INTERNATIONAL STANDARD

ISO 15252-3

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Plastics — Epoxy powder moulding compounds (EP-PMCs) —

Part 3: Requirements for selected moulding compounds

Plastiques — Poudres à mouler à base d'époxydes (EP-PMC) —

Partie 3: Exigences relatives à certaines poudres à mouler

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ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 734 10 79
E-mail copyright@iso.ch
Web www.iso.ch

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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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

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.

Attention is drawn to the possibility that some of the elements of this part of ISO 15252 may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 15252-3 was prepared by Technical Committee ISO/TC 61, *Plastics*, Subcommittee SC 12, *Thermosetting materials*.

ISO 15252 consists of the following parts, under the general title *Plastics — Epoxy powder moulding compounds (EP-PMCs)*:

— *Part 1: Designation system and basis for specifications*

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

— *Part 3: Requirements for selected moulding compounds*

Annex A of this part of ISO 15252 is for information only.

Plastics — Epoxy powder moulding compounds (EP-PMCs) —

Part 3:
Requirements for selected moulding compounds

1 Scope

This part of ISO 15252 specifies the requirements for the physical and chemical properties of epoxy powder moulding compounds (EP-PMCs) and compression- or injection-moulded test specimens produced from them.

It is limited to those powder moulding compounds whose composition and properties are significantly different. It is further limited to those moulding compounds which are of general technical and/or economic importance.

The properties which are used to characterize the moulding compounds, the test methods and the test conditions are selected from those given in ISO 15252-2.

The moulding compounds are divided into types according to their composition and properties. The various types are designated using the designation system defined in ISO 15252-1.

2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this part of ISO 15252. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this part of ISO 15252 are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 472:1999, *Plastics — Vocabulary.*

ISO 15252-1:1999, *Plastics — Epoxy powder moulding compounds (EP-PMCs) — Part 1: Designation system and basis for specifications.*

ISO 15252-2:1999, *Plastics — Epoxy powder moulding compounds (EP-PMCs) — Part 2: Preparation of test specimens and determination of properties.*

3 Terms and definitions

For the purposes of this part of ISO 15252, the terms and definitions given in ISO 472, ISO 15252-1 and ISO 15252-2 apply.

4 Requirements

4.1 Property values

In order for an epoxy powder moulding compound to be considered as complying with this part of ISO 15252, it shall meet the requirements given in the appropriate table (Table 1, 2 or 3).

Tables 1, 2 and 3 give the mean value obtained for the set of test specimens used to determine a particular property. Individual values of properties 2.1, 2.2, 2.3 and 2.4 shall be within 10 % of the mean value, and individual values of properties 3.1 and 3.2 shall be within 5 °C of the mean value.

No specific limits are placed on rheological and processing properties. However, suitable rheological and processing properties are essential for the satisfactory use of a moulding compound. The test methods and test conditions used shall be as agreed between the interested parties.

In addition, for some applications, it may be useful for information to be made available on other properties, for example:

— cure time;

— particle size;

— moisture content.

If this is so, these properties and test methods, as well as the test conditions to be used, shall be as agreed between the interested parties.

4.2 Filler/reinforcement type and content

In order for an epoxy powder moulding compound to be considered as complying with this part of ISO 15252, the nature, form and content by mass of its filler/reinforcement shall be as given in the designation of the moulding compound (see ISO 15252-1:1999, subclause 4.2).

Table 1 — Property requirements for EP-PMCs containing MD or (GF+MD) as filler

	Property	Unit	Pro-cess-ing[a]	Max. or min.	1	2	3	4
					Type: PMC ISO 15252-EP. . .			
					MD65,X,E to MD75,X,E	MD65,X,T to MD75,X,T	(GF10+MD60) to (GF20+MD50)	(GF10+MD60),X,E to (GF20+MD50),X,E
1	**Rheological and processing properties**							
1.1	To be agreed between the interested parties							
2	**Mechanical properties**							
2.1	Stress at break, σ_B	MPa	Q M	⩾ ⩾	— 40	— 40	— 70	— 70
2.2	Flexural strength, σ_{fM}	MPa	Q M	⩾ ⩾	80 80	90 90	120 130	120 130
2.3	Charpy impact strength, a_{cU}	kJ/m^2	Q M	⩾ ⩾	5,0 5,0	5,0 5,0	7,0 9,0	7,0 9,0
2.4	Charpy notched impact strength a_{cA}	kJ/m^2	Q M	⩾ ⩾	1,5 1,5	1,5 1,5	2,0 3,0	2,0 3,0
3	**Thermal properties**							
3.1	Temperature of deflection under load, $T_f1{,}8$	°C	Q/M	⩾	130	180	150	150
3.2	Temperature of deflection under load, $T_f8{,}0$	°C	Q/M	⩾	90	120	100	100
3.3	Flammability (glow bar), BH	—	Q/M	⩽	BH 2-30	BH 2-30	BH 2-10	BH 2-10
4	**Electrical properties**							
4.1	Dissipation factor, tan δ 100	—	Q/M	⩽	0,03	—	—	0,03
4.2	Volume resistivity, ρ_e	Ω·cm	Q/M	⩾	10^{14}	10^{13}	10^{13}	10^{14}
4.3	Surface resistivity, σ_e	Ω	Q/M	⩾	10^{13}	10^{12}	10^{12}	10^{13}
4.4	Proof tracking index, PTI	—	Q/M	⩾	600	300	200	600
5	**Other properties**							
5.1	Water absorption, W_w24	mg	Q/M	⩽	80	80	60	50
5.2		% by mass		⩽	—	—	—	—

[a] Q = Compression moulding
M = Injection moulding

NOTE 1 See ISO 15252-2:1999, Tables 3 and 4, columns 3, 4 and 7, for the methods to be used for the preparation of test specimens and the determination of properties.

NOTE 2 In view of the differences between the property-value limits for compression-moulding and injection-moulding materials, the likely variations in test results and the wide range of properties covered, it should not be assumed that materials having the same designation are exactly equivalent.

Table 2 — Property requirements for EP-PMCs containing (GF+MD) as filler

	Property	Unit	Pro-cess-ing[a]	Max. or min.	5	6	7	8
					Type: PMC ISO 15252-EP. . .			
					(GF15+MD55) to (GF25+MD45)	(GF20+MD50),X,E to (GF30+MD40),X,E	(GF20+MD50) to (GF30+MD40)	(GF25+MD45) to (GF35+MD35)
1	**Rheological and processing properties**							
1.1	To be agreed between the interested parties							
2	**Mechanical properties**							
2.1	Stress at break, σ_B	MPa	Q M	⩾ ⩾	— 70	— 70	— 70	— 80
2.2	Flexural strength, σ_{fM}	MPa	Q M	⩾ ⩾	110 120	130 140	130 140	150 160
2.3	Charpy impact strength, a_{cU}	kJ/m^2	Q M	⩾ ⩾	8,0 10,0	8,0 10,0	7,0 9,0	8,0 10,0
2.4	Charpy notched impact strength a_{cA}	kJ/m^2	Q M	⩾ ⩾	3,0 4,0	4,0 5,0	2,5 4,5	2,5 3,5
3	**Thermal properties**							
3.1	Temperature of deflection under load, $T_f1{,}8$	°C	Q/M	⩾	200	200	180	180
3.2	Temperature of deflection under load, $T_f8{,}0$	°C	Q/M	⩾	120	120	120	120
3.3	Flammability (glow bar), BH	—	Q/M	⩽	BH 2-10	BH 2-10	BH 2-10	BH 2-10
4	**Electrical properties**							
4.1	Dissipation factor, tan δ 100	—	Q/M	⩽	—	0,03	—	—
4.2	Volume resistivity, ρ_e	Ω·cm	Q/M	⩾	10^{13}	10^{14}	10^{13}	10^{14}
4.3	Surface resistivity, σ_e	Ω	Q/M	⩾	10^{12}	10^{13}	10^{12}	10^{13}
4.4	Proof tracking index, PTI	—	Q/M	⩾	250	600	400	250
5	**Other properties**							
5.1	Water absorption, W_w24	mg	Q/M	⩽	40	30	30	30
5.2		% by mass		⩽	—	—	—	—

[a] Q = Compression moulding
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NOTE 1 See ISO 15252-2:1999, Tables 3 and 4, columns 3, 4, and 7, for the methods to be used for the preparation of test specimens and the determination of properties.

NOTE 2 In view of the differences between the property-value limits for compression-moulding and injection-moulding materials, the likely variations in test results and the wide range of properties covered, it should not be assumed that materials having the same designation are exactly equivalent.

Table 3 — Property requirements for EP-PMCs containing (GF+GG) as filler

					9	10	11	12
					Type: PMC ISO 15252-EP. . .			
	Property	Unit	Pro-cess-ing[a]	Max. or min.	(GF25+GG25) to (GF35+GG15)	—	—	—
1	**Rheological and processing properties**							
1.1	To be agreed between the interested parties							
2	**Mechanical properties**							
2.1	Stress at break, σ_B	MPa	Q M	⩾ ⩾	— 50			
2.2	Flexural strength, σ_{fM}	MPa	Q M	⩾ ⩾	120 130			
2.3	Charpy impact strength, a_{cU}	kJ/m^2	Q M	⩾ ⩾	6,0 6,0			
2.4	Charpy notched impact strength a_{cA}	kJ/m^2	Q M	⩾ ⩾	2,0 2,0			
3	**Thermal properties**							
3.1	Temperature of deflection under load, T_f1,8	°C	Q/M	⩾	150			
3.2	Temperature of deflection under load, T_f8,0	°C	Q/M	⩾	100			
3.3	Flammability (glow bar), BH	—	Q/M	⩽	BH 2-10			
4	**Electrical properties**							
4.1	Dissipation factor, tan δ 100	—	Q/M	⩽	—			
4.2	Volume resistivity, ρ_e	Ω·cm	Q/M	⩾	10^{13}			
4.3	Surface resistivity, σ_e	Ω	Q/M	⩾	10^{12}			
4.4	Proof tracking index, PTI	—	Q/M	⩾	250			
5	**Other properties**							
5.1	Water absorption, W_w24	mg	Q/M	⩽	30			
5.2		% by mass		⩽	—			

[a] Q = Compression moulding
M = Injection moulding

NOTE 1 See ISO 15252-2:1999, Tables 3 and 4, columns 3, 4, and 7, for the methods to be used for the preparation of test specimens and the determination of properties.

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