 = to be specified.

1 = the exposed specimens shall not exhibit surface changes (such as dulling and chalking) or deep-seated changes (such as checking, crazing, warping, and discoloration).

2 = the tensile strength after exposure shall be no less than 50 % of the original.

3 = the tensile strength after exposure shall be no less than 90 % of the original.

4 = ISO 105 grey scale rating.

5 = colorfastness by SAE J1545 for exterior materials, CIELAB color difference, 10 degrees observer, illuminant D65, specular included. ΔE = 2.5 max.

6 = colorfastness by SAE J1545 for exterior materials, CIELAB color difference, 10 degrees observer, illuminant D65, specular included. ΔE = 3.0 max.

7 = colorfastness by SAE J1767 for interior materials, CIELAB color difference, 10 degrees observer, illuminant D65, specular included. ΔE = 3.0 max.

Z = Other special requirements characteristics (see 5.2).

5.2 Category “Z” shall be used, as necessary, to designate other special requirements (for example, internal mold release, UV stabilization, etc.) not covered by existing call out capabilities. These shall be spelled out in detail and identified in sequence, that is, 01 ultraviolet (UV)-stabilized, 02 special color, and 03, etc.

5.3 Additional suffixes shall be added to this specification as test methods and requirements are developed or requested, or both.

## 6. Basic Requirements

6.1 The basic requirements from property or cell tables, as they apply, are always in effect unless these requirements are superseded by specific suffix requirements in the line callout.

## 7. General Requirements

7.1 The plastic composition shall be uniform and shall conform to the requirements specified herein. The color and form of the material shall be specified. Note specification changes due to the effects of colorants and, when necessary, cover them by suffixes.

7.2 For recycled, reconstituted, and regrind materials, the level of contamination by nonpolymeric materials, other than fillers and additives, shall not be of such a significant level that it prevents the product from meeting the performance criteria for which it was manufactured.

## 8. Detail Requirements

8.1 Test samples for the various materials shall conform to the requirements prescribed in Tables PP, A, B, C, G, and T and to the suffix requirements as they apply.

8.2 Observed or calculated values obtained from analysis, measurement, or test shall be rounded in accordance with Practice **E29** to the nearest unit in the last right-hand place of figures used in expressing the specified limiting value. The value obtained is compared directly with the specified limiting value. Conformance or nonconformance with the specification is based on this comparison.

## 9. Sampling

9.1 Sampling shall be statistically adequate to satisfy the requirements of 14.4. A lot of material shall be considered as a

unit of manufacture as prepared for shipment, and is permitted to consist of a blend of two or more “production runs” or batches.

## 10. Number of Tests

10.1 The number of tests conducted shall be consistent with the requirements of the specific ISO test method.

## 11. Sample Preparation

11.1 The method of sample preparation and type of specimen used for each test is specified in Table 3.

### 11.2 Injection Molding:

11.2.1 *Specimen Mold*—Specimens shall be injection molded using a mold design specified in ISO 294. A mold of the same design as ISO 294, but with shutoff valves to allow balanced molding of single types of specimens without making a complete mold change, can be used if it can be shown that it provides specimens of the same quality with mechanical properties equivalent to specimens molded in the ISO 294 design.

NOTE 9—Limited data have shown that, for polypropylenes, mechanical test values can be significantly affected by the cross sectional area of the runner. Specimens molded using the specified minimum runner size of 5 mm D (~20 mm<sup>2</sup>) exhibited lower values of most mechanical properties than specimens molded using runners with cross-sectional areas of 50 and 80 mm<sup>2</sup>. Higher viscosity (lower MFR) materials appear to be more sensitive. This effect needs to be considered when comparing data obtained from different sources.

11.2.2 *Cavity Gate Dimensions*—The gate height and width shall be a minimum of two-thirds of the height and width of the specimen.

11.2.3 *Injection Velocity*—The following calculations shall be used to determine the injection velocity:

$$V_I = (\pi \times D^2 \times v_s) / (4 \times n \times A_c) \quad (1)$$

or

$$v_{av} = V_s / (t_I \times A_c \times n) \quad (2)$$

where:

$V_{AV}$  = average injection velocity, mm/s

$V_I$  = injection velocity, mm/s,

$D$  = screw diameter, mm,

$v_s$  = screw speed, mm/s,

$n$  = number of cavities,

$A_c$  = cross section at the position that forms the critical portion of the test specimen,

$V_s$  = shot volume, mm<sup>3</sup>, and

$t_I$  = injection time, s.

NOTE 10—Eq 1 and 2 may give slightly different values to some extent due to different contributions of the compression of the whole melt in front of the screw and from different amounts of back flow.

11.2.4 For a given molding machine and given mold, the injection pressure and injection velocity shall be set to produce equal part weights, including sprue and runners, within 1 % regardless of the material’s melt flow rate.

### 11.2.5 Melt Temperature Determination:

11.2.5.1 *Needle-type Pyrometer*—The melt temperature shall be measured on cycle by taking the temperature of several successive free shots with a needle-type pyrometer to an accuracy of ±3°C. The needle shall be moved around in the

plastic mass and a sufficient number of measurements be made to establish a reliable result. To minimize heat loss from the plastic during the measurement, collect the mass in a heated container, or in one made from material of low thermal conductivity. Control the quantity of plastic in the free shot so that it is equivalent to the weight of a complete injection-molded shot. To avoid excessive thermal history, the shot size shall be kept to a minimum; therefore, the cushion shall be 5 to 10 mm.

11.2.5.2 *Infrared Pyrometer*—The melt temperature can also be measured using an infrared pyrometer with an accuracy of 1 % of reading or ±1°F or ±1°C, a response time of at least 0.5 s, and a distance to target ratio of at least 30 to 1. It is recommended that the infrared pyrometer have a laser beam to establish the position being measured on the molten mass of polymer. This second technique shall only be used after a correlation between the needle-type pyrometer and the infrared pyrometer has been established. This correlation shall be verified at least every six months and shall be re-established each time either pyrometer is recalibrated.

11.2.5.3 If other temperatures have to be used because of the nature of the polymer, they shall be reported, together with the reasons for use.

11.2.5.4 An increase in the MFR during molding to 1.5 times the original value shall be avoided. If the MFR increases by more than 1.5 times the original value, the melt temperature shall be lowered, 10°C at a time, until the increase in MFR is <1.5 times the original value.

11.2.6 *Mold Temperature*—Mold temperature measurements shall be made in each cavity of the mold after machine conditions are at equilibrium and shall be made with a surface-type pyrometer, or equivalent, to an accuracy of ±2°C.

11.2.7 *Specimen Weight*—For a given molding machine and mold combination, the injection pressure and injection velocity shall be set to produce equal part weights, including sprue and runners, within 1 % regardless of the material melt flow rate.

11.2.8 *Injection and Hold Pressures*—The injection pressure and hold pressure shall be set at a level that does not produce flash, sink marks, or voids in the specimens. The maximum amount of flash shall not exceed 1 mm and shall be acceptable only in the non-testing areas of the specimen.

11.2.9 *Reporting*—Report the injection molding conditions in accordance with ISO 294 and ISO 1873-2.

## 11.3 Compression Molding:

11.3.1 *Specimens*—For electrical testing or when the specimens cannot be injection molded, specimens shall be prepared by stamping or machining (see ISO 2818) from a compression-molded sheet. Compression molding of sheet shall be conducted in accordance with ISO 293, with the following additional points specified in ISO 1873-2:

11.3.1.1 *Mold*—A simple three-plate frame.

11.3.1.2 *Predrying*—No drying is normally necessary.

11.3.1.3 *Molding Temperature*—210 ± 5°C.

11.3.1.4 *Average Cooling Rate*—Method B; 15 ± 5°C/min.

11.3.1.5 *Molding Procedure*—The contact pressure time shall be 5 to 10 min, and the full-pressure time shall be 2 to 5 min. The demolding temperature shall be less than or equal to 40°C.

NOTE 11—The method of sample preparation may affect the level of crystallinity or orientation in the test specimen. As a consequence, test specimens may yield different test results. Thus, the method of preparation shall be taken into account when comparing results. In cases of disagreement, injection-molded specimens shall be the referee standard.

## 12. Conditioning

### 12.1 Conditioning:

12.1.1 Once specimens are molded, they shall be moved to a standard laboratory atmosphere or a controlled laboratory atmosphere. For natural unfilled polypropylene the controlled laboratory atmosphere shall be  $23 \pm 2^\circ\text{C}$ . It is recommended that specimens be allowed to cool individually for about 30 min on a bench, or in a rack, or on the injection molded runner before they are placed in any container where the specimens might come in contact with each other. For filled and reinforced polypropylene or polypropylene blends, which contain a hydrophilic comonomer or modifier the specimens shall be conditioned in a standard laboratory atmosphere of  $23 \pm 2^\circ\text{C}$  and  $50 \pm 10\%$  relative humidity, unless sufficient testing has been conducted that indicates the specific material type's properties are not affected by humidity. In those cases, the storage medium can be the same as for unfilled materials. Materials whose properties are affected by humidity, must be stored in accordance with Practice D618, Procedure A. For all materials to be conditioned for electrical testing, conditioning shall comply with the requirements of the standard test methods for electrical testing. In all cases the laboratory shall report both the temperature and humidity conditions during the conditioning procedure.

NOTE 12—When the temperature in the molding area exceeds  $28^\circ\text{C}$  or the humidity level exceeds 60 % (applies only to filled material) specimens shall be moved as quickly as possible to the controlled or standard laboratory atmosphere.

NOTE 13—Acceptable storage mediums include boxes, paper bags or envelopes, plastic bags, or racks, whichever is most practical for the laboratory storing the specimens.

12.1.2 Testing, except for those tests where a test time is specified, shall be conducted within 40 to 96 h after molding. This test time range shall apply to all testing conducted for development of a line callout, data for publication, for certification, or for cases of dispute over testing values.

12.1.3 Specimens that are to be tested for Izod or Charpy impact shall be notched within 1 to 16 h after molding. Once notched the specimens shall condition for a minimum of 40 h before testing. Specimens shall be tested within 96 h after molding.

NOTE 14—Extending the conditioning time may result in increased or decreased test results. Polypropylene properties change with time as a result of amorphous densification and, in some cases, due to a small degree of secondary crystallization in the rubbery phase.

### 12.2 Test Conditions:

12.2.1 Natural unfilled polypropylene shall be tested in a controlled laboratory atmosphere of  $23 \pm 2^\circ\text{C}$ . For filled and reinforced polypropylene or polypropylene blends that contain a hydrophilic comonomer or modifier, the specimens shall be tested in a standard laboratory atmosphere of  $23 \pm 2^\circ\text{C}$  and  $50 \pm 10\%$  relative humidity, unless sufficient testing has been conducted that indicates that specific material type's properties

are not affected by humidity. For all materials to be tested for electrical properties, the laboratory shall comply with the requirements of the standard test methods for electrical testing. In all cases the laboratory shall report both the temperature and humidity conditions during testing.

## 13. Test Methods

13.1 Determine the properties enumerated in this specification in accordance with the methods as they apply, unless otherwise stated herein.

NOTE 15—It is recognized that detailed test values, particularly Charpy Impact, may not predict nor even correlate with performance of parts molded of these materials.

13.1.1 *Flow Rate*—Condition 12 ( $230^\circ\text{C}$  with 2.16 kg load) of ISO 1133. Make two determinations on the material in the form that it is to be molded (such as powder, pellets, or granules).

NOTE 16—This test method serves to indicate the degree of uniformity of the flow rate of the polymer of a single manufacturer as made by an individual process and, in this case, may be indicative of the degree of uniformity of molded specimens and therefore other properties. However, uniformity of flow rate among various polymers of various manufacturers as made by various processes does not, in the absence of other tests, indicate uniformity of other properties and vice versa.

13.1.2 *Tensile Stress at Yield*—Test an unannealed ISO 20753 Type A1 specimen using ISO 527. For materials that show a breaking strain greater than 10 %, use a test speed of 50 mm/min. For materials that break at a strain less than 10 %, use a test speed of 5 mm/min.

13.1.3 *Flexural Modulus (Chord Modulus)*—Using ISO 178, determine a chord modulus between 0.0005 and 0.0025 mm/mm strain using a rectangular 80 by 10 by 4-mm specimen cut from the center of an unannealed ISO 20753 Type A1 multipurpose specimen. Set the test span at 64 mm and test speed to 2 mm/min. The support rods and loading nose shall be  $5 \pm 0.1$  mm in radius. Test results shall be corrected for machine compliance.

NOTE 17—If the ISO 20753 Type A1 specimens were molded on a mold containing a draft angle, the specimens will be trapezoidal. Therefore, the flexural modulus may vary slightly, depending on which side is placed away from the loading nose.

13.1.4 *Charpy Impact Resistance*—The center section of an unannealed ISO 20753 Type A1 multipurpose bar shall be tested in accordance with ISO 179, Method 1A, with the V-notch having 0.25-mm radius at bottom. The test temperature is  $23^\circ\text{C}$ .

13.1.5 *Falling Mass Impact Resistance*—Testing shall be conducted in accordance with ISO 6603-2, with a 60-mm diameter by 2-mm thick specimen or a 60-mm square by 2-mm thick supported by a 40-mm diameter ring and impacted with a 20-mm diameter dart utilizing either the variable height or variable weight method. Determine the total energy to failure.

NOTE 18—The square specimen is preferred as this specimen may also be used to measure mold shrinkage properties.

13.1.6 *Temperature of Deflection Under Load*—Using ISO 75-1 and 75-2, test a rectangular 80 by 10 by 4-mm specimen cut from the center of an unannealed ISO 20753, Type A1

multipurpose specimen in the flatwise position. A load is applied at the center of the specimen to give a fiber stress of 1.8 MPa.

13.1.7 *Multiaxial Impact Ductile-Brittle Transition Temperature*—Test Method **D3763** shall be used to test specimens 3.2 mm thick and equal to or greater than 100 mm in diameter. The test speeds shall be 2.2 m/s and 6.6 m/s with the 12.7-mm diameter impact dart and 76-mm support ring. The temperature at which a minimum of 80 % of the specimens exhibit ductile failure shall be determined based on the definitions listed in Section 3. This temperature shall be determined by either a standard graphical method or through a probability graph method. When using the standard graphical method to determine the passing temperature, it is necessary to repeat this procedure of testing ten specimens at a series of temperatures differing by uniform increments of 5°C. The transition region of the curve shall be established using either 5°C or 10°C increments, but 5°C increments must be used when testing in the transition temperature region. When using probability graph paper, it is not necessary to obtain the lowest no failure temperatures, at which no failure is obtained, nor the highest failure temperature. Draw a straight line through a minimum of four points, two above and two below the 20 % failure point. The temperature indicated at the intersection of the data line with the 20 % failure line shall be reported as the ductile-brittle temperature or 80 % passing temperature.

NOTE 19—Additional test methods for characterization can be found in Table 4, ISO 10350, and ISO 11403-2.

## 14. Inspection and Certification

14.1 Inspection and certification of the material supplied under this classification system shall be for conformance to the requirements specified herein.

14.2 Lot-acceptance inspection shall be the basis on which acceptance or rejection of the lot is made. The lot-acceptance inspection shall consist of those tests that ensure process control during manufacture as well as those necessary to ensure certifiability. Tests are melt flow rate, percent of reinforcement or filler, tensile stress at yield, flexural modulus, Charpy impact, and temperature of deflection under load (HDT).

14.3 Periodic check inspection shall consist of the tests specified for all requirements of the material under this classification system. Inspection frequency shall be adequate to ensure that the material is certifiable in accordance with 14.4.

14.4 Certification shall be that the material was manufactured, sampled, tested, and inspected in accordance with this specification and that the average values meet the requirements at a confidence level of 95 %.

14.5 A report of the test results shall be furnished when requested. The report shall consist of results of the lot-acceptance inspection for the shipment and results of the most recent periodic-check inspection.

## 15. Packaging and Package Marking

15.1 The provision of Practices **D3892** apply for packaging, packing, and marking of plastic materials.

## 16. Keywords

16.1 injection and extrusion materials; polypropylene; recycled

**TABLE PP Requirements for Unreinforced, Reinforced, and Filled Polypropylene**

Group	Description	Class	Description	Grade	Description	Nominal Flow Rate, <sup>A</sup> ISO 1133, Condition 230/2.16, g/10 min	Density, Maximum, ISO 1183, kg/m <sup>3</sup> , <sup>B</sup> (for reference only)	Tensile Stress at Yield, ISO 527, minimum, MPa	Flexural Modulus (Chord), ISO 178, minimum, MPa	Charpy Impact Resistance at 23°C, ISO 179, minimum, kJ/m <sup>2</sup>	Deflection Temperature at 1.8 MPa Stress, ISO 75-2 Flatwise, minimum, °C		
01	Homopolymer	1	general purpose	1	unfilled	≤0.3		26	1075	3.5	48		
				2	unfilled	>0.3 ≤1.0		26	1025	3.1	48		
				3	unfilled	>1.0 ≤3.0		26	1025	2.9	46		
				4	unfilled	>3.0 ≤7.0		26	975	2.5	45		
				5	unfilled	>7.0 ≤20		24.5	875	2.1	45		
				6	unfilled	>20 ≤40		23.5	825	1.9	43		
				7	unfilled	>40 ≤100		22.5	825	1.7	43		
				8	unfilled	>100 ≤200		21.5	875	1.7	43		
				9	unfilled	>200		20	875	1.4	46		
				0	other								
		2	nucleated	1	unfilled	>1.0 ≤3.0		31.5	1375	3.1	53		
				2	unfilled	>1.0 ≤3.0		29	1175	3.1	50		
				3	unfilled	>3.0 ≤7.0		29	1175	2.6	53		
				4	unfilled	>3.0 ≤7.0		29	1175	2.5	50		
				5	unfilled	>7.0 ≤20		28.5	1175	2.4	52		
				6	unfilled	>7.0 ≤20		27	1175	2.1	49		
				7	unfilled	>20		27	1075	2.1	47		
				0	other								
				3	high crystallinity	1	unfilled	≤1.0		36	2050	2.5	53
						2	unfilled	>1.0 ≤3.0		34	1850	2.5	53
		3	unfilled			>3.0 ≤7.0		34	1650	2.5	53		
		4	unfilled			>7.0 ≤20		31	1425	2.6	52		
		5	unfilled			>20 ≤40		28.5	1325	2.8	50		
		6	unfilled			>40		24.5	1325	3.0	50		



**TABLE PP Requirements for Unreinforced, Reinforced, and Filled Polypropylene**

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		0	other	0	other								
02	Refer to Appendix Appendix X1.												
03	Refer to Appendix Appendix X1.												
04	Refer to Appendix Appendix X1.												
05	Homopolymer, Heat- stabilized	1	general purpose	1	unfilled	≤0.3		26	1075	3.5	48		
				2	unfilled	>0.3 ≤1.0	26	1025	3.1	48			
				3	unfilled	>1.0 ≤3.0	26	1025	2.9	46			
				4	unfilled	>3.0 ≤7.0	26	975	2.5	45			
				5	unfilled	>7.0 ≤20	24.5	875	2.1	45			
				6	unfilled	>20 ≤40	23.5	825	1.9	43			
				7	unfilled	>40 ≤100	22.5	825	1.7	43			
				8	unfilled	>100 ≤200	21.5	875	1.7	43			
				9	unfilled	>200	20	875	1.4	46			
				0	other								
		2	nucleated	1	unfilled	>1.0 ≤3.0	31.5	1375	3.1	53			
				2	unfilled	>1.0 ≤3.0	29	1175	3.1	50			
				3	unfilled	>3.0 ≤7.0	29	1175	2.6	53			
				4	unfilled	>3.0 ≤7.0	29	1175	2.5	50			
				5	unfilled	>7.0 ≤20	28.5	1175	2.4	52			
				6	unfilled	>7.0 ≤20	27	1175	2.1	49			
				7	unfilled	>20	27	1075	2.1	47			
				0	other								
				3	high crystallinity	1	unfilled	≤1.0	36	2050	2.5	53	
						2	unfilled	>1.0 ≤3.0	34	1850	2.5	53	
3	unfilled	>3.0 ≤7.0	34			1650	2.5	53					
4	unfilled	>7.0 ≤20	31			1425	2.6	52					
5	unfilled	>20 ≤40	28.5			1325	2.8	50					
6	unfilled	>40	24.5			1325	3.0	50					
0	other												
0	other	0	other										
06	Copolymers or impact modified	0	other	0	other	Use Table H to a reduced line callout of materials where only the ratio of stiffness to impact is important. Use Table B when a full line callout is required.							
07	Copolymers or impact modified, Heat- stabilized	0	other	0	other	Use Table H to a reduced line callout of materials where only the ratio of stiffness to impact is important. Use Table B when a full line callout is required.							
11	Glass-filled homopolymer	1	reinforced	G10	10 % glass	...	1000	35	2000	3.0	81		
				G15	15 % glass	...	1010	35	2700	2.4	110		
				G20	20 % glass	...	1060	50	3500	4.5	120		
				G30	30 % glass	...	1150	54	5000	5.5	130		
		0	other										
		2	reinforced, heat- stabilized	G15	15 % glass	...	1020	35	2700	2.4	110		
				G20	20 % glass	...	1060	50	3500	4.5	120		
G30	30 % glass			...	1150	54	4100	5.5	130				
0	other												

**TABLE PP Requirements for Unreinforced, Reinforced, and Filled Polypropylene**

Group	Description	Class	Description	Grade	Description	Nominal Flow Rate, <sup>A</sup> ISO 1133, Condition 230/2.16, g/10 min	Density, Maximum, ISO 1183, kg/m <sup>3</sup> , <sup>B</sup> (for reference only)	Tensile Stress at Yield, ISO 527, minimum, MPa	Flexural Modulus (Chord), ISO 178, minimum, MPa	Charpy Impact Resistance at 23°C, ISO 179, minimum, kJ/m <sup>2</sup>	Deflection Temperature at 1.8 MPa Stress, ISO 75-2 Flatwise, minimum, °C			
12	Glass-filled copolymer	3	chemically- coupled	G20	20 % glass	...	1090	54	3800	5.0	125			
				G30	30 % glass	...	1160	55	5000	6.0	130			
				G40	40 % glass	...	1270	70	8000	7.7	140			
		4	chemically- coupled, heat- stabilized	G10	10 % glass	...	1000	34	1800	3.0	90			
				G20	20 % glass	...	1090	54	3200	5.3	125			
				G25	25 % glass	...	1090	60	4000	5.5	...			
				G30	30 % glass	...	1160	55	4300	6.0	130			
				G40	40 % glass	...	1270	70	8000	7.7	140			
		5	highly- coupled	0	other									
				0	other									
		6	highly- coupled, heat- stabilized	G45	45 % glass	...	1310	100	10 000	9.5	145			
				0	other									
		12	Glass-filled copolymer	1	reinforced	G20	20 % glass	...	1060	45	2850	3.8	130	
						0	other							
				2	reinforced, heat- stabilized	G10	10 % glass	...	1000	37	2600	2.5	108	
						G15	15 % glass	...	1020	40	2500	2.9	112	
						G20	20 % glass	...	1060	45	2850	3.8	128	
						G30	30 % glass	...	1150	57	5350	6.0	135	
				3	chemically- coupled	0	other							
						G15	15 % glass	...	1020	30	2000	10.0	110	
4	chemically- coupled, heat- stabilized			G15	15 % glass	...	1030	30	2000	10.0	110			
				G20	20 % glass	...	1090	55	3800	5.7	130			
				G30	30 % glass	...	1150	60	5400	6.2	134			
5	highly- coupled			0	other									
		0	other											
6	highly- coupled, heat- stabilized	0	other											
		0	other											
21	Talc-filled homopolymer	1	general purpose	T15	15 % talc	...	1000	23	1750	2.0	47			
				T20	20 % talc	...	1100	26	2010	1.8	59			
				T30	30 % talc	...	1190	23	2500	1.9	64			
				T40	40 % talc	...	1290	25	3000	2.2	63			
		2	heat- stabilized	T20	20 % talc	...	1110	25	1750	1.6	54			
				T30	30 % talc	...	1180	26	2800	1.7	65			
				T40	40 % talc	...	1300	24	2900	1.7	64			
				0	other									
		3	high crystallinity	0	other									
				0	other									
		4	high crystallinity, heat- stabilized	0	other									
				0	other									
		5	Extrusion Grade	T20	20 % talc	...	1050	31	2119	...	66			
				0	other									
		6	Extrusion Grade, heat- stabilized	T20	20 % talc	...	1100	23	1800	2.4	60			
T40	40 % talc			...	1280	24	4000	2.5	73					
0	other	0	other											
		0	other											
22	Talc-filled copolymer	1	general purpose	T10	10 % talc	...	1020	23	1300	2.3	47			
				T15	15 % talc	...	1030	20	1500	3.0	51			
				T20	20 % talc	...	1130	19	1500	2.0	51			
				T25	25 % talc	...	1130	20	2000	2.2	53			
				T40	40 % talc	...	1280	19	2300	2.3	57			
				0	other									

**TABLE PP Requirements for Unreinforced, Reinforced, and Filled Polypropylene**

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		2	heat-stabilized	T10	10 % talc	...	1010	18	1250	3.0	47				
				T20	20 % talc	...	1080	17	1500	3.0	53				
						T25	25 % talc	...	1090	19	2100	3.8	53		
						T30	30 % talc	...	1150	19	1560	4.0	59		
						T40	40 % talc	...	1280	19	2300	2.3	57		
						0	other								
						3	high crystallinity	0	other						
						4	high crystallinity, heat-stabilized	T15	15 % talc	...	1100	27	1900	3.3	67
						0	other								
						5	Extrusion Grade	0	other						
						6	Extrusion Grade, heat-stabilized								
31	Calcium carbonate-filled homopolymer	1	general purpose	K10	10 % CaCO <sub>3</sub>	...	990	29	1540	...	58				
				0	other										
		2	heat-stabilized	K10	10 % CaCO <sub>3</sub>	...	1000	22	1180	2.5	54				
				K25	25 % CaCO <sub>3</sub>	...	1090	22	1600	3.2	53				
						0	other								
						3	chemically-reactive	0	other						
						4	chemically-reactive, heat-stabilized	0	other						
						5	Extrusion Grade	K40	40 % CaCO <sub>3</sub>	...	1250	24	2530	...	59
						0	other								
						6	Extrusion Grade, heat-stabilized	K40	40 % CaCO <sub>3</sub>	...	1280	17	2200	5.0	48
						0	other								
32	Calcium carbonate-filled copolymer	1	general purpose	K20	20 % CaCO <sub>3</sub>	...	1060	31	1520	...	...				
				0	other										
		2	heat-stabilized	K10	10 % CaCO <sub>3</sub>	...	1000	25	1300	4.6	63				
				K20	20 % CaCO <sub>3</sub>	...	1060	20	1600	5.0	50				
						0	other								
						3	chemically-reactive	0	other						
						4	chemically-reactive, heat-stabilized	0	other						
						5	Extrusion Grade	0	other						
						6	Extrusion Grade, heat stabilized	0	other						
		41	Mica-filled homopolymer	1	general purpose	P10	10 % Mica	...	1040	28	2200	2.0	62		
						P20	20 % Mica	...	1080	23	2200	2.4	64		
2	general purpose, heat-stabilized			P10	10 % Mica	...	1040	28	1200	1.0	56				
				P20	20 % Mica	...	1100	25	2000	1.9	59				
						0	other								

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		3	high crystallinity	0	other								
		4	high crystallinity, heat-stabilized	0	other								
		5	Extrusion Grade	0	other								
		6	Extrusion Grade, heat-stabilized	P20 0	20 % Mica other	...	1080	32	2000	2.8	70		
42	Mica-filled copolymer	1	general purpose	P10	10 % Mica	...	1040	22	1400	5.0	52		
				P20	20 % Mica	...	1080	20	1800	5.8	58		
				P25	25 % Mica	...	1150	22	2400	2.3	58		
				P35 0	35 % Mica other	...	1230	19	2600	3.0	63		
		2	general purpose, heat-stabilized	P10	10 % Mica	...	1040	23	1440	4.7	52		
				P20	20 % Mica	...	1090	24	2110	2.1	63		
				P40 0	40 % Mica other	...	1260	31	3800	2.5	83		
		3	high crystallinity	0	other								
		4	high crystallinity, heat-stabilized	0	other								
		51	Glass/talc-filled homopolymer	1	general purpose	R15	15 % glass/talc	...	1050	28	2100	4.7	94
						0	other						
				2	general purpose, heat-stabilized	0	other						
3	chemically-coupled			0	other								
4	chemically-coupled, heat-stabilized			R20	20 % glass/talc	...	1080	44	2990	3.7	115		
				R30	30 % glass/talc	...	1160	53	3500	5.5	131		
				R35	35 % glass/talc	...	1220	55	5000	5.7	130		
				R40 0	40 % glass/talc other	...	1250	52	4100	6.2	135		
52	Glass/talc-filled copolymer	1	general purpose	0	other								
				0	other								
		2	general purpose, heat-stabilized	0	other								
				0	other								
		3	chemically-coupled	R15	15 % glass/talc	...	1030	27	2100	4.0	95		
4	chemically-coupled, heat-stabilized	0	other										



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53	Glass/ calcium carbonate- filled homopolymer	1	general purpose	0	other						
		2	general purpose, heat- stabilized	0	other						
		3	chemically- coupled	0	other						
		4	chemically- coupled, heat- stabilized	R30	30 % glass/ calcium carbonate other	...	1150	55	3800	5.6	130
54	Glass/ calcium carbonate- filled copolymer	1	general purpose	0	other						
		2	general purpose, heat- stabilized	0	other						
		3	chemically- coupled	0	other						
		4	chemically- coupled, heat- stabilized	0	other						
55	Glass/mica- filled homopolymer	1	general purpose	0	other						
		2	general purpose, heat- stabilized	0	other						
		3	chemically- coupled	R40	40 % glass/mica other	...	1260	40	6000	3.5	125
		4	chemically- coupled, heat- stabilized	R35 R40	35 % glass/mica 40 % glass/mica other	...	1220 1290	55 44	5000 6000	5.7 4.7	130 124
56	Glass/mica- filled copolymer	1	general purpose	R35	35 % glass/mica	...	1200	65	6000	7.0	...
		2	general purpose, heat- stabilized	0	other other						
		3	chemically- coupled	R35	35 % glass/mica other	...	1020	47	5500	6.5	128
		4	chemically- coupled, heat- stabilized	R35	35 % glass/mica other	...	1200	43	4850	6.8	122
00	Other	0	other	0	other						

<sup>A</sup>Nominal flow rate is as supplied by the manufacturer of the material. Maximum allowable tolerance ±30 % per individual lot.

<sup>B</sup>For general information, not a requirement.

**TABLE A Detail Requirements of Filled and Reinforced Polypropylene Not Called Out by Tables C, G, or T**

Designation or Order No.	Property	0	1	2	3	4	5	6	7	8	9
1	Tensile stress at yield, ISO 527, min, MPa	unspecified	20	33	47	60	75	90	105	120	specify value
2	Flexural modulus (chord), ISO 178, min, MPa	unspecified	1000	2000	3000	4000	5000	6000	7000	8000	specify value
3	Charpy impact resistance at 23°C, ISO 179, min, kJ/m <sup>2</sup>	unspecified	2.0	3.3	4.7	6.0	8.6	12	17	23	specify value
4	Deflection temperature at 1.8 MPa, ISO 75-2, Flatwise, min, °C	unspecified	47	52	56	61	67	72	78	84	specify value
5	To be determined	unspecified									specify value

**TABLE B Detail Requirements of Unfilled and Unreinforced Polypropylene**

Designation or Order No.	Property	0	1	2	3	4	5	6	7	8	9
1	Tensile stress at yield, ISO 527, min, MPa	unspecified	5	10	15	20	25	29	33	38	specify value <sup>A</sup>
2	Flexural modulus (chord), ISO 178, min, MPa	unspecified	100	250	500	750	1000	1250	1500	1750	specify value <sup>A</sup>
3	Charpy impact resistance at 23°C, ISO 179, min, kJ/m <sup>2</sup>	unspecified	1.6	5.1	9.5	18	27	36	45	62	specify value <sup>A</sup>
4	Deflection temperature at 1.8 MPa, ISO 75-2, Flatwise, min, °C	unspecified	39	42	47	49	50	55	58	60	specify value <sup>A</sup>
5	Flow rate, <sup>B</sup> ISO 1133, Condition 230/2.16, g/10 min	unspecified	<0.3	>0.3-1.0	>1.0-3.0	>3.0-10	>10-20	>20-40	>40-100	>100	specify value <sup>A</sup>

<sup>A</sup>If a specific value is required, it must appear on the drawing or contract.

<sup>B</sup>Nominal flow rate is as supplied by the manufacturer of the material. Allowable tolerance ±30 % per individual lot.

**TABLE C Detail Requirements of Calcium Carbonate Filled Polypropylene**

Designation or Order No.	Property	0	1	2	3	4	5	6	7	8	9
1	Tensile stress at yield, ISO 527, min, MPa	unspecified	10	13	16	20	23	26	29	32	specify value <sup>A</sup>
2	Flexural modulus (chord), ISO 178, min, MPa	unspecified	800	1100	1400	1750	1950	2250	2550	2750	specify value <sup>A</sup>
3	Charpy impact resistance at 23°C, ISO 179, min, kJ/m <sup>2</sup>	unspecified	2.0	3.8	5.5	7.3	8.6	10.4	12.6	14.4	specify value <sup>A</sup>
4	Deflection temperature at 1.8 MPa, ISO 75-2, Flatwise, min, °C	unspecified	45	47	49	51	53	55	57	59	specify value <sup>A</sup>
5	To be determined	unspecified									specify value <sup>A</sup>

<sup>A</sup>If a specific value is required, it must appear on the drawing or contract.

**TABLE G Detail Requirements of Glass Reinforced Polypropylene**

Designation or Order No.	Property	0	1	2	3	4	5	6	7	8	9
1	Tensile stress at yield, ISO 527, min, MPa	unspecified	23	30	38	45	54	61	70	77	specify value <sup>A</sup>
2	Flexural modulus (chord), ISO 178, min, MPa	unspecified	1000	1950	2850	3750	4700	5600	6500	7450	specify value <sup>A</sup>
3	Charpy impact resistance at 23°C, ISO 179, min, kJ/m <sup>2</sup>	unspecified	2.0	3.8	5.5	7.7	9.5	12	14	16	specify value <sup>A</sup>
4	Deflection temperature at 1.8 MPa, ISO 75-2, Flatwise, min, °C	unspecified	50	70	90	100	110	120	130	140	specify value <sup>A</sup>
5	To be determined	unspecified									specify value <sup>A</sup>

<sup>A</sup>If a specific value is required, it must appear on the drawing or contract.

**TABLE H Detail Requirements of Unfilled/Unreinforced Polypropylene Copolymers and Impact-Modified Polypropylene**

Designation or Order No.	Property	0	1	2	3	4	5	6	7	8	9
1	Flexural modulus (chord), ISO 178, min, MPa	unspecified	350	500	650	800	950	1100	1250	1400	specify value <sup>A</sup>
2	Charpy impact resistance at 23°C, ISO 179, min, kJ/m <sup>2</sup>	unspecified	1.5	3.0	6.0	9.0	18	27	53	No Break	specify value <sup>A</sup>
3	Multiaxial impact ductile-brittle transition temperature, °C <sup>B</sup>	unspecified	<+10	<0	<-10	<-20	<-30	<-40	<-50	<-15	specify value <sup>A</sup>
4	High Speed Multiaxial impact ductile-brittle transition temperature, °C <sup>C</sup>	unspecified	<+10	<0	<-10	<-20	<-30	<-40	<-50	<-15	specify value <sup>A</sup>
5	To be determined	unspecified									specify value <sup>A</sup>

<sup>A</sup>If a specific value is required, it must appear on the drawing or contract.

<sup>B</sup>Tested to 2.2 m/s per Table 4, section 2.21.

<sup>C</sup>Tested to 6.6 m/s per Table 4, section 2.22.

**TABLE T Detail Requirements of Talc Filled Polypropylene**

Designation or Order No.	Property	0	1	2	3	4	5	6	7	8	9
1	Tensile stress at yield, ISO 527, min, MPa	unspecified	11	15	19	23	26	30	34	38	specify value <sup>A</sup>
2	Flexural modulus (chord), ISO 178, min, MPa	unspecified	650	1000	1350	1750	2100	2450	2800	3150	specify value <sup>A</sup>
3	Charpy impact resistance at 23°C, ISO 179, min, kJ/m <sup>2</sup>	unspecified	2.0	3.8	5.5	7.3	9.1	11	12.5	14.5	specify value <sup>A</sup>
4	Deflection temperature at 1.8 MPa, ISO 75-2, Flatwise, min, °C	unspecified	44	47	50	53	56	59	62	65	specify value <sup>A</sup>
5	To be determined	unspecified									specify value <sup>A</sup>

<sup>A</sup>If a specific value is required, it must appear on the drawing or contract.

**TABLE 1 Coding System for Fillers and Reinforcing Materials**

Code	Material
B	boron
C	carbon
E	clay
F	flame retardant
G	glass
K	calcium carbonate
L	lubricants
M	minerals
N	other minerals
O	metals
P	mica
R	mixture of filler/reinforcement
S	organic synthetics
T	talc
U	wallastonite
W	wood
X	not specified
Y	proprietary
Z	others

**TABLE 2 Coding System for the Mass Content of Fillers and Reinforcement**

Code	Nominal Mass Content (%)
XX	proprietary
00	≤2.5
05	>2.5 to 7.5
10	>7.5 to 12.5
15	>12.5 to 17.5
20	>17.5 to 22.5
25	>22.5 to 27.5
30	>27.5 to 32.5
35	>32.5 to 37.5
40	>37.5 to 42.5
45	>42.5 to 47.5
50	>47.5 to 55
60	>55 to 65
70	>65 to 75
80	>75 to 85
90	>85

**TABLE 3 Recommended Processing Conditions**

Material MFR, g/10 min	Melt Temperature, °C	Mold Temperature, °C	Cycle Time, s <sup>A</sup>	Hold Time, s	Injection Velocity, mm/s	Injection and Hold Pressure	Back Pressure, MPa	Demolding Temperature, °C
<1	255 ± 5	40 ± 5	60	40	200 ± 20	variable	7	60
≥1, ≤7	230 ± 5	40 ± 5	60	40	200 ± 20	variable	7	60
>7	200 ± 5	40 ± 5	60	40	200 ± 20	variable	7	60

<sup>A</sup>The cycle time will be dependent on the time it takes the material to reach the demolding temperature.

**TABLE 4 Properties and Test Conditions**

Number	Properties	Standard	Specimen Type, Dimensions, mm	Processing Method	Unit	Suffix	Test Conditions and Supplementary Instructions
1.0	Rheological properties						
1.1	Melt flow rate—mass	ISO 1133	granule or powder		g/10 min		230°C, 2160 g
1.2	Melt flow rate—volume		granule or powder		mL/10 min		230°C, 2160 g
2.0	<b>Mechanical Properties</b>						
2.1	Tensile modulus	ISO 527-1,	ISO 20753 Type A1	injection	MPa		For modulus, speed is 1 mm/min.
2.2	Tensile yield stress	ISO 527-2					For other tensile properties, test speed is 50 mm/min for ductile materials, 5 mm/min for brittle materials, see Footnote A for definition of ductile and brittle failure; <sup>A</sup> see Footnote B for measurement of break properties. <sup>B</sup>
2.3	Tensile yield strain						
2.4	Tensile break stress						
2.5	Tensile break strain						
2.6	Tensile creep modulus	ISO 899 ISO 11403-1	20 by 2.5 by 1.6	injection	MPa		Test at seven temperatures, one of which is +23°C. Temperature shall be selected to span the useful working range of the polymer. For PP, the following temperatures are recommended for use: -40, -20, 0, +23, +50, +80, and +100°C. For each temperature, test at five stress levels up to 10 000 h. Stress levels shall be 20, 40, 60, 80, and 100 % of the maximum stress that can be maintained for prolonged periods of time at the test temperature. Determine the creep modulus at 1 h and 1000 h at strain level less than 0.5 %.
2.7	Flexural modulus	ISO 178	center of ISO 20753 Type A1	injection	MPa		Test speed 2 mm/min, 64-mm span, and chord modulus between 0.0005 and 0.0025 mm/mm strain, and results corrected for machine compliance
2.8	Flexural strength						(2.6)
2.9	Flexural creep modulus	ISO 6602	center of ISO 20753 Type A1	injection	MPa		Same requirements as tensile creep (2.6)
2.10	Compressive strength and modulus	ISO 604	for strength 10 by 10 by 4, for modulus 50 by 10 by 4	injection	MPa		Speed of test 0.02 mm/min for modulus, 0.1 mm/min for brittle materials, and 0.5 mm/min for ductile materials
2.11	Shear modulus	ISO 537	60 by 10 by 1	injection	MPa		Method A at 1 Hz, from -100 to +150°C
2.12	Charpy impact strength	ISO 179	center of ISO 20753 Type A1	injection	kJ/m <sup>2</sup>		Method 1 unnotched (edgewise)
2.13	Charpy notched impact strength	ISO 179	center of ISO 20753 Type A1	injection	kJ/m <sup>2</sup>		Method 1A (edgewise)
2.14	Izod impact strength	ISO 180	center of ISO 20753 Type A1	injection	kJ/m <sup>2</sup>		Method 1A, V-notch 0.25 mm radius
2.15	Tensile impact strength	ISO 8256	80 by 10 by 4 Double-V notch, r = 1	injection	kJ/m <sup>2</sup>		Determined only when fracture cannot be achieved in the Izod or Charpy test
2.16	Falling dart impact	ISO 6603-1	60 by 60 by 2 (or 60 mm diameter by 2 mm)	injection	J		50 % failure energy, Method A
2.17	Instrumented falling dart impact	ISO 6603-2	60 by 60 by 2 (or 60 mm diameter by 2 mm)	injection	J		20 mm diameter dart, 40 mm support velocity 4.4 m/s, report peak and total values
2.18	Ball indentation hardness	ISO 2039-1	50 by 50 by 4	injection	N/mm <sup>2</sup>		Thickness can be achieved by plying
2.19	Rockwell hardness	ISO 2039-2	min 50 by 50 by 6 (min)	injection	HRR		Value at 1 s, durometer A or D, thickness can be achieved by plying
2.20	Shore A or D hardness	ISO 868	min 50 by 50 by 6 (min)	injection	Value A or D		Value at 1 s, durometer A or D, thickness can be achieved by plying
2.21	Multiaxial Impact Ductile-Brittle Transition Temperature	ASTM D3763	min 100 mm diameter by 3.2 mm	injection	°C		Test speed of 2.2 m/s with 12.7 mm diameter impact dart and 76 mm support ring, temperature at which a minimum of 80 % of specimens exhibit ductile failure.
2.22	High Speed Multiaxial Impact Ductile-Brittle Transition Temperature	ASTM D3763	min 100 mm diameter by 3.2 mm	injection	°C		Test speed of 6.6 m/s with 12.7 mm diameter impact dart and 76 mm support ring, temperature at which a minimum of 80 % of specimens exhibit ductile failure.



**TABLE** *Continued*

Number	Properties	Standard	Specimen Type, Dimensions, mm	Processing Method	Unit	Suffix	Test Conditions and Supplementary Instructions
3.0	<b>Thermal Properties</b>						
3.1	Peak melting temperature	ISO 11357-3	powder, granules, sheet		°C		Heating rate 10°C/min on second heat in accordance with ISO 10350, after first heat and cool down at a rate of 20°C/min
3.2	Temperature of deflection under load	ISO 75-1 ISO 75-2	120 by 10 by 4	injection	°C		Stress level 0.45 MPa or 1.80 MPa, span 100 mm for specimens in edgewise position, 64 mm for specimens positioned flatwise
3.3	Vicat softening temperature	ISO 306	min 10 by 10 <sup>2</sup> or 10 mm diameter disk by min 3 mm thickness	injection	°C		Method A with 10 N load at 50°C/h
3.4	Brittleness temperature	ISO 974	20 by 2.5 by 1.6	injection	°C		Unnotched specimens
3.5	Coefficient of linear thermal expansion	TMA	ISO 20753 Type A1	injection	1/K		Secant value over temperature range of 23 to 55°C
3.6	Flammability	IEC 60695-11-10	120 by 10 by 4	injection or sheet	mm/s, or s, or extent of burn rating		Horizontal burn, either time or length of burn, 20 mm flame, 30 s exposure to the flame
		IEC 60695-11-10 ISO 3795	120 by 10 by 4 356 by 100 by 1.5 min	injection or sheet injection or sheet	mm/s		Vertical burn, two 10 s exposures to flame, 20 mm flame height 38 mm flame height, 15 s exposure to flame
3.7	Oxygen index	ISO 4589	80 by 10 by 4	injection	%		Procedure A—top surface ignition
4.0	<b>Electrical Properties</b>						
4.1	Relative permittivity	IEC 250	80 by 80 by 1	compression			Frequency 1 MHz
4.2	Dissipation factor	IEC 250	80 by 80 by 1	compression			Frequency 1 MHz
4.3	Volume resistivity	IEC 93	80 by 80 by 1	compression	ohm-m		Voltage 500 V
4.4	Surface resistivity	IEC 93	80 by 80 by 1	compression	ohm		
4.5	Dielectric strength	IEC 243-1	80 by 80 by 1	compression	kv/mm		Use electrode configuration 25 mm/75 mm coaxial cylinders; immersion in transformer oil IEC 296; use 20 step by step test
4.6	Comparative tracking index	IEC 112	100 by 100 by 3 (min) or 100 mm diameter disk by 3 (min) thickness	compression			Use 0.1 % ammonium chloride (aqueous solution), at 50 Hz
5.0	<b>Aging Properties</b>						
5.1	Natural Weathering	ISO 877	Dependent on secondary testing to be conducted	Injection		W3	Interior Applications, 5° southern exposure, under glass, 12 months, Florida. Refer to ISO 4582 for determination of change and to footnote D for criteria of failure.
5.2	Natural Weathering	ISO 877	Dependent on secondary testing to be conducted	Injection		W4	Exterior Applications, 5° southern exposure, direct weathering, 12 and 24 month exposures, Florida. Refer to ISO 4582 for determination of change and to footnote D for criteria of failure.
5.3	Natural Weathering	SAE J1976	Dependent on secondary testing to be conducted	Injection		W8	Exterior Applications, 5° southern exposure, direct weathering, 12 and 24 month exposures, Florida. Refer to ISO 4582 for determination of change and to footnote <sup>C</sup> for criteria of failure.
5.4	Artificial Weathering	ISO 4892-1 ISO 4892-2 Method B	ISO 20753 Type A1 multipurpose specimen	Injection		W5	(Artificial daylight behind window glass) Specimens exposed in a xenon-arc accelerated test apparatus with window glass filters that conforms to ISO 4892-2, Part 2 Method B, Cycle 6 for interior applications. See footnote <sup>D</sup> for exposure duration. Refer to ISO 4582 for determination of change and to footnote <sup>C</sup> for criteria of failure.

**TABLE** *Continued*

Number	Properties	Standard	Specimen Type, Dimensions, mm	Processing Method	Unit	Suffix	Test Conditions and Supplementary Instructions
5.5	Artificial Weathering	ISO 4892-1 ISO 4892-2 Method A	ISO 20753 Type A1 multipurpose specimen	Injection		W6	(Unfiltered artificial daylight) Specimens exposed in a xenon-arc accelerated test apparatus with daylight filters that conforms to ISO 4892-2, Part 2 Method A, Cycle 1 for exterior applications. See footnote <sup>D</sup> for exposure duration. Refer to ISO 4582 for determination of change and to footnote <sup>C</sup> for criteria of failure.
5.6	Artificial Weathering	ISO 4892-1 ISO 4892-3	Type 1 Tensile Bar	Injection		W7	Specimens exposed in a fluorescent UV/condensation accelerated test apparatus that conforms to ISO 4892-3, Part 3 and operated in accordance with exposure Cycle 1. See footnote <sup>D</sup> for exposure duration. Refer to ISO 4582 for determination of change and to footnote <sup>C</sup> for criteria of failure.
5.7	Artificial Weathering	SAE J2412	Type 1 tensile bar for physical testing and minimum 65.5 by 63.5 square or 63.5 diameter disk by 3.2 for color change	Injection		W2	Specimens exposed in a xenon-arc accelerated test apparatus that conforms to conditions in SAE J2412 or equivalent for interior applications. Radiant exposure of 1240.8 kJ/(m <sup>2</sup> .nm) at 340 nm. Refer to ISO 4582 for determination of change and to footnote <sup>C</sup> for criteria of failure.
5.8	Artificial Weathering	SAE J2527	Type 1 tensile bar for physical testing and minimum 65.5 by 63.5 square or 63.5 diameter disk by 3.2 for color change	Injection		W1	Specimens exposed in a xenon-arc accelerated test apparatus that conforms to conditions in SAE J2527 or equivalent for exterior applications. Radiant exposure of 2500 kJ/(m <sup>2</sup> .nm) at 340 nm. Refer to ISO 4582 for determination of change and to footnote <sup>C</sup> for criteria of failure.
6.0	<b>Other Properties</b>						
6.1	Water absorption	ISO 62	50 mm square or disk by 3 mm	injection	%		24 h immersion at 23°C
6.2	Density	ISO 1183A	10 by 10 by 4	injection	kg/m <sup>3</sup>		
6.3	Limiting viscosity number	ISO 1191 or ISO 1628-3	granules or powder		mL/g		Decalin at 135°C
6.4	Xylene solubles	ISO 6427 Appendix B	granules or powder		%		1 % solution of PP in xylene 30 min cooling time
6.5	Isotactic index	ISO 9113	granules or powder		%		Solubility in boiling heptane 24 h extraction
6.6	Ash	ISO 3451-1	any form		%		

<sup>A</sup>Ductile Failure—If the polymer shows ductile failure, that is, breaking strain beyond 10 %, the testing speed shall be 50 mm/min, and the values for yield stress and strain and the nominal strain at break are recorded. If breaking occurs above 50 % nominal strain, record >50 for the nominal strain at break. If no yielding is observed up to 50 % nominal strain, the stress at 50 % nominal strain shall be recorded. Determination of the nominal strain is based on the initial and final grip separations instead of the extensometer measurements. Brittle failure—If the polymer shows brittle failure, that is, breaking without yielding and with the strain at break less than 10 %, the testing speed shall be 5 mm/min, and the values for stress and strain at break shall be recorded.

<sup>B</sup>The measurement of break properties for polypropylene is not very reproducible and need not be reported unless requested.

<sup>C</sup>Failure is when the material loses tensile strength or Izod impact resistance. If color change is critical, ΔE cannot exceed 3.0

<sup>D</sup>The minimum exposure time used shall be that necessary to produce a substantial change in the tensile or impact resistance for the least stable material being evaluated.

**APPENDIX**
**(Nonmandatory Information)**
**X1. TABLE PP REQUIREMENTS FOR UNREINFORCED POLYPROPYLENE GROUPS 02, 03, AND 04**

X1.1 **Table X1.1** is the former Table PP for the line call-out of random copolymers (Group 02), heterophasic copolymers or impact modified polypropylene (Group 03), and heterophasic copolymers or impact modified and heat stabilized polypropylene (Group 04). Groups 02 and 03 have been replaced by

Group 06 in the main document (Table PP). Group 04 has been replaced by Group 07 in the main document (Table PP). A material previously classified with these groupings may continue to be used. All new material references shall use the designated call-outs found in the main document.

**TABLE X1.1 TABLE PP Requirements for Unreinforced, Reinforced, and Filled Polypropylene**

Group	Description	Class	Description	Grade	Description	Nominal Flow Rate, ISO 1133, Condition 230/2.16, g/10 min	Density, Maximum, ISO 1183, kg/m <sup>3</sup> , (for reference only)	Tensile Stress at Yield, ISO 527, minimum, MPa	Flexural Modulus (Chord), ISO 178, minimum, MPa	Charpy Impact Resistance at 23°C, ISO 179, minimum, kJ/m <sup>2</sup>	Deflection Temperature at 1.8 MPa Stress, ISO 75-2 Flatwise, minimum, °C		
02	Random Copolymer	1	general purpose	1	unfilled	...	910	22.5	1025	3.3	47		
				2	unfilled	...	910	22.5	825	3.3	44		
				3	unfilled	...	910	21	700	3.3	44		
				4	unfilled	...	910	19	600	4.2	42		
				5	unfilled	...	910	16	525	4.6	42		
				6	unfilled	...	910	15	425	5.1	42		
				7	unfilled	...	910	14	350	5.1	42		
				0	other								
		2	nucleated	1	unfilled	...	915	24.5	1000	3.8	49		
				2	unfilled	...	915	22.5	700	4.2	46		
				3	unfilled	...	915	21	600	4.2	45		
				4	unfilled	...	915	20	400	5.1	44		
		3	high crystallinity	0	other								
				0	other								
		4	heat stabilized	0	other								
				0	other								
03	Heterophasic Copolymers or Impact Modified	1	low impact	1	unfilled	...	...	24.5	1025	1.7	47		
				2	unfilled	...	...	20	875	1.6	43		
				3	unfilled	...	...	22	875	3.3	45		
				4	unfilled	...	...	17	675	3.3	43		
				5	unfilled	...	...	16	450	3.3	42		
				6	unfilled	...	...	22.5	825	5.1	46		
				7	unfilled	...	...	21	775	5.1	45		
				8	unfilled	...	...	19	775	5.1	45		
				9	unfilled	...	...	17	675	5.1	43		
				0	other								
				2	moderate impact	1	unfilled	...	...	25.5	1025	6.0	49
						2	unfilled	...	...	23.5	875	6.9	47
		3	unfilled			...	...	22	875	6.9	46		
		4	unfilled			...	...	20	775	6.9	45		
		5	unfilled			...	...	18	575	6.9	45		
		6	unfilled			...	...	18	575	6.9	42		
		7	unfilled			...	...	21	725	8.6	46		
		8	unfilled			...	...	16	675	8.6	43		
		3	medium impact	1	unfilled	...	...	23.5	1025	9.5	46		
				2	unfilled	...	...	22	925	11	45		
				3	unfilled	...	...	18	725	11	43		
				4	unfilled	...	...	16	525	11	42		
				5	unfilled	...	...	16	625	14	43		
				6	unfilled	...	...	23.5	875	18	45		
7	unfilled			...	...	19	875	18	45				
8	unfilled			...	...	19	725	18	45				
4	high impact	1	unfilled	...	...	22.5	825	27	47				
		2	unfilled	...	...	20	825	27	46				
		3	unfilled	...	...	20	575	27	45				
		0	other										
		0	other										
		0	other										
		0	other										
		0	other										

**TABLE X1.1** *Continued*

Group	Description	Class	Description	Grade	Description	Nominal Flow Rate, ISO 1133, Condition 230/2.16, g/10 min	Density, Maximum, ISO 1183, kg/m <sup>3</sup> , (for reference only)	Tensile Stress at Yield, ISO 527, minimum, MPa	Flexural Modulus (Chord), ISO 178, minimum, MPa	Charpy Impact Resistance at 23°C, ISO 179, minimum, kJ/m <sup>2</sup>	Deflection Temperature at 1.8 MPa Stress, ISO 75-2 Flatwise, minimum, °C
				4	unfilled	...	...	16	525	27	43
				5	unfilled	...	...	14	475	27	42
				6	unfilled	...	...	15	525	36	43
				7	unfilled	...	...	22.5	775	53	45
				8	unfilled	...	...	19	725	53	43
				9	unfilled	...	...	18	525	53	42
				0	other						
		5	nucleated	1	unfilled	...	...	27.5	1025	1.6	46
				2	unfilled	...	...	25.5	1325	3.3	52
				3	unfilled	...	...	22	975	3.3	50
				4	unfilled	...	...	20	875	3.3	49
				5	unfilled	...	...	22	1075	5.1	49
				6	unfilled	...	...	18	825	5.1	49
				7	unfilled	...	...	24.6	1175	7.1	49
				8	unfilled	...	...	21	875	7.1	47
				9	unfilled	...	...	18	575	9.5	47
				0	other						
04	heterophasic copolymers or impact modified and heat stabilized	1	low impact, heat stabilized	1	unfilled						
				0	other						
		2	moderate impact, heat stabilized	1	unfilled						
				0	other						
		3	medium impact, heat stabilized	1	unfilled						
				0	other						
		4	high impact, heat stabilized	1	unfilled						
				0	other						
		5	nucleated, heat stabilized	1	unfilled						
				0	other						

## SUMMARY OF CHANGES

Committee D20 has identified the location of selected changes to this standard since the last issue (D5857 - 15) that may impact the use of this standard. (May 1, 2017)

(1) Revised 3.2.5, 4.14, 13.1.7.

(2) Revised Tables H and 4.

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