INTERNATIONAL STANDARD

ISO 4613-1

Second edition
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Plastics — Ethylene/vinyl acetate (E/VAC) moulding and extrusion materials —

Part 1:
Designation and specification

Plastiques — Matériaux à base de copolymère éthylène/acétate de vinyle (E/VAC) pour moulage et extrusion —

Partie 1: Désignation et spécification

Reference number
ISO 4613-1:1993(E)

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 4613-1 was prepared by Technical Committee ISO/TC 61, *Plastics*, Sub-Committee SC 9, *Thermoplastic materials*.

This second edition cancels and replaces the first edition (ISO 4613-1:1985), which has been brought into accordance with the revised frame text for designation standards.

ISO 4613 consists of the following parts, under the general title *Plastics — Ethylene/vinyl acetate (E/VAC) moulding and extrusion materials*:

— *Part 1: Designation and specification*

— *Part 2: Preparation of test specimens and determination of properties*

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Plastics — Ethylene/vinyl acetate (E/VAC) moulding and extrusion materials —

Part 1:
Designation and specification

1 Scope

1.1 This part of ISO 4613 establishes a system of designation for ethylene/vinyl acetate thermoplastic material, which may be used as the basis for specifications.

1.2 The types of E/VAC plastics are differentiated from each other by a classification system based on appropriate levels of the designatory properties

a) vinyl acetate content

b) melt flow rate

and on information about intended application and/or method of processing, important properties, additives, colorants, fillers and reinforcing materials.

1.3 This part of ISO 4613 is applicable to all ethylene vinyl acetate copolymers containing from 3 % (*m/m*) to 50 % (*m/m*) (approximately 25 % molar) of vinyl acetate.

It applies to materials ready for normal use in the form of powder, granules or pellets and to materials unmodified or modified by colorants, additives, fillers, etc.

1.4 It is not intended to imply that materials having the same designation give necessarily the same performance. This part of ISO 4613 does not provide engineering data, performance data or data on processing conditions which may be required to specify a material for a particular application and/or method of processing.

If such additional properties are required, they shall be determined in accordance with the test methods specified in ISO 4613-2, if suitable.

1.5 In order to specify a thermoplastic material for a particular application or to ensure reproducible processing, additional requirements may be given in data block 5 (see clause 3, introductory paragraph).

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 4613. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 4613 are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 1043-1:1987, *Plastics — Symbols — Part 1: Basic polymers and their special characteristics.*

ISO 1133:1991, *Plastics — Determination of the melt mass-flow rate (MFR) and the melt volume-flow rate (MVR) of thermoplastics.*

ISO 4613-2:1989, *Plastics — Ethylene/vinyl acetate copolymer (E/VAC) thermoplastics — Part 2: Preparation of test specimens and determination of properties.*

ISO 8985:1989, *Plastics — Ethylene/vinyl acetate copolymer (E/VAC) thermoplastics — Determination of vinyl acetate content.*

3 Designation and specification system

The designation and specification system for thermoplastics is based on the following standardized pattern:

<table>
<tr><td colspan="7">Designation</td></tr>
<tr><td rowspan="3">Description block (optional)</td><td colspan="6">Identity block</td></tr>
<tr><td rowspan="2">International Standard Number block</td><td colspan="5">Individual-item block</td></tr>
<tr><td>Data block 1</td><td>Data block 2</td><td>Data block 3</td><td>Data block 4</td><td>Data block 5</td></tr>
</table>

The designation consists of an optional description block, reading "Thermoplastics", and an identity block comprising the International Standard number and an individual-item block. For unambiguous coding, the individual-item block is subdivided into 5 data blocks comprising the following information:

— Data block 1: Identification of the plastic by its symbol E/VAC in accordance with ISO 1043-1 and information about the polymerization process or composition of the polymer (see 3.1).

— Data block 2: Position 1: Intended application or method of processing (see 3.2).

Positions 2 to 8: Important properties, additives and supplementary information (see 3.2).

— Data block 3: Designatory properties (see 3.3).

— Data block 4: Fillers or reinforcing materials and their nominal content (see 3.4).

— Data block 5: For the purpose of specifications, a fifth data block may be added containing additional information.

The first character of the individual-item block shall be a hyphen. The data blocks shall be separated from each other by commas.

If a data block is not used, this shall be indicated by doubling the separation sign, i.e. by two commas (,,).

3.1 Data block 1

In this data block, after the hyphen, E/VAC plastics are identified by the symbol "E/VAC", in accordance with ISO 1043-1 and, after a space, the vinyl acetate content is indicated.

The vinyl acetate content, expressed as a percentage by mass, shall be determined in accordance with ISO 8985. The possible values of vinyl acetate content are divided into 7 ranges, each represented by a 2-figure code-number as specified in table 1.

3.2 Data block 2

In this data block, information about intended application and/or method of processing is given in position 1 and information about important properties, additives and colour in positions 2 to 8. The code-letters used are specified in table 2.

If information is presented in positions 2 to 8 and no specific information is given in position 1, the letter X shall be inserted in position 1.

3.3 Data block 3

In this data block, the range of the melt flow rate is represented by a letter and a 3-figure code-number (see 3.3.1).

If a property value falls on or near a range limit, the manufacturer shall state which range will designate the material. If subsequent individual test values lie on, or on either side of, the limit because of manufacturing tolerances, the designation is not affected.

NOTE 1 Not all the combinations of the values of the designatory properties have to be provided for currently available polymers.

3.3.1 Melt flow rate

The melt mass-flow rate shall be determined in accordance with ISO 1133 under the test conditions specified in table 3.

Table 1 — Code-numbers used for additional information in data block 1

Code-number	VAC content % (*m/m*)
03	> 3 but ⩽ 5
08	> 5 but ⩽ 10
13	> 10 but ⩽ 15
18	> 15 but ⩽ 20
25	> 20 but ⩽ 30
35	> 30 but ⩽ 40
45	> 40 but ⩽ 50

Table 2 — Code-letters used in data block 2

Code-letter	Position 1	Code-letter	Positions 2 to 8
A	Adhesives	**A**	Processing stabilized
B	Blow moulding	**B**	Antiblocking
C	Calendering	**C**	Coloured
		D	Powder
E	Extrusion	**E**	Expandable
F	Extrusion of films	**F**	Special burning characteristics
G	General use	**G**	Granules
H	Coating	**H**	Heat ageing stabilized
K	Cable and wire coating	**K**	Metal deactivated
L	Monofilament extrusion	**L**	Light or weather stabilized
M	Moulding		
		N	Natural (no colour added)
		P	Impact modified
Q	Compression moulding		
R	Rotational moulding	**R**	Mould release agent
S	Sintering	**S**	Lubricated
T	Tape manufacture	**T**	Transparent
		W	Stabilized against hydrolysis
X	No indication		
		Y	Increased electrical conductivity
		Z	Antistatic

Table 3 — Test conditions used for the determination of melt flow rate

Code-letter	Temperature °C	Nominal load kg
D	190	2,16
B	150	2,16
Z	125	0,325

Set of conditions B is used only for materials having an MFR greater than 100 when tested under set of conditions D.

Set of conditions Z is used only for materials having an MFR greater than 100 when tested under set of conditions B.

The possible values of melt mass-flow rate are divided into 11 ranges, each represented by a 3-figure code-number as specified in table 4. The test conditions used shall be indicated by a single letter, selected from table 3, immediately preceding the code-number.

Table 4 — Ranges of melt flow rate in data block 3

Code-number	Range of melt flow rate (MFR) g/10 min
000	$\leqslant$ 0,10
001	> 0,10 but $\leqslant$ 0,20
003	> 0,20 but $\leqslant$ 0,40
006	> 0,40 but $\leqslant$ 0,80
012	> 0,80 but $\leqslant$ 1,5
022	> 1,5 but $\leqslant$ 3,0
045	> 3,0 but $\leqslant$ 6,0
090	> 6,0 but $\leqslant$ 12,0
200	> 12,0 but $\leqslant$ 25,0
400	> 25,0 but $\leqslant$ 50,0
700	> 50,0

NOTE 2 Melt mass-flow rate (MFR) will be replaced by melt volume-flow rate (MVR) at the next five-year revision of this standard.

3.4 Data block 4

In this data block, the type of filler and/or reinforcing material is represented by a single code-letter in position 1 and its physical form by a second code-letter in position 2, the code-letters being as specified in table 5. Subsequently (without a space), the mass content may be given by a two-figure number in positions 3 and 4.

3.5 Data block 5

Indication of additional requirements in this optional data block is a way of transforming the designation of a material into a specification for a particular application. This shall be done for example by reference to a suitable national standard or to a standard-like, generally established specification.

Table 5 — Code-letters for fillers and reinforcing materials in data block 4

Code-letter	Material	Code-letter	Form
B	boron	**B**	beads, spheres, balls
C	carbon[1)]		
		D	powder
		F	fibre
G	glass	**G**	ground
		H	whiskers
K	calcium carbonate		
L	cellulose[1)]		
M	mineral[1)2)], metal[1)]		
S	synthetic, organic[1)]	**S**	scales, flakes
T	talcum		
W	wood		
X	not specified	**X**	not specified
Z	others[1)]	**Z**	others[1)]

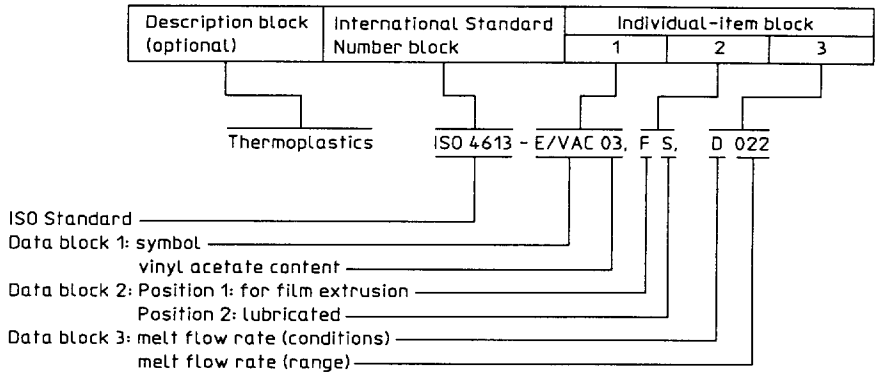
1) These materials may be further defined by their chemical symbol, for example, or additional symbols defined in the relevant International Standard. In the case of metals (M), it is essential to indicate the type of metal by means of its chemical symbol.

2) Mineral fillers should be designated more precisely if a symbol is available.

Mixtures of materials and/or forms may be indicated by combining the relevant codes using the sign "+" and placing the whole between parentheses. For example, a mixture of 25 % glass fibres (GF) and 10 % mineral powder (MD) would be indicated by (GF25+MD10).

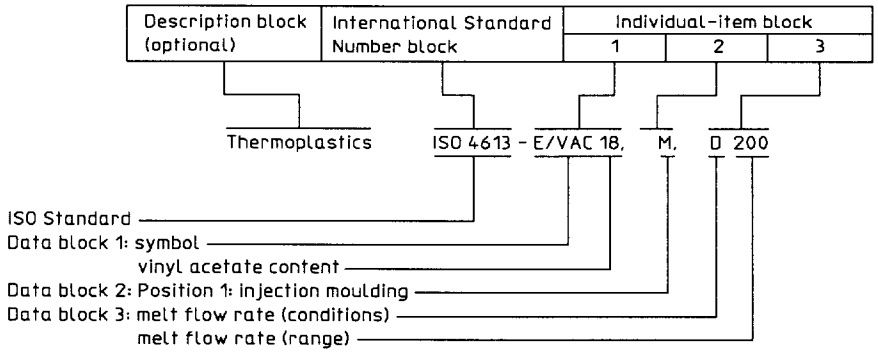
4 Examples of designations

4.1 An ethylene/vinyl acetate thermoplastic material (E/VAC) with a vinyl acetate content of 4 % (*m/m*) (03) intended for extrusion of film (F) with slip agent (S) and a melt flow rate (MFR 190/2,16) (D) of 2 g/10 min (022) would be designated:



Designation: ISO 4613-E/VAC 03,FS,D022

4.2 An ethylene/vinyl acetate thermoplastic material (E/VAC) with a vinyl acetate content of 17 % (*m/m*) (18) for injection moulding (M) with a melt flow rate (MFR 190/2,16) (D) of 19 g/10 min (200) would be designated:



Designation: ISO 4613-E/VAC 18,M,D200

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