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

GB/T 9352-2008

Replacing GB/T 9352-1988

**Plastic -- Compression moulding of test specimens of
thermoplastic materials**

塑料 热塑性塑料材料试样的压塑

(English Translation)

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Foreword

This standard is equivalent to ISO 293 use 2004 "Plastics --- thermoplastic compression molding sample preparation" (in English).

9352-1988 "thermoplastic compression molding sample preparation" This standard replaces GB/T . This standard and GB/T 9352-1988 Technical the content of the only made editorial changes.

The standard proposed by China Petroleum and Chemical Corporation.

This standard by the National Standardization Technical Committee plastic resins and petrochemical products Club (SAC/TC15/SC1) centralized.

This standard was drafted. Beijing Yanshan Petrochemical Branch resin Institute of Applied China, Sichuan University, Chenguang Chemical Research Institute Co., the company.

Introduction

To make repeatable test results, we need to have a sample of a predetermined state. Compared to injection molding, compression molding purpose is to prepare a uniform and isotropic Sex sample and the sheet by machining or stamping method may obtain a sample from the sheet.

In the compression molding process, the degree of mixing of the material occurs very small and could be ignored. Melted pellets and powder occurs only on the surface, pre-plastic sheet (A mill sheet) is softened only partially.

Therefore, only when the molding material itself is homogeneous and isotropic, homogeneous and isotropic in order to obtain a sample. When processing more Phase material (such as ABS), consideration should be given to maintain its internal structure.

GB/T 9352-2008/ISO 293:2004 Compression molding of thermoplastic plastic material samples

1 Scope

This standard specifies the sample preparation of thermoplastic molding and general principles and steps of the test piece, the sample can be machined or stamped Obtained from the test piece.

In order to obtain a molding having repetitive include four individual cooling methods main processing steps are standard. For each Materials required during molding mold temperature and cooling method should be in accordance with international standards related materials or by the relevant provisions of the interests of both sides agreed.

Note: Not recommended reinforced thermoplastic material by this method.

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. For dated references, subsequent Amendments (not including errata content) or revisions do not apply to this standard, however, encourage the parties to the agreement are based on research Whether the latest versions of these documents. For undated reference documents, the latest versions apply to this standard.

GB/T 3505-2000 Geometrical product specifications Profile method - Terms surface structure (GPS) surface structure, definitions and parameters Number (eqv ISO 4287:1997)
ISO 286-1 Geometrical product specifications (GPS) --- ISO system of limits and fits --- Part 1. Tolerances, deviations and distribution Co-foundation (1988)

3 Terms and Definitions

The following terms and definitions apply to this standard.

Warm-up and during the molding, the molding compound in the closest region of the mold or molding machine template temperature measured.

At the end of the cooling in the region closest to the mold plastic molding machine template or mold temperature measured.

NOTE: For non-overflow die, can be used to measure borehole temperature specified in 3.1 and 3.2 on the mold.

Contact pressure is maintained, the material inside the mold is heated to a temperature required for the molding time.

To maintain full pressure is applied at the time of molding temperature.

With a constant flow of cooling fluid cooling rate. The average cooling rate calculation. The temperature difference between the mold and the mold release temperature divided by it cooled to a temperature required for the release time.

Note: The average cooling rate is usually °C/min represents.

GB/T 9352-2008/ISO 293:2004