

Plastics — Compression moulding test specimens of thermoplastic materials

IMPORTANT NOTE. Before reading this method it is essential to read BS 2782-0, issued separately.
The European Standard EN ISO 293:2003 has the status of a British Standard

ICS 83.080.20

This British Standard, having been prepared under the direction of the Plastics Standards Committee, was published under the authority of the Board of BSI and comes into effect on 31 October 1988
© BSI 11 July 2003
First published October 1977
First revision October 1988

The following BSI references relate to the work on this standard:
Committee reference PLM/17
Draft for comment 78/55602 DC

Amendments issued since publication

Amd. No.	Date	Comments
14419	15 July 2003	Renumbers BS 2782-9:Method 901A:1998 as BS EN ISO 293:2003

Contents

	Page
National foreword	ii
0 Introduction	3
1 Scope and field of application	3
2 References	3
3 Definitions	3
4 Apparatus	4
5 Procedure	5
6 Inspection of the moulded specimens or sheets	7
7 Test report	7
Figure 1 — Types of flash (“picture frame”) moulds	7
Figure 2 — Positive-type mould	7
Table — Cooling methods	6

National foreword

This British Standard is the English language version of EN ISO 293:2003. It is identical with ISO 293:1986.

It supersedes BS 2782-9: Method 901A:1977, which is withdrawn and which was identical with the first edition of ISO 293, published in 1974.

This method differs from Method 901A:1977 principally in the following respects:

- a) recommendations are introduced in respect of the surface roughness of the mould tools and of the fit between mould parts, with supporting references;
- b) definitions are incorporated for key terms;
- c) requirements for the moulding press in respect of the magnitude and variation of the clamping force and surface temperatures are more rigorously specified;
- d) a subclause (5.1.2) has been introduced on the preparation of sheet preforms when necessary;
- e) a choice of four cooling methods with specific cooling rates is specified and coded;
- f) guidance on moulding conditions for specific plastics materials, particularly polyvinyl chloride plastics or polyethylene plastics, has been deleted in favour of reference to the corresponding international standards for specifying and determining the properties of the material as applicable.

Cross-references

The British Standards which implement international or European publications referred to in this document may be found in the *BSI Catalogue* under the section entitled “International Standards Correspondence Index”, or by using the “Search” facility of the *BSI Electronic Catalogue* or of British Standards Online.

The Technical Committee has reviewed the provisions of ISO 468, to which reference is made in the text, and has decided that they are acceptable for use in conjunction with this method. There is no corresponding British Standard for ISO 468-1982; the relevant (metric) provisions of BS 1134-1:1972 “*Method and instrumentation*” and BS 1134-2:1972 “*General information and guidance*” were related to ISO/R 468.

WARNING NOTE. This British Standard method, which is identical with ISO 293, does not necessarily detail all precautions necessary to meet the requirements of the Health and Safety at Work etc. Act 1974. Attention should be paid to any appropriate safety precautions and the method should be operated only by trained personnel.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, pages 1 to 7 and a back cover.

The BSI copyright notice displayed in this document indicates when the document was last issued.