

Tentative Method of

DESIGNATING THE FLOW TEMPERATURE OF THERMO- PLASTIC MOLDING MATERIALS¹



A.S.T.M. Designation: D 863 - 45 T

ISSUED, 1945.²

This Tentative Method has been approved by the sponsoring committee and accepted by the Society in accordance with established procedures, for use pending adoption as standard. Suggestions for revisions should be addressed to the Society at 1916 Race St., Philadelphia 3, Pa.

Scope

1. This method of flow designation is based on method A of the Tentative Method of Test for Measuring the Flow Properties of Thermoplastic Molding Materials (A.S.T.M. Designation: D 569)³ and is applicable to cellulosic molding compounds and to molding compounds for which method A of A.S.T.M. Method D 569 is applicable.

Method

2. The flow temperature shall be de-

termined by method A of A.S.T.M. Method D 569.

Flow Designation

3. M flow shall be defined as 293 ± 9 F. (145 ± 5 C.) and all other flows shall extend from this temperature in multiples of 9 F. (5 C.) as follows:

Flow Designation	Flow Temperature	
	Deg. Fahr.	Deg. Cent.
H _n	for each 9 F. (5 C.) higher, add 1 flow (that is, H ₃ , H ₄ , H ₅ , etc.)	
H ₂	320 $\pm$ 9	160 $\pm$ 5
H.....	311 $\pm$ 9	155 $\pm$ 5
MH.....	302 $\pm$ 9	150 $\pm$ 5
M.....	293 $\pm$ 9	145 $\pm$ 5
MS.....	284 $\pm$ 9	140 $\pm$ 5
S.....	275 $\pm$ 9	135 $\pm$ 5
S ₂	266 $\pm$ 9	130 $\pm$ 5
S _n	for each 9 F. (5 C.) lower, add 1 flow (that is, S ₂ , S ₄ , S ₅ , etc.)	

¹ Under the standardization procedure of the Society, this method is under the jurisdiction of the A.S.T.M. Committee D-20 on Plastics.

² Accepted by the Administrative Committee on Standards, January 17, 1946.

³ Appears in this publication, see Contents in Numerical Sequence of A.S.T.M. Designations at front of book.