
**Plastics — Determination of the
melt mass-flow rate (MFR) and
melt volume-flow rate (MVR) of
thermoplastics —**

**Part 1:
Standard method**

*Plastiques — Détermination de l'indice de fluidité à chaud des
thermoplastiques, en masse (MFR) et en volume (MVR) —*

Partie 1: Méthode normale





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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 61, *Plastics*, Subcommittee SC 5, *Physical-chemical properties*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 249, *Plastics*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This second edition cancels and replaces the first edition (ISO 1133-1:2011), of which it constitutes a minor revision. The changes are as follows:

- references to withdrawn standards in [Annex B](#) (informative), [Annex D](#) (informative) and Bibliography have been updated;
- editorial corrections.

A list of all parts in the ISO 1133 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Introduction

For stable materials that are not rheologically sensitive to the time-temperature history experienced during melt flow rate testing, this document is recommended.

For materials whose rheological behaviour is sensitive to the test's time-temperature history, e.g. materials which degrade during the test, ISO 1133-2 is recommended. Also, ISO 1133-2 is considered to be particularly relevant for moisture-sensitive plastics.

NOTE At the time of publication, there is no evidence to suggest that the use of ISO 1133-2 for stable materials results in better precision in comparison with the use of this document.

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Part 1: Standard method

WARNING — Persons using this document should be familiar with normal laboratory practice, if applicable. This document does not purport to address all of the safety problems, if any, associated with its use. It is the responsibility of the user to establish appropriate safety and health practices and to ensure compliance with any regulatory requirements.

1 Scope

This document specifies two procedures for the determination of the melt mass-flow rate (MFR) and the melt volume-flow rate (MVR) of thermoplastic materials under specified conditions of temperature and load. Procedure A is a mass-measurement method. Procedure B is a displacement-measurement method. Normally, the test conditions for measurement of melt flow rate are specified in the material standard with a reference to this document. The test conditions normally used for thermoplastics are listed in [Annex A](#).

The MVR is particularly useful when comparing materials of different filler content and when comparing filled with unfilled thermoplastics. The MFR can be determined from MVR measurements, or vice versa, provided the melt density at the test temperature is known.

This document is also possibly applicable to thermoplastics for which the rheological behaviour is affected during the measurement by phenomena such as hydrolysis (chain scission), condensation and cross-linking, but only if the effect is limited in extent and only if the repeatability and reproducibility are within an acceptable range. For materials which show significantly affected rheological behaviour during testing, this document is not appropriate. In such cases, ISO 1133-2 applies.

NOTE The rates of shear in these methods are much smaller than those used under normal conditions of processing, and therefore it is possible that data obtained by these methods for various thermoplastics will not always correlate with their behaviour during processing. Both methods are used primarily in quality control.

2 Normative references

There are no normative references in this document.

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>