



Designation: D 883 – 9900

An American National Standard

Standard Terminology Relating to Plastics¹

This standard is issued under the fixed designation D 883; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

1.1 This terminology covers definitions of technical terms used in the plastics industry. Terms that are generally understood or adequately defined in other readily available sources are not included.

1.2 When a term is used in an ASTM document for which Committee D-20 is responsible it is included only when judged, after review, by Subcommittee D20.92 to be a generally usable term.

1.3 Definitions that are identical to those published by another standards body are identified with the abbreviation of the name of the organization; for example, IUPAC is the International Union of Pure and Applied Chemistry.

1.4 A definition is a single sentence with additional information included in discussion notes. It is reviewed every 5 years; the year of last review is appended.

1.5 For literature related to plastics terminology, see Appendix X1.

2. Referenced Documents

2.1 *ASTM Standards:*

C 162 Terminology of Glass and Glass Products²

¹ This terminology is under the jurisdiction of ASTM Committee D-20 on Plastics and is the direct responsibility of Subcommittee D20.92 on Terminology. Current edition approved ~~Nov. Aug. 10, 1999; 2000.~~ Published ~~January~~ October 2000. Originally published as D 883 – 46. Last previous edition D 883 – 989.

***A Summary of Changes section appears at the end of this standard.**

- D 638M Test Method for Tensile Properties of Plastics—[Metric]³
- D 747 Test Method for Apparent Bending Modulus of Plastics by Means of a Cantilever Beam³
- D 790 Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials³
- D 882 Test Methods for Tensile Properties of Thin Plastic Sheet³
- D 907 Terminology of Adhesives⁴
- D 1003 Test Method for Haze and Luminous Transmittance of Transparent Plastics³
- D 1566 Terminology Relating to Rubber⁵
- ~~D 1928 Practice 4703 Practice for Preparation of Compression-Molded Polyethylene~~ Compression Molding Thermoplastic Materials into Test Specimens, Plaques, or Sheets and Test Specimens³⁶
- E 308 Practice for Computing the Colors of Objects by Using the CIE System⁷

3. Terminology

3.1 Definitions:

A-stage, *n*—an early stage in the preparation of certain thermosetting resins in which the material is still soluble in certain liquids, and may be liquid or capable of becoming liquid upon heating.

DISCUSSION—Sometimes referred to as Resol. (See also **B-stage** and **C-stage**.) (1978)⁸

acetal plastics, *n*—plastics based on polymers having a predominance of acetal linkages in the main chain. (See also **polyoxymethylene**.) (1985)

acrylic plastics—plastics based on polymers made with acrylic acid or a structural derivative of acrylic acid. (1982)

addition polymerization—polymerization in which monomers are linked together without the splitting off of water or other simple molecules. (1983)

adiabatic extrusion—a method of extrusion in which, after the extrusion apparatus has been heated sufficiently by conventional means to plastify the material, the extrusion process can be continued with the sole source of heat being the conversion of the drive energy, through viscous resistance of the plastic mass in the extruder. (1978)

aging, *n*—(1) the effect on materials of exposure to an environment for an interval of time. (2) the process of exposing materials to an environment for an interval of time. (1973)

alkyd plastics—plastics based on alkyd resins. (1980)

alkyd resin—a polyester convertible into a crosslinked form; requiring a reactant of functionality higher than two, or having double bonds. (1982)

alloy, *n* (in plastics)—two or more immiscible polymers united, usually by another component, to form a plastic resin having enhanced performance properties.

allyl plastics—plastics based on allyl resins. (1978)

allyl resin—a resin made by polymerization of chemical compounds containing the allyl group. (1978)

amino plastics, *n*— plastics based on amino resins. (1978)

amino resin, *n*— a resin made by polycondensation of a compound containing amino groups, such as urea or melamine, with an aldehyde, such as formaldehyde, or an aldehyde-yielding material. (1985)

apparent density—See **density, apparent**.

aromatic polyester, *n*—a polyester derived from monomers in which all the hydroxyl and carboxyl groups are linked directly to aromatic nuclei. (1986)

artificial weathering—exposure to laboratory conditions, which may be cyclic, involving changes in temperature, relative humidity, radiant energy, and any other elements found in the atmosphere in various geographical areas.

DISCUSSION—The laboratory exposure conditions are usually intensified beyond those encountered in actual outdoor exposure in an attempt to achieve an accelerated effect. (1980)

average injection velocity, *n*—the mean value of the velocity of the molten plastic flow front within a cavity during the injection time that is calculated from the shot volume and injection time.

DISCUSSION—The average injection velocity is calculated as follows:

² Annual Book of ASTM Standards, Vol 15.02.

³ Annual Book of ASTM Standards, Vol 08.01.

⁴ Annual Book of ASTM Standards, Vol 15.06.

⁵ Annual Book of ASTM Standards, Vol 09.01.

⁶ Annual Book of ASTM Standards, Vol 06.01, 08.03.

⁷ Date indicates year

⁷ Annual Book of introduction or latest review or revision: ASTM Standards, Vol 06.01.

⁸ These definitions are identical with those appearing in Terminology D 907, which were prepared by ASTM Committee D-14 on Adhesives.

⁸ Date indicates year of introduction or latest review or revision.

$$V_{av} = \frac{V_s}{t_i \times A_c \times n}$$

where:

V_{av}	=	average injection velocity, mm/s,
V_s	=	shot volume, mm ³ ,
t_i	=	injection time, s,
A_c	=	cross section of the cavity, mm ² , and
n	=	number of cavities.

This calculation is valid for molds containing a single cavity or those containing identical multi-specimen cavities only and not for family molds.

B-stage, n —an intermediate stage in the reaction of certain thermosetting resins in which the material swells when in contact with certain liquids and softens when heated, but may not entirely dissolve or fuse.

DISCUSSION—The resin in an uncured thermosetting molding compound is usually, in this stage, sometimes referred to as Resitol. (See also **A-stage** and **C-stage**.) (1978)

bag modeling—a method of molding or laminating which involves the application of fluid pressure, usually by means of air, steam, water or vacuum, to a flexible barrier material which transmits the pressure to the material being molded or bonded.

DISCUSSION—The process is usually employed for forming shapes from preformed laminates comprising a fibrous sheet impregnated with an A-stage or a B-stage thermosetting resin. (1986)

binder, n —in a reinforced plastic, the continuous phase which holds together the reinforcement.

DISCUSSION—During fabrication, the binder, which may be either thermoplastic or thermoset, usually undergoes a change in state. (1978)

biodegradable plastic, n — See **degradable plastic**.

blister, n —an imperfection, a rounded elevation of the surface of a plastic, with boundaries that may be more or less sharply defined, somewhat resembling in shape a blister on the human skin. (1983)

block copolymer—an essentially linear copolymer in which there are repeated sequences of polymeric segments of different chemical structure. (1982)

blocking, n —unintentional adhesion between plastic films or between a film and another surface. (1983)

bloom, n —a visible exudation or efflorescence on the surface of a material. (1972)

blowing agent—a compounding ingredient used to produce gas by chemical or thermal action, or both, in manufacture of hollow or cellular articles. (1983)

blow molding—a method of fabrication in which a heated parison is forced into the shape of a mold cavity by internal gas pressure. (1985)

branched polyethylene plastics, n —those containing significant amounts of both short-chain and long-chain branching and having densities in the 0.910 to 0.940 g/cm³ range.

DISCUSSION—These plastics, usually produced commercially by free radical polymerization, are subcategorized by density level; low density polyethylene plastic and medium density polyethylene plastic.

bulk density, n — the weight per unit volume of a loosely packed material, such as a molding powder or pellets.

DISCUSSION—This term should not be used synonymously with apparent density.

bulk factor, n — the ratio of the volume of a given mass of molding material to its volume in the molded form.

DISCUSSION—The bulk factor is also equal to the ratio of the density of the material to its apparent density in the unmolded form. (ISO) (1982)

bulk molding compound (BMC), n —a putty-like mixture of any thermosetting resin containing fillers, fiber reinforcements, catalysts and thickening agents, or thermoplastic polymers, often extruded into logs or ropes.

DISCUSSION—BMC is suitable for molding by any one of three matched-metal-mold processes—compression molding, transfer molding, or injection molding. (1983)

butylene plastics—plastics based on resins made by the polymerization of butene or copolymerization of butene with one or more unsaturated compounds, the butene being in greatest amount by weight. (1975)

C-stage, n —the final stage in the reaction of certain thermosetting materials in which they have become practically insoluble and infusible.

DISCUSSION—The resin in a fully cured thermoset molding is, in this stage, sometimes referred to as Resite. (See also **A-stage** and **B-stage**.) (1986)

cast film—a film made by depositing a layer of plastic, either molten, in solution, or in a dispersion, onto a surface, solidifying and removing the film from the surface. (1982)

cavity, n —in specimen preparation, the part of the hollow space of a mold that forms one specimen.

cell, *n*—a small cavity surrounded partially or completely by walls. (1983)

cell, closed—a cell totally enclosed by its walls and hence not interconnecting with other cells. (ISO) (See **cell** and **cell, open**.) (1983)

cell, open—a cell not totally enclosed by its walls and hence interconnecting with other cells. (See **cell** and **cell, closed**.) (1983)

cellular plastic—a plastic containing numerous cells, intentionally introduced, interconnecting or not, distributed throughout the mass. (See also **syntactic cellular plastics**.) (1983)

cellular striation, *n*—a condition characterized by a layer within a cellular material that differs greatly from the characteristic cell structure.

cellulosic plastics, *n*—plastics based on cellulose compounds, such as esters (cellulose acetate) and ethers (ethyl cellulose). (1985)

chalking, *n*—(plastics) a powdery residue on the surface of a material resulting from degradation or migration of an ingredient, or both.

DISCUSSION—Chalking may be designed-in characteristic. (1980)

chemically foamed polymeric material—a cellular material in which the cells are formed by gases generated from thermal decomposition or other chemical reaction. (1982)

chlorinated poly(vinyl chloride)—a poly(vinyl chloride) (PVC) polymer modified by additional chlorination. (2000)

chlorinated poly(vinyl chloride) plastics—plastics based on chlorinated poly(vinyl chloride) in which the chlorinated poly(vinyl chloride) is in the greatest amount by weight. (1978)

chlorofluorocarbon plastics—plastics based on polymers made with monomers composed of chlorine, fluorine, and carbon only. (ISO) (1983)

chlorofluorohydrocarbon plastics, *n*—plastics based on polymers made with monomers composed of chlorine, fluorine, hydrogen, and carbon only. (ISO) (1982)

circuit—in filament winding, the winding produced by a single revolution of mandrel or form. (1978)

closed-cell cellular plastics—cellular plastics in which almost all the cells are noninterconnecting. (1983)

cold flow—See **creep**. (1983)

cold molding—a special process of compression molding in which the molding is formed at room temperature and subsequently baked at elevated temperatures. (1982)

collapse, *n*—inadvertent densification of cellular material during manufacture resulting from breakdown of cell structure. (1982)

composite, *n*—a solid product consisting of two or more distinct phases, including a binding material (matrix) and a particulate or fibrous material.

DISCUSSION—Examples are moulding material containing reinforcing fibers, particulate fillers, or hollow spheres. (1991)

compost—the product of composting.

compostable plastic—a plastic that undergoes biological degradation during composting to yield carbon dioxide, water, inorganic compounds, and biomass at a rate consistent with other known compostable materials and leaves no visually distinguishable or toxic residues. (1996)

compound, *n*—an intimate admixture of (a) polymer(s) with all the materials necessary for the finished product. (1983)

compression molding—the method of molding a material already in a confined cavity by applying pressure and usually heat. (1986)

condensation polymer—a polymer made by condensation polymerization. (1983)

condensation polymerization—polymerization in which monomers are linked together with the splitting off of water or other simple molecules. (1983)

contact pressure molding, *n*—a method of molding or laminating in which the pressure, usually less than 70 kPa (10 psi), is only slightly more than necessary to hold the materials together during the molding operation. (1985)

cooling time, *n*—in molding, the time interval from the start of forward screw movement until the mold starts to open.

copolymer—See **polymer**. (1983)

copolymerization—See **polymerization**. (1983)

crater, *n*—a small, shallow surface imperfection. (1978)

crazing, *n*—apparent fine cracks at or under the surface of a plastic.

DISCUSSION—The crazed areas are composed of polymeric material of lower density than the surrounding matrix. (1978)

creep, *n*—the time-dependent part of strain resulting from stress. (1983)

cross laminate—a laminate in which some of the layers of material are oriented approximately at right angles to the remaining layers with respect to the grain or strongest direction in tension. (See also **parallel laminate**.) (1982)

crosslinking, *n*—the formation of a three dimensional polymer by means of interchain reactions resulting in changes in physical properties. (1983)

cross section of the cavity, *n*—in a mold for test specimens, the area of a planar section perpendicular to the flow pattern during filling of the mold that forms the critical portion of the test specimen.

cure, *v*—to change the properties of a polymeric system into a more stable, usable condition by the use of heat, radiation, or reaction with chemical additives.

DISCUSSION—Cure may be accomplished, for example, by removal of solvent or by crosslinking. (ISO) (1983)

cure cycle—the schedule of time periods, at specified conditions, to which a reacting thermosetting material is subjected to reach a specified property level. (1983)

cure time—the period of time that a reacting thermosetting material is exposed to specific conditions to reach a specified property level. (1983)

cut-layers—as applied to laminated plastics, a condition of the surface of machined or ground rods and tubes and of sanded sheets in which cut edges of the surface layer or lower laminations are revealed. (1978)

cycle time, *n*— in molding, the total time used to carry out a complete sequence of operations making up the molding cycle.

degradable plastic, *n*—a plastic designed to undergo a significant change in its chemical structure under specific environmental conditions resulting in a loss of some properties that may vary as measured by standard test methods appropriate to the plastic and the application in a period of time that determines its classification. (1991)

biodegradable plastic, *n*—a degradable plastic in which the degradation results from the action of naturally-occurring micro-organisms such as bacteria, fungi, and algae.

DISCUSSION—The level of biodegradability may be indicated as shown in subordinate definitions for biodegradable plastics. (1991)

hydrolytically degradable plastic, *n*—a degradable plastic in which the degradation results from hydrolysis.

DISCUSSION—The level of hydrolytic degradability may be indicated as shown in subordinate definitions for hydrolytically degradable plastic. (1991)

oxidatively degradable plastic, *n*—a degradable plastic in which the degradation results from oxidation.

DISCUSSION—The level of oxidative degradability may be indicated as shown in subordinate definitions for oxidatively degradable plastic. (1991)

photodegradable plastic, *n*—a degradable plastic in which the degradation results from the action of natural daylight.

DISCUSSION—The level of photodegradability may be indicated as shown in subordinate definitions for photodegradable plastic. (1991)

degradation, *n*— a deleterious change in the chemical structure, physical properties, or appearance of a plastic. (1980)

delamination, *n*— the separation of the layers of material in a laminate. (1978)

density, apparent—the weight in air of a unit volume of a material.

DISCUSSION—This term is sometimes used synonymously with bulk density. (1973)

density, bulk—the weight per unit volume of a material including voids inherent in material as tested.

DISCUSSION—This term is commonly used for material such as molding powder. (1973)

depth, *n*—in the case of a beam, the dimension parallel to the direction in which the load is applied. (1978)

dome, *n*—in reinforced plastics, an end of a filament-wound cylindrical container. (1985)

dry-blend, *n*— a dry compound prepared without fluxing or addition of solvent (also called powder blend). (1983)

dry-spot, *n*—an imperfection in reinforced plastics, an area of incomplete surface film where the reinforcement has not been wetted with resin. (1983)

durometer, *n*— an instrument for measuring indentation hardness.

elastomer, *n*— a macromolecular material that at room temperature returns rapidly to approximately its initial dimensions and shape after substantial deformation by a weak stress and release of the stress. (1985)

engineered plastic, *n*—a material that has been made by specific design and through use of particular monomers and monomer sequences to produce a plastic with desired properties, possibly for a specific application. (1991)

engineering plastics, *n*—those plastics and polymeric compositions for which well-defined properties are available such that engineering rather than empirical methods can be used for the design and manufacture of products that require definite and predictable performance in structural applications over a substantial temperature range.

epoxy plastics, *n*— thermoplastic or thermosetting plastics containing ether or hydroxyalkyl repeating units, or both, resulting from the ring-opening reactions of lower molecular weight polyfunctional oxirane resins, or compounds, with catalysts or with various polyfunctional acidic or basic coreactants.

DISCUSSION—Epoxy plastics often are modified by the incorporation of diluents, plasticizers, fillers, thixotropic agents, or other materials. (1985)

ethylene plastics, *n*—plastics based on polymers of ethylene or copolymers of ethylene with other monomers, the ethylene being in greatest amount by mass. (ISO) (1982)

expandable plastic, *n*—a plastic in a form capable of being made cellular by thermal, chemical, or mechanical means. (1985)

expanded plastics— See **cellular plastic**. (1985)

extrusion, *n*— a process in which heated or unheated plastic is forced through a shaping orifice (a die) in one continuously formed shape, as in film, sheet, rod, or tubing. (1983)

fabricating, *n*— the manufacture of plastic products from molded parts, rods, tubes, sheeting, extrusions, or other forms by appropriate operations such as punching, cutting, drilling, and tapping including fastening plastic parts together or to other parts by mechanical devices, adhesives, heat sealing, or other means. (1978)

fiber show, *n*— strands or bundles of fibers not covered by resin which are at or above the surface of a reinforced plastic. (1985)

filler, *n*—a relatively inert material added to a plastic to modify its strength, permanence, working properties, or other qualities, or to lower costs. (See also **reinforced plastic**.) (1978)

film, *n*—in plastics, an optional term for sheeting having a nominal thickness not greater than 0.25 mm (0.01 in.). (1985)

fish-eye, *n*—small globular mass that has not blended completely into the surrounding material. See **gel**. (1978)

fluorocarbon plastic, *n*—a plastic based on polymers made with perfluoromonomers.

DISCUSSION—When the monomer is essentially tetrafluoroethylene, the prefix TFE is sometimes used to designate these materials. It is preferable to use the accepted abbreviation, PTFE. TFE should not be used by itself to mean PTFE. When the resins are copolymers of tetrafluoroethylene and hexafluoropropylene, the resins may be designated with the prefix FEP. Other prefixes may be adopted to designate other fluorocarbon plastics. (ISO) (1983)

fluorohydrocarbon plastics, *n*—plastics based on polymers made with monomers composed of fluorine, hydrogen, and carbon only. (ISO) (1982)

fluoroplastic, *n*— a plastic based on polymers made from monomers containing one or more atoms of fluorine, or copolymers of such monomers with other monomers, the fluorine-containing monomer(s) being in greatest amount by mass.

DISCUSSION—For specific examples of fluoroplastic see **fluorocarbon plastic**, **chlorofluorocarbon plastics**, **fluorohydrocarbon plastics**, and **chlorofluorohydrocarbon plastics**. (1983)

foamed plastics, *n*— See **cellular plastics** (the preferred terminology). (1983)

forming, *n*—a process in which the shape of plastic pieces such as sheets, rods, or tubes is changed to a desired configuration.

DISCUSSION—The use of the term “forming” in plastics technology does not include such operations as molding, casting, or extrusion, in which shapes or pieces are made from molding materials or liquids. (1982)

furan plastics—plastics based on furan resins. (ISO) (1982)

furan resin, *n*— a resin in which the furan ring is an integral part of the polymer chain and represents the greatest amount by mass. (ISO) (1983)

gate, *n*—in an injection mold, a constriction in the flow channel between the runner and the mold cavity. (1983)

gel, *n*—(1) a semisolid system consisting of a network of solid aggregates in which liquid is held.

(2) the initial jelly-like solid phase that develops during the formation of a resin from a liquid.

(3) with respect to vinyl plastisols, gel is a state between liquid and solid that occurs in the initial states of heating, or upon prolonged storage.

DISCUSSION—All three types of gels have very low strengths and do not flow like a liquid. They are soft, flexible, and may rupture under their own weight unless supported externally. (1978)

(4) in plastic film and sheet, a nodule of plastic material composed of one or more of oxidized, high-molecular-weight, unmelted, non-solvated, or cross-linked material of the same composition as the matrix that, for a variety of reasons, has not blended with the matrix. See **fish-eye**.

DISCUSSION—Gel in the film or sheet is to be distinguished from contamination such as particles of dirt, carbon, or lint. (1992)

gel point, *n*— the stage at which a liquid begins to exhibit pseudo-elastic properties.

DISCUSSION—This stage may be detected as the inflection point on a viscosity-time plot. (See **gel** (2).) (1985)

gel time, *n*—the period of time from the initial mixing of the reactants of a liquid material composition to the time when gelation occurs, as defined by a specific test method.

DISCUSSION—For a material that must be processed by exposure to some form of energy, the zero time is the start of exposure. (1983)

glass, *n*—an inorganic product of fusion which has cooled to a rigid condition without crystallizing.

DISCUSSION—Term not defined by Committee D-20. Definition approved by Committee C-14 on Glass and Glass Products. See Terminology C 162.

(a) Glass is typically hard and brittle and has a conchoidal fracture. It may be colorless or colored, and transparent to opaque. Masses or bodies of glass may be made colored, translucent, or opaque by the presence of dissolved, amorphous, or crystalline material.

(b) When a specific kind of glass is indicated, such descriptive terms as flint glass, barium glass, and window glass should be used following the basic definition, but the qualifying term is to be used as understood by trade custom.

(c) Objects made of glass are loosely and popularly referred to as glass; such as glass for a tumbler, a barometer, a window, a magnifier or a mirror. (1978)

glass finish—a material applied to the surface of glass fibers used to reinforce plastics and intended to improve the physical properties of such reinforced plastics over that obtained using glass reinforcement without finish. (1982)

glass transition—the reversible change in an amorphous polymer or in amorphous regions of a partially crystalline polymer from (or to) a viscous or rubbery condition to (or from) a hard and relatively brittle one.

DISCUSSION—The glass transition generally occurs over a relatively narrow temperature region and is similar to the solidification of a liquid to a

glassy state; it is not a phase transition. Not only do hardness and brittleness undergo rapid changes in this temperature region but other properties, such as thermal expansibility and specific heat also change rapidly. This phenomenon has been called second order transition, rubber transition and rubbery transition. The word transformation has also been used instead of transition. Where more than one amorphous transition occurs in a polymer, the one associated with segmental motions of the polymer backbone chain or accompanied by the largest change in properties is usually considered to be the glass transition. (1980)

glass transition temperature (T_g)—the approximate midpoint of the temperature range over which the glass transition takes place.

DISCUSSION—The glass transition temperature can be determined readily only by observing the temperature at which a significant change takes place in a specific electrical, mechanical, or other physical property. Moreover, the observed temperature can vary significantly depending on the specific property chosen for observation and on details of the experimental technique (for example, rate of heating, frequency). Therefore, the observed T_g should be considered only an estimate. The most reliable estimates are normally obtained from the loss peak observed in dynamic mechanical tests or from dilatometric data. (1978)

graft copolymer—a copolymer in which polymeric side chains have been attached to the main chain of a polymer of different structure. (1973)

gusset, *n*—(1) a piece used to give additional size or strength in a particular location of an object.

(2) the folded-in portion of flattened tubular film. (1972)

halocarbon plastics—plastics based on resins made by the polymerization of monomers composed only of carbon and a halogen or halogens. (1978)

haze—the cloudy or turbid aspect or appearance of an otherwise transparent specimen caused by light scattered from within the specimen or from its surfaces.

DISCUSSION—For the purpose of Test Method D 1003, haze is the percentage of transmitted light which, in passing through the specimen, deviates from the incident beam through forward scatter more than 2.5 deg on the average. (1983)

heat mark—extremely shallow depression or groove in the surface of a plastic visible because of a sharply defined rim or a roughened surface. (See also **shrink mark.**) (1978)

high density polyethylene plastics, (HDPE) *n*—those linear polyethylene plastics, g. v., having a standard density of 0.941 g/cm³ or greater.

DISCUSSION—These plastics are usually produced commercially by processes not employing free radical polymerization. Standard density refers to the density of the material molded to a thickness of 1.9 mm (0.075 in.) using the procedures of Method Procedure C in ASTM of Annex A1 of Practice D 4928–D 4703.

high-pressure molding, *n*—a method of molding or laminating in which the pressure used is greater than 1400 kPa (200 psi). (1985)

hold pressure, *n*— in molding, the melt pressure during the hold time interval in injection molding.

homopolymer, *n*— a polymer resulting from polymerization involving a single monomer. (1983)

hydrocarbon plastics—plastics based on resins made by the polymerization of monomers composed of carbon and hydrogen only. (1985)

hydrolytically degradable plastics, *n*—See **degradable plastic.**

inhibitor, *n*— a substance used in low concentration which suppresses a chemical reaction.

DISCUSSION—Inhibitors, unlike catalysts, are consumed during the reaction. (1983)

injection molding, *n*—the process of forming a material by forcing it, in a fluid state and under pressure, through a runner system (sprue, runner, gate(s)) into the cavity of a closed mold.

DISCUSSION—Screw injection molding and reaction injection molding are types of injection molding. (1983)

injection time, *n*— the time interval from the beginning of screw forward movement until switching over to hold pressure. (1995)

insert, *n*—a part consisting of metal or other material which may be molded into position or may be pressed into the molding after the completion of the molding operation. (ISO) (1978)

isotactic, *adj*— pertaining to a type of polymeric molecular structure containing a sequence of regularly spaced asymmetric atoms arranged in like configuration in a polymer chain. (1985)

knit-line, *n*—See **weld-line** (the preferred terminology). (1983)

knuckle area—in reinforced plastics, the area of transition between sections of different geometry in a filament-wound part. (1985)

laminat⁹e, *n*—a product made by bonding together two or more layers of material or materials. (See also **cross laminate** and **parallel laminate.**) (ISO)

DISCUSSION—A single resin-impregnated sheet of paper, fabric, or glass mat, for example, is not considered a laminate. Such a single-sheet construction may be called a “lamina.” (See also **reinforced plastic.**) (1983)

⁹ These definitions are identical with those appearing in Terminology D 907, which were prepared by ASTM Committee D14 on Adhesives.

lattice pattern—in reinforced plastics, a pattern of filament winding with a fixed arrangement of open voids. (1985)

lay, *n*—(1) the length of twist produced by stranding filaments, such as fibers, wires, or roving; (2) the angle that such filaments make with the axis of the strand during a stranding operation.

DISCUSSION—Length of twist of a filament is usually measured as the distance parallel to the axis of the strand between successive turns of the filament. (1985)

lay up, *n*—in reinforced plastics, an assembly of layers of resin-impregnated material ready for processing. (1982)

lay up, *v*—in reinforced plastics, to assemble layers of resin-impregnated material for processing. (1985)

let-go, *n*—an area in laminated glass over which an initial adhesion between interlayer and glass has been lost. (1985)

lignin plastics—plastics based on lignin resins. (ISO) (1983)

lignin resin—a resin made by heating lignin or by reaction of lignin with chemicals or resins, the lignin being in greatest amount by mass. (ISO) (1983)

linear low density polyethylene plastics, (LLDPE) *n*—those linear polyethylene plastics, q.v., having a standard density of 0.919 to 0.925 g/cm³.

DISCUSSION—These plastics are usually produced commercially by processes not employing free radical polymerization. Standard density refers to the density of the material molded to a thickness of 1.9 mm (0.075 in.) using the procedures of Method Procedure C in ASTM of Annex A1 of Practice D 1928. D 4703.

linear medium density polyethylene plastics, (LMDPE) *n*—those linear polyethylene plastics, q. v., having a standard density of 0.926 to 0.940 g/cm³.

DISCUSSION—These plastics are usually produced commercially by processes not employing free radical polymerization. Standard density refers to the density of the material molded to a thickness of 1.9 mm (0.075 in.) using the procedures of Method Procedure C in ASTM of Annex A1 of Practice D 1928. D 4703.

linear polyethylene plastics, *n*—those containing insignificant amounts of long-chain branching but which may contain significant amounts, by design, of short-chain branching.

DISCUSSION—These plastics, usually produced commercially by processes not employing free radical polymerization, are subcategorized by density level; linear low density polyethylene plastic, linear medium density polyethylene plastic, and high density polyethylene plastic. For differentiation among high molecular versions of these plastics produced commercially by stereo-specific catalysts, see extra-high molecular weight polyethylene plastic and ultra-high molecular weight polyethylene plastic.

low density polyethylene plastics, (LDPE) *n*—those branched polyethylene plastics, q. v., having a standard density of 0.910 to 0.925 g/cm³.

DISCUSSION—These plastics are usually produced commercially by processes employing free radical polymerization. Standard density refers to the density of the material molded to a thickness of 1.9 mm (0.075 in.) using the procedures of Method Procedure C in ASTM of Annex A1 of Practice D 1928. D 4703.

low-pressure molding, *n*—a method of molding or laminating in which the pressure is 1400 kPa (200 psi) or less. (1985)

lubricant bloom—See **bloom**. (1982)

luminous transmittance, *n*—the ratio of the luminous flux transmitted by a body to the flux incident upon it.

DISCUSSION—Parallel definitions apply to spectral and radiant transmittance. See Test Method E 308 for a detailed discussion of terminology. (1982)

mat, *n*—a fibrous material consisting of randomly oriented chopped or swirled filaments loosely held together with a binder. (1982)

mechanically foamed plastic, *n*—a cellular plastic in which the cells are formed by the physical incorporation of gases. (1985)

medium density polyethylene plastics, (MDPE) *n*—those branched polyethylene plastics, q. v., having a standard density of 0.926 to 0.940 g/cm³.

DISCUSSION—These plastics are usually produced commercially by processes employing free radical polymerization. Standard density refers to the density of the material molded to a thickness of 1.9 mm (0.075 in.) using the procedures of Method Procedure C in ASTM of Annex A1 of Practice D 1928. D 4703.

melamine plastics, *n*—plastics based on resins made by the condensation of melamine and aldehydes. (1985)

melt pressure, *n*—the pressure applied to the plastic material in front of the screw driving the injection molding process on a reciprocating screw machine that is calculated based on the hydraulic force acting axially on the screw.

DISCUSSION—Melt pressure is calculated as follows:

$$P = \frac{4 \times 10^{-3} \times F_s}{\pi \times D^2}$$

where:

P = melt pressure, MPa,

F_s = hydraulic axial force, kN, and
 D = screw diameter, mm. (1995)

melt temperature, n —the temperature of the molten plastic. (1995)

mold open time, n — the time interval from the instant the mold begins to open until it is closed again. (1995)

mold temperature, n —the mean temperature of the mold cavity surface measured after the system has obtained thermal equilibrium and immediately after opening the mold. (1995)

molding, bag—See **bag molding**. (1985)

molding, blow—See **blow molding**. (1985)

molding, compression— See **compression molding**. (1985)

molding, contact pressure, n —See **contact pressure molding**. (1985)

molding, high-pressure, n — See **high-pressure molding**. (1985)

molding, injection— See **injection molding**. (1985)

molding, low-pressure, n — See **low-pressure molding**. (1985)

molding, transfer— See **transfer molding**. (1985)

molding pressure, compression—the calculated fluid pressure applied to the material in the mold. (1985)

molding pressure, injection—the pressure applied to the cross-sectional area of the material cylinder. (1982)

molding pressure, transfer—the pressure applied to the cross-sectional area of the material pot or cylinder. (1982)

monomer, n —a low-molecular-weight substance consisting of molecules capable of reacting with like or unlike molecules to form a polymer. (1983)

necking, n —the localized reduction in cross-section which may occur in a material under tensile stress. (1982)

nonrigid plastic, n —for purposes of general classification, a plastic that has a modulus of elasticity either in flexure or in tension of not over 70 MPa (10 000 psi) at 23°C and 50 % relative humidity when tested in accordance with Test Methods D 790, Test Method D 747, Test Method D 638, or Test Methods D 882. (1983)

novolac (or novolak), n —a phenolic-aldehyde resin which, unless a source of methylene groups is added, remains permanently thermoplastic. (See also **resinoid** and **thermoplastic**.) (1977)

nylon plastics, n — plastics based on resins composed principally of a long-chain synthetic polymeric amide which has recurring amide groups as an integral part of the main polymer chain. (1985)

olefin plastics—plastics based on polymers made by the polymerization of olefins or copolymerization of olefins with other monomers, the olefins being at least 50 mass %. (1983)

oligomer, n —a substance composed of only a few nonomeric units repetitively linked to each other, such as a dimer, trimer, tetramer, etc., or their mixtures.

DISCUSSION—The physical properties of an oligomer vary with the addition or removal of one or a few constitutional units from its molecules. (1983)

oligomerization, n —the process of converting a monomer or mixture of monomers into a oligomer. (1983)

open-cell cellular plastic, n —a cellular plastic in which there is a predominance of interconnected cells. (1985)

organosol, n — a suspension of a finely divided polymer in a plasticizer, together with a volatile organic liquid.

DISCUSSION—The volatile liquid evaporates at elevated temperatures, and the resulting residue is a homogeneous polymeric mass, provided the temperature is high enough to accomplish mutual solution of the polymer and plasticizer. (1985)

oxidatively degradable plastic, n —See **degradable plastic**.

parallel laminate—a laminate in which all the layers of material are oriented approximately parallel with respect to the grain or strongest direction in tension. (See also **cross laminate**) (1985)

parison, n —the shaped plastic mass, generally in the form of a tube, used in blow molding. (ISO) (1983)

phenolic plastics, n —plastics based on resins made by the condensation of phenols, such as phenol or cresol, with aldehydes. (1985)

phenolic resin compound, single-stage— a phenolic material in which the resin, because of its reactive groups, is capable of further polymerization by application of heat. (See also **phenolic resin compound, two-stage**). (1978)

phenolic resin compound, two-stage—a phenolic material in which the resin is essentially not reactive at normal storage temperatures, but contains a reactive additive which causes further polymerization upon the application of heat. (1978)

photodegradable plastic, n —See **degradable plastic**.

pimple, n —an imperfection, a small, protuberance of varied shape on the surface of a plastic product. (1983)

pit, n —an imperfection, a small crater in the surface of the plastic, with its width of approximately the same order of magnitude as its depth. (1983)

plastic(s), n — a material that contains as an essential ingredient one or more organic polymeric substances of large molecular weight, is solid in its finished state, and, at some stage in its manufacture or processing into finished articles, can be shaped by flow.

DISCUSSION—Rubber, textiles, adhesives, and paint, which may in some cases meet this definition, are not considered plastics. See ASTM definitions of these terms.

DISCUSSION—The above definition may be used as a separate meaning from the definitions contained in the dictionary for the adjective “plastic.”

DISCUSSION—The plural form may be used as an adjective to refer to two or more plastic materials, for example, plastics industry. However, when the intent is to distinguish “plastic products” from “wood products” or “glass products,” the singular form should be used. As a general rule, if the adjective is to restrict the noun modified with respect to the type of material, “plastic” should be used; if the adjective is to indicate that more than one type of plastic material is or may be involved, “plastics” is permissible. (1982)

plastic foam, n—See **cellular plastic** (the preferred terminology). (1983)

plasticizer, n— a substance incorporated in a material to increase its workability, flexibility, or distensibility. (1983)

plastic pipe—a hollow cylinder of a plastic material in which the wall thicknesses are usually small when compared to the diameter and in which the inside and outside walls are essentially concentric. (1982)

plastic tubing, n— (1) a particular size of plastic pipe in which the outside diameter is essentially the same as the corresponding size of copper tubing.

(2) small diameter flexible pipe. (See **plastic pipe**.) (1982)

plastisol, n— a liquid suspension of a finely divided PVC polymer or copolymer in a plasticizer.

DISCUSSION—The polymer does not dissolve appreciably in the plasticizer at room temperature, but does at elevated temperatures, to form a homogeneous plastic mass (plasticized polymer). (1985)

plate-mark—any imperfection in a pressed plastic sheet resulting from the surface of the pressing plate. (1982)

polepiece, n— in reinforced plastics, the supporting part of the mandrel used in filament winding, usually on one of the axes of rotation. (1985)

polyaddition—See **addition polymerization**. (1982)

polyamide plastics— See **nylon plastics**. (1982)

polyarylate, n—See **aromatic polyester**. (1986)

polyaryletherketone, n—a polymer in which aryl groups are connected by one or more ether as well as one or more Ketone linkages. (1991)

polybutylene, n— a polymer prepared by the polymerization of butene as the sole monomer. (See **polybutylene plastics** and **butylene plastics**.) (1985)

polybutylene plastics, n—plastics based on polymers made with butene as essentially the sole monomer. (1985)

polycarbonate, n— a polyester polymer in which the repeating structural unit in the chain is of the carbonate type. (1983)

polycarbonate plastics—polyester plastics based on polymers in which the repeating structural units in the chains are essentially all of the carbonate type. (1983)

polycondensation—See **condensation polymerization**. (1982)

polydicyclopentadiene plastic, n—a crosslinked thermoset polymer formed by the ring-opening metathesis polymerization of dicyclopentadiene.

polyester, n— a polymer in which the repeated structural unit in the chain is of the ester type. (ISO)

DISCUSSION—The polyester is linear and thermoplastic if derived, either actually or formally, from (a) mono-hydroxy-mono-carboxylic acids by self-esterification, or (b) the interaction of diols and dicarboxylic acids. (1985)

polyester plastics—synonymous with **alkyd plastics**.

polyether, n— a polymer in which the repeated structural unit in the chain is of the ether type. (1985)

polyethylene, n— a polymer prepared by the polymerization of ethylene as the sole monomer. (See **polyethylene plastics** and **ethylene plastics**.) (1982)

polyethylene plastics—plastics based on polymers made with ethylene as essentially the sole monomer.

DISCUSSION—In common usage for this plastic, essentially means no less than 85 percent ethylene and no less than 95 percent total olefins. (1975)

polymer, n—a substance consisting of molecules characterized by the repetition (neglecting ends, branch junctions and other minor irregularities) of one or more types of monomeric units. (IUPAC) (1971)

polymerization—a chemical reaction in which the molecules of monomers are linked together to form polymers. (See also **polycondensation** and **polyaddition**.) (1971)

polymethylmethacrylimide (PMMI), n—a thermoplastic polymer formed from a reaction of poly(methyl methacrylate) and monomethyl amine. (1992)

polyol, n—an alcohol having many hydroxyl groups, also known as a polyhydric alcohol or polyalcohol.

DISCUSSION—In cellular plastics usage, the term includes compounds containing alcoholic hydroxyl groups such as polyethers, glycols, polyesters, and castor oil used in urethane foams. (1983)

polyolefin, n— a polymer prepared by the polymerization of an olefin(s) as the sole monomer(s). (See **polyolefin plastics** and **olefin plastics**.) (1982)

polyolefin plastics, n—plastics based on polymers made with an olefin(s) as essentially the sole monomer(s). (1985)

polyoxymethylene, n—a polymer in which the repeated structural unit in the chain is oxymethylene.

DISCUSSION—Polyoxymethylene is theoretically the simplest member of the generic class of polyacetals. (ISO) (1983)

polyoxymethylene plastics, *n*—acetal plastics based on polymers in which oxymethylene is essentially the sole repeated structural unit in the chains. (ISO) (See also **acetal plastics**.) (1985)

polyphthalamide (PPA), *n*—a polyamide in which residues of terephthalic acid or isophthalic acid or a combination of the two comprise at least 60 molar percentage of the dicarboxylic acid part of the repeating structural units in the polymer chain. (1992)

polypropylene, *n*— a polymer prepared by the polymerization of propylene as the sole monomer. (See **polypropylene plastics** and **propylene plastics**.) (1978)

polypropylene plastics—plastics based on polymers made with propylene as essentially the sole monomer. (1975)

polystyrene, *n*— a polymer prepared by the polymerization of styrene as the sole monomer. (See **styrene plastics**.) (1978)

polyterephthalate, *n*—a thermoplastic polyester in which the terephthalate group is one of the repeating structural unit in the polymer chain. (1985)

polyterephthalate plastics—a thermoplastic polyester in which the terephthalate group is a repeated structural unit in the chain, the terephthalate being in greater amount than other dicarboxylates which may be present. (1985)

polyurethane, *n*— a polymer prepared by the reaction of an organic diisocyanate with compounds containing hydroxyl groups.

DISCUSSION—Polyurethanes or urethanes, as they are sometimes called, may be thermosetting, thermoplastic, rigid or soft and flexible, cellular, or solid. (1983)

poly(vinyl acetate), *n*—a polymer prepared by the polymerization of vinyl acetate as the sole monomer. (1985)

poly(vinyl alcohol)—polymers prepared by the essentially complete hydrolysis of polyvinyl esters. (1978)

poly(vinyl chloride)—a polymer prepared by the polymerization of vinyl chloride as the sole monomer. (1978) monomer (vinyl chloride content in monomer not less than 99 %). (2000)

postforming, *n*— the forming of cured or partially cured thermosetting plastics. (1982)

pot life—the period of time during which a reacting thermosetting composition remains suitable for its intended processing after mixing with reaction-initiating agents. (1973)

powder blend—See **dry-blend**. (1982)

preform, *n*—a coherent, shaped mass of powdered, granular or fibrous plastic molding compound, or of fibrous filler material with or without resin. (ISO) (1982)

premix, *n*—in reinforced thermosetting plastics, the admixture of resin, reinforcements, fillers, etc., not in web or filamentous form, ready for molding. (1982)

prepolymer, *n*— a polymer of degree of polymerization between that of the monomer or monomers and the final polymer. (ISO) (1982)

prepreg, *n*—in reinforced thermosetting plastics, the admixture of resin, reinforcements, fillers, etc., in web or filamentous form, ready for molding. (1982)

pressure-break, *n*— as applied to a defect in a laminated plastic a break apparent in one or more outer sheets of the paper, fabric, or other base visible through the surface layer of resin which covers it. (1982)

propylene plastics, *n*—plastics based on polymers of propylene or copolymers of propylene with other monomers, the propylene being in the greatest amount by mass. (ISO) (1982)

pulled-surface, *n*— as applied to a defect in a laminated plastic imperfections in the surface ranging from a slight breaking or lifting in spots to pronounced separation of its surface from its body. (1982)

recycled plastic, *n*—those plastics composed of post-consumer material or recovered material only, or both, that may or may not have been subject to additional processing steps of the types used to make products such as recycled-regrind or reprocessed or reconstituted plastics. (1991)

regular transmittance—ratio of the light flux transmitted without diffusion to the flux incident. (1985)

reinforced plastic—a plastic with high strength fillers imbedded in the composition, resulting in some mechanical properties superior to those of the base resin. (See also **filler**.)

DISCUSSION—The reinforcing fillers are usually fibers, fabrics, or mats made of fibers. (1973)

reinforced reaction injection molding (RRIM), *n*—the process of using solid reinforcements, such as, glass fiber, mica, or talc in the reaction injection molding process. (1983)

release agent, *n*— a material added to a compound or applied to the mold cavity, or both, to reduce parts sticking to the mold. (1983)

reprocessed plastic—a thermoplastic prepared from usually melt processed scrap or reject parts by a plastics processor, or from non-standard or non-uniform virgin material.

DISCUSSION—Use of the term “scrap” in this definition does not connote that the feed stock is necessarily less desirable or useable than the virgin material from which it may have been generated. Reprocessed plastic may or may not be reformulated by the addition of fillers, plasticizers, stabilizers, pigments, etc. See **reworked plastic** and **recycled plastic**. (1985)

resin, *n*—a solid or pseudosolid organic material often of high molecular weight, which exhibits a tendency to flow when subjected to stress, usually has a softening or melting range, and usually fractures conchoidally.

DISCUSSION—In a broad sense, the term is used to designate any polymer that is a basic material for plastics. (1982)

resin streak, *n*— a streak of excess resin on the surface of a laminated plastic. (1982)

reworked plastic, *n*—a plastic from a processor's own production that has been reground, pelletized, or solvated after having been previously processed by molding, extrusion, etc. See **recycled plastic** and **reprocessed plastic**. (1991)

rigid plastic, *n*— for purposes of general classification, a plastic that has a modulus of elasticity, either in flexure or in tension, greater than 700 MPa (100 000 psi) at 23°C and 50 % relative humidity when tested in accordance with Test Method D 747, Test Methods D 790, Test Method D 638M, or Test Methods D 882. (1983)

rise time, *n*— the time required for a free-rise cellular plastic to achieve its ultimate expansion under controlled conditions. (1983)

rubber, *n*—term not defined by Committee D-20. Definition approved by Committee D-11 on Rubber and Rubber-Like Materials is as follows:

“**rubber**—a material that is capable of recovering from large deformations quickly and forcibly, and can be, or already is, modified to a state in which it is essentially insoluble (but can swell) in boiling solvent, such as benzene, methylethylketone, and ethanol-toluene azeotrope.”

“A rubber in its modified state, free of diluents, retracts within 1 min to less than 1.5 times its original length after being stretched at room temperature (18 to 29°C) to twice its length and held for 1 min before release.”

DISCUSSION—See Terminology D 1566.

runner, *n*—(1) the secondary feed channel in an injection or transfer mold that runs from the inner end of the sprue or pot to the cavity gate.

(2) the piece formed in a secondary feed channel or runner. (1986)

sample, *n*—a small part or portion of a material or product intended to be representative of the whole. (1972)

saran plastics—See **vinylidene chloride plastics**. (1972)

semirigid plastic, *n*—for purposes of general classification, a plastic that has a modulus of elasticity either in flexure or in tension of between 70 and 700 MPa (10 000 and 100 000 psi) at 23°C and 50 % relative humidity when tested in accordance with Test Method D 747, Test Methods D 790, Test Method D 638M, or Test Methods D 882. (1983)

set, *n*—strain remaining after complete release of the force producing the deformation. (1975)

sheet, *n*—an individual piece of sheeting. (See also **film**, **sheeting**.) (1973)

sheeting, *n*—a form of plastic in which the thickness is very small in proportion to length and width and in which the plastic is present as a continuous phase throughout, with or without filler. (See also **film**.) (1972)

sheet molding compound (SMC), *n*—a fiber-reinforced thermosetting compound, in sheet form.

DISCUSSION—The resin is usually a polyester. SMC can be compression molded into complex shapes with little scrap. (1983)

short, *n*—an imperfection in a molded plastic part due to an incompletely filled out condition.

DISCUSSION—In reinforced plastics, this may be evident either through an absence of surface film in some areas, or as lighter unfused particles of material showing through a covering surface film, accompanied possibly by thin-skinned blisters. In thermoplastics, the term short shot is often used to describe this condition. (1983)

shot volume, *n*— the total hollow space of a mold including cavity or cavities, runner(s), and sprue. (1995)

shrink mark—an imperfection, a depression in the surface of a molded material where it has retracted from the mold. (1983)

silicone plastics—plastics based on polymers in which the main polymer chain consists of alternating silicone and oxygen atoms. (1985)

skin, *n*—a relatively dense layer at the surface of a cellular polymeric material. (1985)

specimen, *n*—a piece or portion of a sample used to make a test. (ISO) (1972)

specular transmittance, *n*— See **regular transmittance** (the preferred terminology). (1983)

sprue, *n*—(1) the primary feed channel that runs from the outer face of an injection or transfer mold to the mold gate in a single cavity mold.

(2) the piece formed in a primary feed channel or sprue. (1972)

stress-crack, *n*— an external or internal crack in a plastic caused by tensile stresses less than its short-time mechanical strength.

DISCUSSION—The development of such cracks is frequently accelerated by the environment to which the plastic is exposed. The stresses which cause cracking may be present internally or externally or may be combinations of these stresses. (1972)

styrene plastics, *n*—plastics based on polymers of styrene or copolymers of styrene with other monomers, the styrene being in greatest amount by mass. (ISO) (1972)

styrene-rubber plastics, *n*—plastics based on styrene polymers and rubbers, the styrene polymers being in the greatest amount by mass. (ISO) (1972)

styrenic thermoplastic elastomer (TES), *n*—a copolymer material comprising styrenic end-block segments bound to a rubbery segment that may be saturated or unsaturated.

DISCUSSION—These products normally contain substantial amounts of added materials such as other polymers, oils, fillers, resins, and colorants. (1992)

surfacing mat, *n*— a thin mat of fine fibers used primarily to produce a smooth surface on a reinforced plastic. (1985)

syneresis, *n*— the contraction of a gel accompanied by the separation of a liquid. (1985)

syntactic cellular plastics—materials consisting of hollow sphere fillers in a resin matrix. (1985)

telomer, *n*—a polymer composed of molecules having terminal groups incapable of reacting with additional monomers, under the conditions of the synthesis, to form larger polymer molecules of the same chemical type. (IUPAC, ISO) (1986)

thermal break, *n*— a solid or cellular material or combination of materials of low thermal transmission placed between components of high thermal transmission in order to reduce the heat flow across the assembly.

thermally foamed plastic—a cellular plastic produced by applying heat to effect gaseous decomposition or volatilization of a constituent. (1985)

thermoplastic, *n*— a plastic that repeatedly can be softened by heating and hardened by cooling through a temperature range characteristic of the plastic, and that in the softened state can be shaped by flow into articles by molding or extrusion. (1985)

thermoplastic, *adj*—capable of being repeatedly softened by heating and hardened by cooling through a temperature range characteristic of the plastic, and that in the softened state can be shaped by flow into articles by molding or extrusion for example.

DISCUSSION—Thermoplastic applies to those materials whose change upon heating is substantially physical. (1985)

thermoplastic elastomers (TPE)—a diverse family of rubber-like materials that, unlike conventional vulcanized rubbers, can be processed and recycled like thermoplastic materials.

thermoset, *n*— a plastic that, after having been cured by heat or other means, is substantially infusible and insoluble. (1983)

thermoset, *adj*— pertaining to the state of a plastic in which it is substantially infusible. (1985)

thermosetting, *adj*—capable of being changed into a substantially infusible or insoluble product when cured by heat or other means. (1985)

transfer molding—a method of forming articles by fusing a plastic material in a chamber and then forcing essentially the whole mass into a hot mold where it solidifies. (1985)

transition, first order—a change of state, associated with crystallization or melting in a polymer. (1985)

urea plastics—plastics based on resins made by the condensation of urea and aldehydes. (1985)

urethane plastics—plastics based on polymers in which the repeated structural units in the chains are of the urethane type, or on copolymers in which urethane and other types of repeated structural units are present in the chains. (ISO) (1983)

vacuum forming—a forming process in which a heated plastic sheet is drawn against the mold surface by evacuating the air between it and the mold. (1972)

vinyl acetate plastics—plastics based on polymers of vinyl acetate or copolymers of vinyl acetate with other monomers, the vinyl acetate being in greatest amount by mass. (ISO) (1983)

vinyl chloride copolymer—a polymer prepared by the polymerization of vinyl chloride and other monomers, the vinyl chloride content being a minimum 51 % of the mass of the polymer. (2000)

vinyl chloride plastics—plastics based on polymers of vinyl chloride or copolymers of vinyl chloride with other monomers, the vinyl chloride being in greatest amount by mass. (ISO) (1983)

vinylidene chloride plastics—plastics based on polymer resins made by the polymerization of vinylidene chloride or copolymerization of vinylidene chloride with other unsaturated compounds, the vinylidene chloride being in the greatest amount by weight. (1972)

virgin plastic—a plastic material in the form of pellets, granules, powder, floc, or liquid that has not been subjected to use or processing other than that required for its initial manufacture. (1985)

viscosity—the property of resistance of flow exhibited within the body of a material.

DISCUSSION—In testing, the ratio of the shearing stress to the rate of shear of a fluid. Viscosity is usually taken to mean “Newtonian viscosity”, in which case the ratio of shearing stress to rate of shearing strain is constant. In non-Newtonian behavior which is the usual case with plastics materials, the ratio varies with the shearing rate. Such ratios are often called the “apparent viscosities” at the corresponding shear rates. (See **viscosity coefficient**.) (IUPAC symbol: η .) (ISO) (1983)

viscosity coefficient—the shearing stress necessary to induce a unit velocity flow gradient in a material.

DISCUSSION—In actual measurement, the viscosity coefficient of a material is obtained from the ratio of shearing stress to shearing rate. This assumes the ratio to be constant and independent of the shearing stress, a condition which is satisfied only by Newtonian fluids. Consequently, in all other cases, values obtained are apparent and represent one point on the flow curve. In the cgs system, the viscosity coefficient is expressed in poises (dyne-seconds per square centimetre) and in the SI system in newton-seconds per square metre. (See **viscosity**.) (ISO) (1983)

void, *n*—(1) in a solid plastic, an unfilled space of such size that it scatters radiant energy such as light.
(2) a cavity unintentionally formed in a cellular material and substantially larger than the characteristic individual cells. (ISO) (1972)

vulcanization, *n*— an irreversible process during which a rubber compound, through a change in its chemical structure (for example, cross-linking), becomes less plastic and more resistant to swelling by organic liquids and elastic properties are conferred, improved, or extended over a greater range of temperature. (1972)

warpage, *n*—distortion caused by nonuniform change of internal stresses. (See also **dome**.)

DISCUSSION—Also called warp. (1985)

weld- or knit-line—a mark on, or weakness in, a molded plastic formed by the union of two or more streams of plastic flowing together. (1966)

weld-line, *n*— a discontinuity in a molded plastic part formed by the merging of two or more streams of plastic flowing together. (1985)

weld-mark, *n*— a visible weld-line. (1985)

wet layup, *n*— a method of making a reinforced plastic in which the polymer compound is applied as a liquid and as the reinforcement is put in place. (1985)

wet winding, *n*— a method of making filament-wound reinforced plastics in which the fiber reinforcement is coated with a polymer compound as a liquid just prior to wrapping on a mandrel. (1985)

whisker, *n*—a short, single-crystal fiber. (1985)

width—in the case of a beam, the cross-sectional dimension perpendicular to the direction in which the load is applied. (1991)

wrinkle, *n*—an imperfection in reinforced plastics that has the appearance of a wave molded into one or more plies of fabric or other reinforcing material. (1983)

ANNEXES

(Mandatory Information)

A1. GENERAL TERMS

A-stage, <i>n</i>	engineered plastic
addition polymerization	engineering plastics
alloy	isotactic, <i>adj</i>
aging, <i>n</i>	luminous transmittance
apparent density	mat
artificial weathering	oligomerization
B-stage, <i>n</i>	parison, <i>n</i>
binder, <i>n</i>	plastic(s)
blocking, <i>n</i>	polyaddition
bulk density	polycondensation
C-stage, <i>n</i>	polymerization
composite	regular transmittance
compost	sample, <i>n</i>
compound, <i>n</i>	set
condensation polymerization	specimen, <i>n</i>
copolymerization	specular transmittance, <i>n</i>
crosslinking, <i>n</i>	surfacing mat
degradation, <i>n</i>	thermoplastic, <i>adj</i>
density, apparent	thermoset, <i>adj</i>
density, bulk	thermosetting, <i>adj</i>
depth, <i>n</i>	vulcanization, <i>n</i>
dry-blend, <i>n</i>	warpage, <i>n</i>
	whisker
	width

A2. MATERIALS

acetal plastics	alkyd resin
acrylic plastics	allyl plastics
alkyd plastics	allyl resin
amino plastics, <i>n</i>	plastic pipe
amino resin	plastic tubing
aromatic polyester	plastisol, <i>n</i>
biodegradable plastics	polyamide plastics
block copolymer	polyarylate
branched polyethylene plastics	polyaryetherketone
bulk molding compound, <i>n</i>	polybutylene
butylene plastics	polybutylene plastics
cast film	polycarbonate, <i>n</i>
	polydicyclopentadiene plastics
cellulosic plastics	polycarbonate plastics
chlorinated poly(vinyl chloride) plastics	polyester
chlorofluorocarbon plastics	polyester plastics
chlorofluorohydrocarbon plastics, <i>n</i>	polyether, <i>n</i>
condensation polymer	polyethylene, <i>n</i>
copolymer	polyethylene plastics
cross laminate	polymer, <i>n</i>
degradable plastic	polymethylmethacrylimide, <i>n</i>
elastomer, <i>n</i>	polyol, <i>n</i>
epoxy plastics	polyolefin
ethylene plastics, <i>n</i>	polyolefin plastics
filler, <i>n</i>	polyoxymethylene
film, <i>n</i>	polyoxymethylene plastics
fluorocarbon plastic	polyphthalamide, <i>n</i>
fluorohydrocarbon plastics	polypropylene, <i>n</i>
fluoroplastic	polypropylene plastics
furan plastics	polystyrene, <i>n</i>
furan resin	polyurethane, <i>n</i>
glass, <i>n</i>	poly(vinyl acetate), <i>n</i>
glass finish	poly(vinyl alcohol), <i>n</i>

graft copolymer
halocarbon plastics
high density polyethylene plastics
homopolymer, *n*
hydrocarbon plastics
hydrolytically degradable plastic
inhibitor, *n*
laminare, *n*
lignin plastics
lignin resin
linear low density polyethylene plastics
linear polyethylene plastics
low density polyethylene plastics
melamine plastics
monomer, *n*
nonrigid plastic
novolac, *n*
nylon plastics
olefin plastics
oligomer, *n*
organosol, *n*
oxidatively degradable plastic
parallel laminate
phenolic plastics
phenolic resin compound, single-stage
phenolic resin compound, two-stage
photodegradable plastic
plastic(s), *n*
plasticizer, *n*

poly(vinyl chloride), *n*
preform, *n*
prepolymer, *n*
propylene plastics
recycled plastic
reinforced plastic
reprocessed plastic
resin, *n*
reworked plastic
rigid plastic
rubber, *n*
saran plastics
semirigid plastic
sheet, *n*
sheeting, *n*
silicone plastics
styrene plastics
styrene-rubber plastics
syntactic cellular plastics
telomer, *n*
thermoplastic, *n*
thermoplastic elastomers
thermoset, *n*
urea plastics
urethane plastics
vinyl acetate plastics
vinyl chloride plastics
vinylidene chloride plastics
virgin plastic

A3. TERMS RELATING TO PROCESSING

<p> adiabatic extrusion average injection velocity, <i>n</i> bag molding blow molding bulk factor cavity, <i>n</i> circuit cold molding compression molding cooling time, <i>n</i> cross section of the cavity, <i>n</i> cure, <i>v</i> cure cycle cure time cycle time, <i>n</i> delamination, <i>n</i> dome, <i>n</i> extrusion, <i>n</i> fabricating, <i>n</i> gate, <i>n</i> hold pressure, <i>n</i> injection molding, <i>n</i> injection time, <i>n</i> insert, <i>n</i> knuckle area lattice pattern lay, <i>n</i> </p>	<p> lay up, <i>n</i> lay up, <i>v</i> melt pressure, <i>n</i> melt temperature, <i>n</i> mold open time, <i>n</i> mold temperature, <i>n</i> molding, contact pressure molding, high-pressure molding, injection molding, low-pressure molding pressure, compression molding pressure, injection molding pressure, transfer necking, <i>n</i> polepiece, <i>n</i> postforming, <i>n</i> pot life powder blend reinforced reaction injection molding, <i>n</i> release agent, <i>n</i> runner, <i>n</i> sheet molding compound, <i>n</i> shot volume, <i>n</i> sprue, <i>n</i> transfer molding vacuum forming wet layup wet winding </p>
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A4. RHEOLOGICAL AND STATE TERMS

<p> cold flow creep, <i>n</i> gel, <i>n</i> gel point gel time glass transition </p>	<p> glass transition temperature (T_g) syneresis, <i>n</i> transition, first order viscosity, <i>n</i> viscosity coefficient </p>
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A5. CELLULAR PLASTICS

<p> cell, <i>n</i> cellular plastic channel, <i>n</i> chemically foamed polymeric material closed-cell foamed plastic collapse, <i>n</i> expandable plastic expanded plastics </p>	<p> foamed plastics mechanically foamed plastic open-cell cellular plastic plastic foam rise time, <i>n</i> skin, <i>n</i> thermal break thermally foamed plastic void, <i>n</i> </p>
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A6. DESCRIPTIVE TERMS

cut-layers
gusset, *n*

haze, *n*
stress-crack

A7. DEFECTS IN FABRICATED ARTICLES

blister, *n*
bloom, *n*
chalking, *n*
crater, *n*
crazing, *n*
delamination, *n*
dome, *n*
dry-spot
fiber show
fish-eye, *n*
frosting, *n*
heat mark
knit-line, *n*
let-go, *n*

lubricant bloom
pimple, *n*
pit, *n*
plate-mark
pressure-break, *n*
pulled-surface, *n*
resin streak, *n*
short, *n*
shrink mark
warpage, *n*
weld- or knit-line
weld-line
weld mark
wrinkle, *n*

A8. TERMS NOT RECOMMENDED

blush—use chalking, frosting, or lubricant bloom.
boil
bulging—use blister or dome.
cat's eye—use fish-eye.
chicken-skin
cold
cord
crush—use pressure-break.
densification

densification

dimple—use shrink mark.
dimple—use shrink mark.
dog-skin
dry-area—use dry-spot.
flow-lines—use weld-mark.
fog—use haze.
gas-mark
gas-pocket—use heat mark.
grease-mark—use bloom.
inverted blister—use shrink mark.

liquid resin

low-spot
open bubble—use pit.
pebble
piping—use shrink mark.
pock-mark—use pit.
precure—use short.
reclaimed plastic
reformulated plastic—use recycled plastic, reprocessed
reformulated plastic—use recycled plastic, reprocessed plastic, or reworked plastic.
—plastic, or reworked plastic.

seed
sink-mark—use shrink mark.
skip
string
sun hour
tear-drop—use fish-eye.
ultraviolet sun hour
unconverted-spot
vinyl plastics

APPENDIX

(Nonmandatory Information)

X1. RELATED LITERATURE

X1.1 The following literature relates to plastic terminology:

Beach, N. E., *A Consensus Glossary of Plastic Terms*, Plastics Technical Evaluation Center, Picatinny Arsenal, Dover, NJ, December 1966.

Davydov, V. N., *Technical Dictionary of High Polymers*, Pergamon Press, New York, NY, 1969.

Dictionary of Scientific and Technical Terms, McGraw-Hill, Inc., New York, NY, 1975.

SPI Plastic Engineering Handbook, 3rd ed., Reinhold Publishing Corp., New York, NY, 1960.

The Encyclopedia of Basic Materials for Plastics, edited by H. R. Simonds and J. M. Church, Reinhold Publishing Corp., New York, NY, 1967. Whittington, L. R., *Whittington's Dictionary of Plastics*, 2nd ed., Technomic Publishing Co., Westport, CT, 1978.

Handbook of Chemistry and Physics, The Chemical Rubber Publishing Co., Cleveland, OH.

A Glossary of Urethane Industry Terms, The Martin Sweets Co., Inc., 3131 West Market St., Louisville, KY.

The Condensed Chemical Dictionary, Reinhold Publishing Co., New York, NY.

Graham, E. C., *The Basic Dictionary of Science*, The MacMillan Co., New York, NY.

Bennett, H., *Concise Chemical and Technical Dictionary*, Chemical Publishing Co., Inc., New York, NY.

Modern Plastics Encyclopedia, McGraw-Hill, Inc., New York, NY. (Published annually in October.)

SUMMARY OF CHANGES

This section identifies the location of selected changes to this terminology. For the convenience of the user, Committee D20 has highlighted those changes that may impact the use of this terminology. This section may also include descriptions of the changes or reasons for the changes, or both.

D 883 – 00:

(1) Modified **poly(vinyl chloride)** to add minimum monomer content.

(2) Added **chlorinated poly(vinyl chloride)**.

(3) Added **vinyl chloride copolymer**.

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