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

GB/T 27797.6-2011

**Fibre-reinforced plastics -- Methods of producing test plates --
Part 6: Pultrusion moulding**

纤维增强塑料 试验板制备方法 第6部分：拉挤模塑

(English Translation)

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Table of Contents

- Foreword
- 1 Scope
- 2 Normative references
- 5 Material

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 627,797.

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

This section uses the translation method identical with ISO 1268-6:2002 (E) "fiber reinforced plastics test plates preparation methods - Part 6.

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

--- Plastic resin content test methods (ISO 1172:1996, MOD) GB/T 2577-2005 glass fiber reinforced;

--- GB/T 27797.1 fiber reinforced plastic plate test preparation methods - Part 1. General

(ISO 1268-1:2001, IDT).

This part made the following editorial changes.

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

--- In Chapter 6, Chapter 9, Chapter 10, Article No. plus.

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., China North Industries Group fifty-three Institute, Changzhou Tianma Group has Limited.

1 Scope

This section GB/T 27797 specifies the preparation of reinforced plastic pultrusion molding method of test plates. The resulting test panels for measuring and processing Specimen given layer mechanical and physical properties of plywood.

This method is suitable for the preparation of glass fibers, carbon fibers or aramid fibers (continuous roving, tow, surface mat, fabric or a combination thereof) reinforced thermosetting or a thermoplastic resin sheet. Reinforcing materials may be used alone or in combination.

GB/T 27797 and this part of 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 1172 Textile glass fiber reinforced plastic prepreg, molding compounds and laminates glass fibers and inorganic mineral filler content Burning Determination Act (Textile-glass-reinforcedplastics-Prepregs, mouldingcompoundsandlaminates-De-terminationofthetextile-glassandmineralfillercontent-Calcinationmethods) ISO 1268-1 fiber reinforced plastics test plates preparation methods - Part 1. General (Fibre-reinforcedplastics-Meth-odsofproducingtestplates-Part 1. Generalconditions) Health and safety See ISO 1268-1.

Principle 4

4.1 pultrusion process is a unique process of molding fiber composites can be molded with a continuous length of a composite material complex geometric cross-section, there are

Different fiber content, orientation and arrangement of fiber types. Pultruded profiles usually due to a cross-sectional shape is too small or unsuitable's difficult to cut again Comp verify its performance. If you can not meet the test conditions require obtaining a sample from the production of profiles, it is necessary to use the same raw materials, in accordance with the same process for preparing an alternative flat, then cut the sample from the plate according to the relevant alternative test methods. This section provides this alternate plate Preparation Process. This method can also be used to compare the performance of different profiles at different raw materials and production conditions of production.

4.2 After the reinforcing material impregnated with a suitable resin, pulled through the mold and cured under specified conditions, the preparation of the strip plate. Flat strip should be sufficient Width in order to sample length in the transverse direction of the cut or other specific needs.

5 Material

5.1

reinforcing material, suitable for all forms of pultrusion, mostly continuous roving, tow or yarn, carpet and fabric. Reinforcements should be subject to the table Surface treatment so that the resin system used in the match.