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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 27797.10-2011

**Fibre-reinforced plastics -- Methods of producing test plates -- Part 10:
Injection moulding of BMC and other long-fibre moulding compounds
-- General principles and moulding of multipurpose test specimens**

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Administration of the People's Republic of China**

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Foreword

GB/T 27797 "fiber reinforced plastics test plates Preparation" is divided into 11 parts.

--- Part 1. General;

--- Part 2. the contact and injection molding;

--- Part 3. wet molding;

--- Part 4. prepreg molding;

--- Part 5. Filament winding;

--- Part 6. Pultrusion molding;

--- Part 7. resin transfer molding;

Part --- Article 8. SMC and BMC molding;

Part --- Article 9. GMT/STC molding;

--- Part 10. BMC and other long-fiber molding plastic injection molding and general principles common specimen molding;

--- Part 11. BMC and other long-fiber molding plastic injection molding small square pieces.

This section GB/T Part of 1,027,797.

This section drafted in accordance with GB/T 1.1-2009 given rules.

This section uses the translation method identical with ISO 1268-10. Part 10 2005 (E) "fiber reinforced plastics test plates Preparation

Points. BMC and other long-fiber molding plastic injection molding general principles and general molded specimen. "

Consistency correspondence between this part of international documents and normative references of our files are as follows.

--- GB/T 2035-2008 Plastics terms and definitions (ISO 472.1999, IDT);

--- GB/T 11997-2008 plastic multipurpose test specimens (ISO 3167.2002, IDT);

Get --- GB/T 19467.2-2004 plastic comparable single-point data - Part 2. Long fiber reinforced materials

(ISO 10350-2.2001, IDT);

--- GB/T 27797.1 fiber reinforced plastic plate test preparation methods - Part 1. General (ISO 1268-1.2001, IDT);

--- GB/T 27797.11 fiber reinforced plastic plate test preparation methods - Part 11. BMC and other long-fiber molding compounds

Injection molding small square pieces (ISO 1268-11.2005, IDT).

This part made the following editorial changes.

--- Some of the statements apply to international standards to apply to our standard formulation;

--- In addition 4.2.4, 5.1 article number.

This part is proposed by the China Building Materials Federation.

The fiber-reinforced plastic part by the National Standardization Technical Committee (SAC/TC39) centralized.

This section is drafted. Beijing glass Composite Material Co., Ltd., Changzhou Tianma Group Co., Ltd., China North Industries Group fifty-three

graduate School.

1 Scope

This section GB/T 27797 specifies the general principle of injection molding bulk molding compound (BMC) of the test sample is given by the repeatability

Injection molding conditions the same mold design details of the type of sample. Where appropriate, this part of GB/T 27797 also apply to sheet molding

Plastics (SMC) for injection molding. Its purpose is to enhance the main parameters of the injection molding process consistency, establish a unified operating conditions in the injection report

Make regulations. Under special conditions, for comparing the experimental injection of test panels, we need to change the use of the injection material. These conditions should be in the appropriate injection material

The standard method is given, or the two sides reach an agreement.

Note. The test showed that the mold design is an important factor repeated injection of the

sample.

GB/T 27797 in this part of the GB/T 27797.1 used together.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version suitable for use herein

Member. For undated references, the latest edition (including any amendments) applies to this document.

ISO 472 Plastics term (Plastics-Vocabulary)

ISO 2577 for determination of shrinkage thermosetting molding plastic
(Plastic-Thermosettingmouldingmaterials-

Determinationofshrinkage)

ISO 3167 multipurpose test specimens of plastic (Plastic-Multipurposetestspecimens)

ISO 1268-1 fiber reinforced plastics test plates preparation methods - Part 1. General
(Fibre-reinforcedplastics-

Methodsofproducingtestplates-Part 1. Generalconditions)

ISO 1268-11 fiber reinforced plastics test plates preparation methods - Part 11. BMC and
other long-fiber molding plastic injection mold

Small square plastic sheets (Fibre-reinforcedplastics-Methodsofproducingtestplates-Part
11. Injectionmoulding

ofBMCandotherlong-fibre moulding compounds-Smalplates)

ISO 10350-2 Plastics comparable single-point data collection and presentation - Part 2.
Long-fiber reinforced plastics (Plastics-Acqui-

sitionandpresentationofcomparable single-pointdata-Part 2. Long-fibre-reinforcedplastics)

ISO 10724-1 Plastics thermosetting plastic injection molding powder sample (PMCs) - Part
1. General principles and multipurpose test specimens

Molding

[Plastics-Injectionmouldingoftestspecimensofthermosettingpowdermouldingcompounds

(PMCs) -Part 1. Generalprinciplesandmouldingofmultipurposetestspecimens]

ISO 10724-2 Plastics thermosetting plastic injection molding powder sample (PMCs) - Part
2. Small sample [Plastics-Injection

mouldingoftestspecimensofthermosettingpowdermouldingcompounds (PMCs) -Part 2. Smal

plates]

ISO 11403-1 Plastics collection of comparable multipoint data - Part 1. mechanical properties (Plastics-Acquisition

andpresentationofcomparablemultipointdata-Part 1. Mechanicalproperties)

ISO 11403-2 Plastics collection of comparable multipoint data - Part 2. thermal properties and processing performance (Plastics-

Acquisitionandpresentationofcomparablemultipointdata-Part 2.

Thermalandprocessingproper-

ties)