

Contents

| | |
|--|---------------|
| Preface to the Third Edition | V |
| Preface to the Second Edition | VI |
| Preface to the First Edition | VIII |
| The Authors | XI |
| The Editors | XI |
| Wolfgang Grellmann | XI |
| Sabine Seidler | XI |
| The Co-Authors | XII |
| Nomenclature (Selection) | XXVII |
| Terminology | XXXVII |
| Materials – Symbols and Abbreviated Terms | XLI |
| 1 Introduction | 1 |
| 1.1 The Genesis of Polymer Testing as a Science | 1 |
| 1.2 Factors Influencing Data Acquisition | 5 |
| 1.3 Classification of Polymer Testing Methods | 6 |
| 1.4 Standards and Regulatory Codes for Polymer Testing | 8 |
| 1.5 Compilation of Standards | 11 |
| 2 Preparation of Specimens | 15 |
| 2.1 Introduction | 15 |
| 2.2 Testing Molding Materials | 17 |

| | | |
|----------|---|-----------|
| 2.3 | Specimen Preparation | 18 |
| 2.3.1 | General Remarks | 18 |
| 2.3.2 | Specimen Preparation by Direct Shaping | 20 |
| 2.3.2.1 | Production of Specimens from Thermoplastic Molding Materials | 20 |
| 2.3.2.2 | Production of Specimens from Thermosetting Molding Materials | 26 |
| 2.3.2.3 | Production of Specimens from Elastomeric Materials | 28 |
| 2.3.3 | Specimen Preparation by Indirect Shaping | 29 |
| 2.3.4 | Characterization of Specimen State | 30 |
| 2.4 | Specimen Preparation and Conditioning | 33 |
| 2.5 | Compilation of Standards | 36 |
| 3 | Determining Process-Related Properties | 39 |
| 3.1 | Molding Materials | 39 |
| 3.2 | Determining Bulk Material Properties | 40 |
| 3.2.1 | Bulk Density, Compacted Apparent Density, Fill Factor | 40 |
| 3.2.2 | Pourability, Repose Angle , Slide Angle | 42 |
| 3.3 | Determining the Properties of Fluids | 43 |
| 3.3.1 | Rheological Fundamentals | 43 |
| 3.3.1.1 | Viscosity of <i>Newtonian</i> and <i>Non-Newtonian</i> Fluids .. | 43 |
| 3.3.1.2 | Temperature and Pressure Dependence of Viscosity . | 46 |
| 3.3.1.3 | Molecular Mass Influence on Viscosity | 46 |
| 3.3.1.4 | Volume Properties | 47 |
| 3.3.2 | Measuring Rheological Properties | 47 |
| 3.3.2.1 | Rheometry/Viscometry | 47 |
| 3.3.2.2 | Rotational Rheometers | 48 |
| 3.3.2.3 | Capillary Rheometers | 55 |
| 3.3.2.4 | Extensional Rheometers | 65 |
| 3.3.3 | Selecting Measurement Methods for Characterizing Polymer Materials | 67 |
| 3.4 | Compilation of Standards | 68 |

| | | |
|----------|--|-----------|
| 4 | Mechanical Properties of Polymers | 71 |
| 4.1 | Fundamental Principles of Mechanical Behavior | 71 |
| 4.1.1 | Mechanical Loading Parameters | 71 |
| 4.1.1.1 | Stress | 71 |
| 4.1.1.2 | Strain | 74 |
| 4.1.2 | Material Behavior and Constitutive Equations | 75 |
| 4.1.2.1 | Elastic Behavior | 75 |
| 4.1.2.2 | Viscous Behavior | 78 |
| 4.1.2.3 | Viscoelastic Behavior | 79 |
| 4.1.2.4 | Plastic Behavior | 85 |
| 4.2 | Mechanical Spectroscopy | 87 |
| 4.2.1 | Experimental Determination of Time-Dependent Mechanical Properties | 87 |
| 4.2.1.1 | Static Testing Methods | 87 |
| 4.2.1.2 | Dynamic-Mechanical Analysis (DMA) | 88 |
| 4.2.2 | Time and Temperature Dependence of Viscoelastic Properties | 96 |
| 4.2.3 | Structural Factors Influencing Viscoelastic Properties | 99 |
| 4.3 | Quasi-Static Test Methods | 101 |
| 4.3.1 | Deformation Behavior of Polymers | 101 |
| 4.3.2 | Tensile Tests on Polymers | 106 |
| 4.3.2.1 | Theoretical Basis of the Tensile Test | 106 |
| 4.3.2.2 | Conventional Tensile Tests | 109 |
| 4.3.2.3 | Enhanced Information of Tensile Tests | 118 |
| 4.3.3 | Tear Test | 124 |
| 4.3.4 | Compression Test on Polymers | 125 |
| 4.3.4.1 | Theoretical Basis of the Compression Test | 125 |
| 4.3.4.2 | Performance and Evaluation of Compression Tests | 129 |
| 4.3.5 | Bend Tests on Polymers | 133 |
| 4.3.5.1 | Theoretical Basis of the Bend Test | 133 |
| 4.3.5.2 | The Standardized Bend Test | 139 |
| 4.4 | Impact Loading | 143 |
| 4.4.1 | Introduction | 143 |
| 4.4.2 | <i>Charpy</i> Impact Test and Notched <i>Charpy</i> Impact Test | 144 |

| | | |
|---------|--|-----|
| 4.4.3 | Tensile-Impact and Notched Tensile-Impact Tests | 150 |
| 4.4.4 | Free-Falling Dart Test and Puncture Impact Test | 152 |
| 4.5 | Fatigue Behavior | 156 |
| 4.5.1 | Fundamentals | 156 |
| 4.5.2 | Experimental Determination of Fatigue Behavior | 158 |
| 4.5.3 | Planning and Evaluating Fatigue Tests | 162 |
| 4.5.4 | Factors Influencing the Fatigue Behavior and Service-Life Prediction of Service Life for Polymers | 164 |
| 4.6 | Long-Term Static Behavior | 167 |
| 4.6.1 | Fundamentals | 167 |
| 4.6.2 | Tensile Creep Test | 168 |
| 4.6.3 | Flexural Creep Test | 175 |
| 4.6.4 | Creep Compression Test | 176 |
| 4.7 | Hardness Test Methods | 178 |
| 4.7.1 | Principles of Hardness Testing | 178 |
| 4.7.2 | Conventional Hardness Testing Methods | 180 |
| 4.7.2.1 | Test Methods for Determining Hardness Values after Unloading | 180 |
| 4.7.2.2 | Test Methods for Determining Hardness Values under Load | 182 |
| 4.7.2.3 | Special Test Methods | 185 |
| 4.7.2.4 | Comparability of Hardness Values | 186 |
| 4.7.3 | Instrumented Hardness Test | 187 |
| 4.7.3.1 | Fundamentals of Measurement Methodology | 187 |
| 4.7.3.2 | Material Parameters Derived from Instrumented Hardness Tests | 190 |
| 4.7.3.3 | Examples of Applications | 192 |
| 4.7.4 | Correlating Microhardness with Yield Stress and Fracture Toughness | 194 |
| 4.8 | Friction and Wear | 198 |
| 4.8.1 | Introduction | 198 |
| 4.8.2 | Fundamentals of Friction and Wear | 200 |
| 4.8.2.1 | Frictional Forces | 200 |
| 4.8.2.2 | Temperature Increase Resulting from Friction | 201 |

| | | |
|----------|--|------------|
| 4.8.2.3 | Wear as a System Characteristic | 201 |
| 4.8.2.4 | Wear Mechanisms and Formation of Transfer Film .. | 202 |
| 4.8.3 | Wear Tests and Wear Characteristics | 203 |
| 4.8.3.1 | Selected Model Wear Tests | 204 |
| 4.8.3.2 | Wear Parameters and Their Determination | 205 |
| 4.8.3.3 | Wear Parameters and Their Presentation | 206 |
| 4.8.4 | Selected Experimental Results | 207 |
| 4.8.4.1 | Counterbody Influence | 207 |
| 4.8.4.2 | Influencing of Fillers | 208 |
| 4.8.4.3 | Influence of Loading Parameters | 210 |
| 4.8.4.4 | Predicting Properties via Artificial Neural Networks | 212 |
| 4.8.5 | Summary | 213 |
| 4.9 | Compilation of Standards | 214 |
| 5 | Fracture Toughness Measurements in Engineering Plastics .. | 229 |
| 5.1 | Introduction | 229 |
| 5.2 | Current State and Development Trends | 230 |
| 5.3 | Fundamental Concepts of Fracture Mechanics | 231 |
| 5.3.1 | Linear-Elastic Fracture Mechanics (LEFM) | 231 |
| 5.3.2 | Crack-Tip-Opening Displacement (CTOD) Concept | 236 |
| 5.3.3 | J-Integral Concept | 239 |
| 5.3.4 | Crack Resistance (R-) Curve Concept | 241 |
| 5.4 | Experimental Determination of Fracture Mechanical Parameters | 243 |
| 5.4.1 | Quasi-Static Loading | 243 |
| 5.4.2 | Instrumented <i>Charpy</i> Impact Test | 246 |
| 5.4.2.1 | Test Configuration | 246 |
| 5.4.2.2 | Maintenance of Experimental Conditions | 248 |
| 5.4.2.3 | Types of Load-Deflection Diagrams - Optimization of Diagram Shape | 250 |
| 5.4.2.4 | Special Approximation Methods for Estimating <i>J</i> Values | 251 |
| 5.4.2.5 | Requirements for Specimen Geometry | 254 |
| 5.4.3 | Instrumented Free-Falling Dart Test | 256 |
| 5.5 | Applications for Material Development | 258 |

| | | |
|----------|--|------------|
| 5.5.1 | Fracture Mechanical Toughness Evaluation on Modified Polymers | 258 |
| 5.5.1.1 | Particle Filled Thermoplastics | 258 |
| 5.5.1.2 | Fiber-Reinforced Thermoplastics | 262 |
| 5.5.1.3 | Blends and Copolymers | 266 |
| 5.5.2 | Instrumented Tensile-Impact Testing for Product Evaluation | 272 |
| 5.5.3 | Consideration of Fracture Behavior for Material Selection and Dimensioning | 275 |
| 5.6 | Compilation of Standards | 277 |
| 6 | Testing of Physical Properties | 283 |
| 6.1 | Thermal Properties | 283 |
| 6.1.1 | Introduction | 283 |
| 6.1.2 | Determining Heat Conductivity | 285 |
| 6.1.3 | Differential Scanning Calorimetry (DSC) | 289 |
| 6.1.4 | Thermogravimetric Analysis (TGA) | 294 |
| 6.1.5 | Thermomechanical Analysis (TMA) | 296 |
| 6.2 | Optical Properties | 299 |
| 6.2.1 | Introduction | 299 |
| 6.2.2 | Reflection and Diffraction | 300 |
| 6.2.2.1 | Directed and Diffuse Reflection | 300 |
| 6.2.2.2 | Refractive Index Determination | 301 |
| 6.2.3 | Dispersion | 305 |
| 6.2.4 | Polarization | 305 |
| 6.2.4.1 | Optical Activity | 306 |
| 6.2.4.2 | Polarization of Optical Components | 306 |
| 6.2.4.3 | Polarization-Optical Testing Methods | 308 |
| 6.2.5 | Transmission, Absorption and Reflection | 314 |
| 6.2.6 | Gloss, Intrinsic Diffuse Reflectance and Haze | 315 |
| 6.2.7 | Color | 319 |
| 6.2.8 | Transparency and Translucency | 322 |
| 6.2.9 | Infrared Spectroscopy | 325 |
| 6.2.10 | Laser Technology | 328 |
| 6.2.11 | Testing the Stability of Optical Values | 329 |

| | | |
|----------|--|------------|
| 6.3 | Electrical and Dielectrical Properties | 330 |
| 6.3.1 | Introduction | 330 |
| 6.3.2 | Physical Fundamentals | 333 |
| 6.3.3 | Electrical Conductivity and Resistance | 336 |
| 6.3.3.1 | Volume Resistivity | 336 |
| 6.3.3.2 | Surface Resistivity | 339 |
| 6.3.3.3 | Insulation Resistance | 340 |
| 6.3.3.4 | Contacting and Specimen Preparation | 343 |
| 6.3.4 | Dielectrical Properties and Dielectrical Spectroscopy | 344 |
| 6.3.4.1 | Relaxation Processes | 345 |
| 6.3.4.2 | Alternating Current Conductivity (AC Conductivity) | 353 |
| 6.3.4.3 | Broadband Dielectric Measurement Techniques | 354 |
| 6.3.5 | Special Technical Testing Methods | 361 |
| 6.3.5.1 | Electrostatic Charge | 361 |
| 6.3.5.2 | Electric Strength | 362 |
| 6.3.5.3 | Creep Resistance and Arc Resistance | 366 |
| 6.4 | Compilation of Standards | 369 |
| 7 | Evaluating Environmental Stress Cracking Resistance | 383 |
| 7.1 | General Remarks on the Failure of Polymers in Aggressive Fluids ... | 383 |
| 7.2 | Testing Environmental Stress Cracking Resistance | 387 |
| 7.2.1 | Test Methods for Determining Environmental Stress Crack Formation | 387 |
| 7.2.2 | Examples for Evaluating Environmental Stress Cracking Resistance with Standardized Test Methods | 391 |
| 7.2.3 | Fracture Mechanics Test Methods | 394 |
| 7.3 | Modeling Plastics Failure in Fluids Caused by Stress Cracking | 398 |
| 7.4 | Factors Influencing Stress Cracking Behavior | 402 |
| 7.4.1 | Crosslinking | 402 |
| 7.4.2 | Molecular Weight and Molecular Weight Distribution | 403 |
| 7.4.3 | Branching | 404 |
| 7.4.4 | Crystalline Regions | 405 |
| 7.4.5 | Molecular Orientation | 407 |
| 7.4.6 | Physical-Chemical Interaction Processes | 410 |

| | | |
|----------|--|------------|
| 7.4.7 | Viscosity of the Immersion Fluid | 416 |
| 7.4.8 | Influence of Test Specimen Thickness | 421 |
| 7.4.9 | Temperature Influence | 422 |
| 7.5 | Compilation of Standards | 425 |
| 8 | Non-Destructive Polymer Testing | 431 |
| 8.1 | Introduction | 431 |
| 8.2 | Non-Destructive Testing by Electromagnetic Waves | 433 |
| 8.2.1 | X-Ray Radiation | 433 |
| 8.2.1.1 | Projection Methods by Means of Absorption | 434 |
| 8.2.1.2 | <i>Compton</i> Backscatter | 436 |
| 8.2.1.3 | X-Ray Refractometry | 437 |
| 8.2.2 | Spectral Range of Visible Light | 440 |
| 8.2.2.1 | Measuring Thickness of Transparent Components .. | 440 |
| 8.2.2.2 | Photoelastic Imaging of Transparent Components ... | 440 |
| 8.2.2.3 | Confocal Laser Scan Microscopes | 441 |
| 8.2.2.4 | Line Projection for Detecting Contour | 442 |
| 8.2.2.5 | Interferometric Methods | 443 |
| 8.2.3 | Thermography | 449 |
| 8.2.4 | Microwaves | 449 |
| 8.2.5 | Dielectric Spectroscopy | 453 |
| 8.2.6 | Eddy Current | 454 |
| 8.3 | Non-Destructive Testing with Elastic Waves | 456 |
| 8.3.1 | Elastic Waves under Linear Material Behavior | 457 |
| 8.3.1.1 | Ultrasound | 457 |
| 8.3.1.2 | Mechanical Vibrometry | 468 |
| 8.3.2 | Elastic Waves with Non-Linear Material Behavior | 471 |
| 8.3.2.1 | Fundamentals on Elastic Waves in Non-Linear Materials | 471 |
| 8.3.2.2 | Non-Linear Air-Ultrasound | 472 |
| 8.3.2.3 | Non-Linear Vibrometry | 475 |
| 8.4 | Non-Destructive Testing by Dynamic Heat Transport | 477 |
| 8.4.1 | External Excitation | 478 |

| | | |
|-----------|---|------------|
| 8.4.1.1 | Heat-Flux Thermography by Non-Periodical Heat Transport | 478 |
| 8.4.1.2 | Thermography with Periodical Heat Transport | 480 |
| 8.4.2 | Internal Excitation | 484 |
| 8.4.2.1 | Thermography with Excitation by Elastic Waves | 484 |
| 8.4.2.2 | Thermography with Other Types of Internal Excitation | 489 |
| 8.5 | Outlook | 489 |
| 9 | Hybrid Methods of Polymer Diagnostics | 497 |
| 9.1 | Objectives | 497 |
| 9.2 | Tensile Test, Acoustic Emission Test and Video Thermography | 499 |
| 9.3 | Tensile Test and Laser Extensometry | 502 |
| 9.4 | Fracture Mechanics and Non-Destructive Testing | 507 |
| 10 | Testing of Composite Materials | 515 |
| 10.1 | Introduction | 515 |
| 10.2 | Theoretical Background | 517 |
| 10.2.1 | Anisotropy | 517 |
| 10.2.2 | Elastic Properties of Laminates | 518 |
| 10.2.3 | Influence from Moisture and Temperature | 518 |
| 10.2.4 | Laminate Theory and <i>St. Venant's</i> Principle | 519 |
| 10.2.5 | Applying Fracture Mechanical Concepts to Fiber Composites .. | 520 |
| 10.3 | Specimen Preparation | 522 |
| 10.3.1 | Manufacture of Laminates | 522 |
| 10.3.2 | Preparing Specimens for Unidirectional Loading | 524 |
| 10.4 | Determining Fiber Volume Content | 526 |
| 10.5 | Mechanical Test Methods | 527 |
| 10.5.1 | Tensile Tests | 527 |
| 10.5.2 | Compression Tests | 530 |
| 10.5.3 | Flexural Tests | 534 |
| 10.5.4 | Interlaminar Shear Strength | 537 |
| 10.5.5 | Shear Tests | 538 |
| 10.5.5.1 | $\pm 45^\circ$ Off-Axis Tensile Test | 538 |

| | | |
|-----------|---|------------|
| 10.5.5.2 | 10° Off-Axis Tensile Test | 540 |
| 10.5.5.3 | Two- and Three-Rail Shear Test | 541 |
| 10.5.5.4 | Iosipescu Shear Test | 543 |
| 10.5.5.5 | Plate-Twist Shear Test | 544 |
| 10.5.5.6 | Torsional Loading on Thin-Walled Tubes | 545 |
| 10.6 | Fracture Mechanical Test Methods | 546 |
| 10.6.1 | Experimental Tests on Fiber Composite Materials | 546 |
| 10.6.2 | Special Specimen Configuration | 547 |
| 10.6.2.1 | Specimens for Mode I Loading | 547 |
| 10.6.2.2 | Specimen for Mode II Loading | 548 |
| 10.6.2.3 | Mixed-Mode Specimens | 551 |
| 10.6.3 | Fracture Mechanical Values of Fiber Composite Materials | 554 |
| 10.7 | Dedicated Test Methods | 555 |
| 10.7.1 | Edge Delamination Test (EDT) | 555 |
| 10.7.2 | Boeing Open-Hole Compression Test | 556 |
| 10.8 | Peel Strength of Flexible Laminates | 557 |
| 10.9 | Impact Loading and Damage Tolerance | 559 |
| 10.10 | Compilation of Standards and Guidelines | 562 |
| 11 | Technological Testing Methods | 569 |
| 11.1 | Heat Distortion Resistance | 569 |
| 11.1.1 | Fundamentals and Definitions | 569 |
| 11.1.2 | Determining Heat Distortion Resistance Temperature <i>HDT</i> and <i>Vicat</i> Softening Temperature | 570 |
| 11.1.3 | Practical Examples for the Informational Value of the <i>Vicat</i> and <i>HDT</i> Test | 573 |
| 11.2 | Fire Behavior | 577 |
| 11.2.1 | Introduction | 577 |
| 11.2.2 | Stages of a Fire and Fire-Determining Parameters | 579 |
| 11.2.3 | Fire Tests | 581 |
| 11.2.3.1 | Smoldering Fire | 582 |
| 11.2.3.2 | Ignitability | 583 |
| 11.2.3.3 | Flame Spread | 587 |
| 11.2.3.4 | Heat Release | 590 |

| | | |
|----------|--|-----|
| 11.2.3.5 | Fire Resistance | 592 |
| 11.2.3.6 | Ease of Extinction | 592 |
| 11.2.4 | Utilization of Cone Calorimeter to Characterize Fire Behavior | 594 |
| 11.3 | Component Testing | 600 |
| 11.3.1 | Introduction | 600 |
| 11.3.2 | Basic Testing Methods | 601 |
| 11.3.2.1 | General Remarks | 601 |
| 11.3.2.2 | Testing Visible Features | 601 |
| 11.3.2.3 | Testing Materials Properties | 603 |
| 11.3.2.4 | Testing Serviceability | 605 |
| 11.3.3 | Testing Plastic Piping | 606 |
| 11.3.3.1 | Quality Assurance for Plastic Piping | 606 |
| 11.3.3.2 | Testing Hydrostatic Rupture Strength for Plastic Pipes | 608 |
| 11.3.4 | Testing Plastics Components for Application in Vehicle Design | 611 |
| 11.3.4.1 | Test Requirements | 611 |
| 11.3.4.2 | Mechanical Tests | 611 |
| 11.3.4.3 | Permeation and Emission Tests | 613 |
| 11.3.5 | Testing Plastics Components for Application in Building Construction | 616 |
| 11.3.5.1 | Introduction | 616 |
| 11.3.5.2 | Testing Sandwich Panels | 617 |
| 11.3.5.3 | Testing Plastic Casing Pipes | 620 |
| 11.4 | Implant Testing | 624 |
| 11.4.1 | Introduction | 624 |
| 11.4.2 | Push-out Tests for Implants | 626 |
| 11.4.3 | Testing the Application Behavior of Pharyngotracheal Voice Prostheses | 629 |
| 11.4.4 | Determining the Mechanical Properties of Human Cartilage .. | 632 |
| 11.5 | Compilation of Standards | 634 |

| | |
|---|------------|
| 12 Testing of Polymeric Films | 643 |
| 12.1 Basics | 643 |
| 12.2 Determination of Mechanical Properties of Films | 644 |
| 12.2.1 Tensile Test | 644 |
| 12.2.2 Tear Test | 647 |
| 12.2.3 Impact Behavior | 648 |
| 12.2.3.1 Tensile-Impact Test | 648 |
| 12.2.3.2 Dynamic Tear Testing | 651 |
| 12.2.3.3 Puncture Tests | 653 |
| 12.3 Characterization of Separation Behavior | 657 |
| 12.3.1 Peel Tests | 657 |
| 12.3.2 Cling Test | 666 |
| 12.4 Fracture Mechanics Characterization | 668 |
| 12.5 Characterization of Film Surfaces | 672 |
| 12.6 Compilation of Standards and Guidelines | 675 |
| | |
| 13 Testing of Microcomponents | 679 |
| 13.1 Introduction | 679 |
| 13.2 Microspecimen Testing | 682 |
| 13.2.1 Micro-Tensile Tests | 682 |
| 13.2.2 Fracture Mechanics Investigations Using Mini Compact Tension (CT) Specimens | 687 |
| 13.3 Nanoindentation Testing | 689 |
| 13.4 Testing Methods on Their Way to the Nanoworld | 691 |
| 13.4.1 Non-Contacting Displacement Field Analysis Using Digital Image Correlation (Gray-Value Correlation Analysis) .. | 691 |
| 13.4.2 In-Situ Deformation Measurement with Atomic Force Microscopy (AFM) | 693 |
| | |
| Index | 701 |