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**Plastics — Poly(vinyl chloride) pastes —  
Determination of apparent viscosity using  
the Severs rheometer**

*Plastiques — Pâtes de poly(chlorure de vinyle) — Détermination de la  
viscosité apparente au rhéomètre Severs*

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## Foreword

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

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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

ISO 4575 was prepared by Technical Committee ISO/TC 61, *Plastics*, Subcommittee SC 9, *Thermoplastic materials*.

This third edition cancels and replaces the second edition (ISO 4575:1985), which has been technically revised.

# Plastics — Poly(vinyl chloride) pastes — Determination of apparent viscosity using the Severs rheometer

## 1 Scope

This International Standard specifies a method for determining the apparent viscosity, at high shear, of poly(vinyl chloride) (PVC) pastes prepared from PVC paste polymers and plasticizers, using the Severs rheometer.

It applies in particular to “standard pastes” prepared in accordance with ISO 4612 or ISO 11468.

## 2 Principle

A sample of the paste is placed in a Severs rheometer and the jacket set to a defined temperature. The flow rate of the paste through a calibrated die is measured at different pressures. The shear rate and apparent viscosity are calculated for each flow rate corresponding to each of the pressures applied. Optionally, a graph of apparent viscosity as a function of the shear rate can be prepared.

## 3 Apparatus

**3.1 Severs rheometer**, of capacity 500 ml to 1 000 ml, of one of the two basic designs shown in Figure 1, and consisting essentially of the following components:

**3.1.1 Measuring vessel**, for example a stainless-steel or bronze cylinder with polished internal surfaces to which can be fixed both a base having an orifice in which can be placed a die, and a cover which can be connected to the source of pressure or to the atmosphere. The whole shall be airtight.

**3.1.2 Jacket**, connected to a system for temperature control which allows the contents of the body of the measuring vessel to be maintained at a temperature of  $(23 \pm 0,5) ^\circ\text{C}$ .

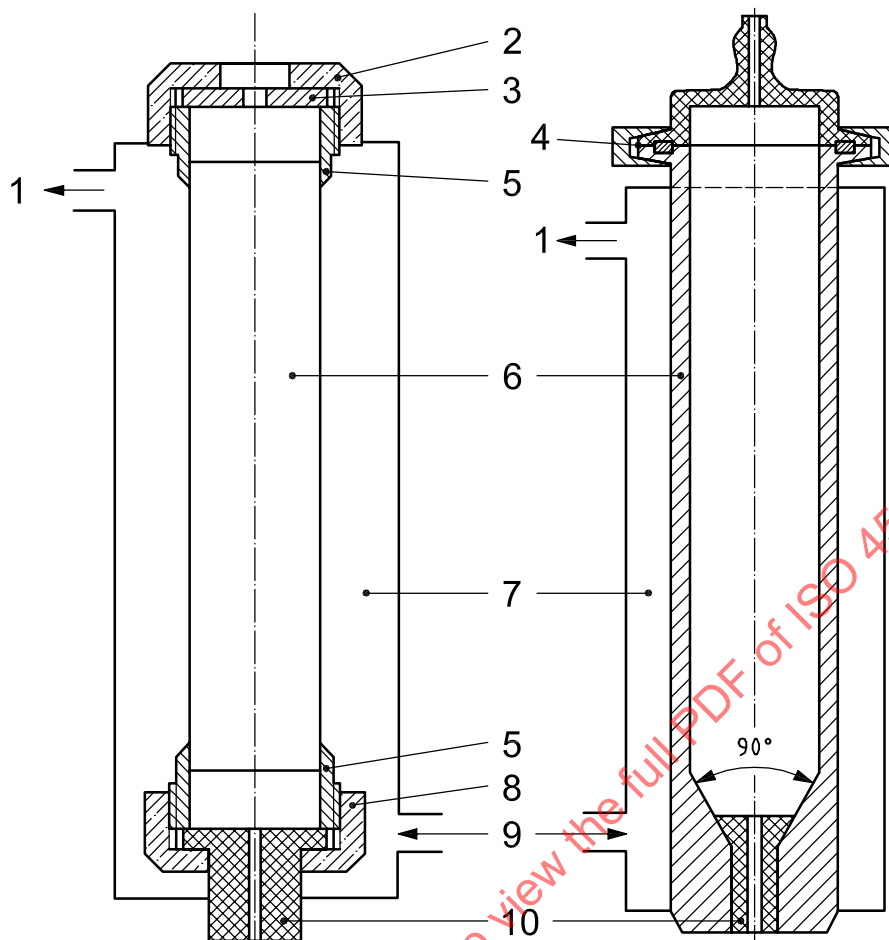
**3.1.3 Non-deformable die**, for example of stainless steel or PTFE, consisting of a cylindrical tube which can be fitted in a tight fashion to the bottom of the measuring vessel. The outer and internal surfaces of the tube shall be polished. The die is defined by the diameter and the height of the tube. Two dies, A and B, are specified in the application of this International Standard. The dimensions of the dies are given in Table 1.

**Table 1 — Dimensions of the dies**

Dimensions in millimetres

| Dimension      | Die A          | Die B          |
|----------------|----------------|----------------|
| Radius of tube | $1,5 \pm 0,05$ | $1,5 \pm 0,05$ |
| Height         | $45 \pm 0,5$   | $22,5 \pm 0,5$ |

**3.1.4 Piston** (if necessary), of rigid plastic material with a diameter slightly less than that of the measuring vessel to prevent the fluid, under pressure, from passing directly through the die in the case of pastes which cavitate. (Its use also simplifies the cleaning of the instrument.) A sketch of the piston is given in Figure 2.

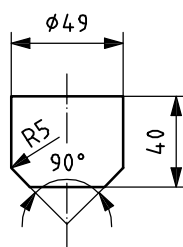


**Key**

- |   |                                  |    |                                 |
|---|----------------------------------|----|---------------------------------|
| 1 | temperature-regulating fluid out | 6  | cylinder                        |
| 2 | lid                              | 7  | jacket                          |
| 3 | PTFE washer                      | 8  | die clamp                       |
| 4 | clamped joint                    | 9  | temperature-regulating fluid in |
| 5 | threaded joint                   | 10 | die                             |

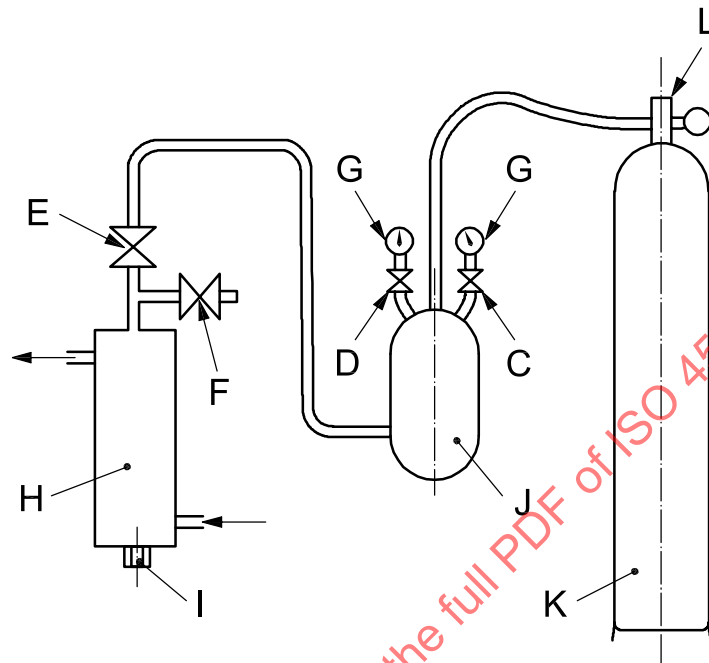
**Figure 1 — Diagram showing the basic principles of two types of Severs rheometer**

Dimensions in millimetres



**Figure 2 — Piston**

**3.1.5 Pressurizing device**, consisting of a cylinder of pressurized nitrogen, an expansion chamber with pressure gauges, and a number of valves. An example is shown in Figure 3.



**Key**

|                                           |                            |
|-------------------------------------------|----------------------------|
| C valve                                   | H Severs rheometer         |
| D valve                                   | I die                      |
| E pressurized-nitrogen inlet valve        | J expansion chamber        |
| F valve to atmosphere                     | K nitrogen cylinder        |
| G pressure gauges (with different scales) | L pressure reduction valve |

**Figure 3 — Example of pressurizing device**

**3.2 Beakers**, of capacity about 50 ml.

**3.3 Timer**, accurate to 0,1 s.

**3.4 Balance**, accurate to  $\pm 0,5$  g.

**3.5 Thermometer**, capable of measuring a temperature of  $(23 \pm 0,5)$  °C.

## 4 Procedure

### 4.1 Choice of test pressures and die

Depending on the test paste and its intended use, choose at least four pressures in the following list of preferred numbers:

100 kPa, 160 kPa, 250 kPa, 400 kPa, 630 kPa, 1 000 kPa, 1 600 kPa, 2 500 kPa<sup>1)</sup>.

Conduct a test with die A and a pressure of 2 500 kPa. From the measured flow rate  $q_m$  (see 5.1), calculate as indicated in 5.2 the corresponding shear rate:

- if the shear rate is more than  $1\,000\text{ s}^{-1}$ , tests shall be carried out with die A;
- if the shear rate is less than or equal to  $1\,000\text{ s}^{-1}$ , tests shall be carried out with die B.

### 4.2 Introduction of the paste and control of the temperature

Position the base together with the appropriate die (see 3.1.3) and introduce the paste to be tested into the measuring vessel (3.1.1). If necessary, place the piston (3.1.4) on the paste.

Bring the temperature of the paste to  $(23 \pm 0,5)^\circ\text{C}$  by circulating water maintained at that temperature in the jacket (3.1.2) (generally 5 min is sufficient).

Screw down the lid and connect it to the pressurizing device (3.1.5).

### 4.3 Regulation of the test pressure

Start the tests at the lowest pressure. Regulate the pressure to  $\pm 10\text{ kPa}$  according to the device used. In the case of the example given in Figure 3, proceed in the following manner:

Close valves E and F, open valves C and D, and operate the pressure reduction valve L progressively until the pressure reading on the gauge having the higher scale range (C) is practically equal to the desired value. Then read the pressure on the gauge having the lower scale range (D) and carefully regulate the pressure to the desired value to the nearest  $\pm 10\text{ kPa}$ .

Operate in the same way when regulating the other test pressures, but without opening valve D for pressures above its maximum gauge reading.

### 4.4 Determination

#### 4.4.1 Weigh three 50 ml beakers (3.2) to the nearest 0,5 g.

Clean the exit orifice of the die and open valve E to admit nitrogen under pressure to the rheometer. Under pressure, the paste will pass through the die. Make sure that the pressure does not vary; regulate, if necessary, by operating the pressure reduction valve L.

Place a weighed beaker under the emerging paste stream and at the same time start the timer (3.3).

When the mass of paste obtained is at least 10 g, remove the beaker and stop the timer simultaneously; note the time of flow  $t_1$  in seconds to the nearest  $\pm 0,1\text{ s}$ . (If the amount is insufficient at the end of 2 min, abandon the test at this pressure and carry it out under greater pressure.)

---

1)  $1\text{ kPa} = 1\text{ kN/m}^2$

Repeat the measurements with the other two weighed beakers in turn, designating the corresponding flow times  $t_2$  and  $t_3$ .

Close the pressurized-nitrogen inlet valve E and open the valve to atmosphere F in order to arrest the flow of paste.

Weigh the containers, determining the masses of paste  $m_1$ ,  $m_2$  and  $m_3$ , in grams, to the nearest 0,5 g.

**4.4.2** Close the valve to atmosphere F and regulate the pressure to its new value. Repeat the test under the conditions specified in 4.4.1.

**4.4.3** After testing, clean the rheometer, avoiding the use of fluffy materials.

## 5 Calculations

### 5.1 Calculation of flow rates

For each one of the test pressures, calculate the flow rates  $q_{m1}$ ,  $q_{m2}$ , and  $q_{m3}$ , in grams per second, corresponding to the measurements, using the equations

$$q_{m1} = \frac{m_1}{t_1} \quad q_{m2} = \frac{m_2}{t_2} \quad q_{m3} = \frac{m_3}{t_3}$$

where  $m_1$ ,  $m_2$  and  $m_3$  and  $t_1$ ,  $t_2$  and  $t_3$  have the same meanings as in 4.4.1.

Calculate the arithmetic mean of the three values, i.e. the flow rate  $q_m$ , in grams per second, corresponding to the test pressure.

### 5.2 Calculation of shear rates and apparent viscosities

For each of the values of flow rate  $q_m$  (calculated as indicated in 5.1), calculate the shear rate and apparent viscosity using the formulae shown in Table 2 (see Notes 1 and 2):

**Table 2 — Formulae for shear rate and apparent viscosity**

| Quantity                                        | Any die                               | Die A                                  | Die B                                  |
|-------------------------------------------------|---------------------------------------|----------------------------------------|----------------------------------------|
| Shear rate, $\dot{\epsilon}$ (s <sup>-1</sup> ) | $\frac{4q_m}{\pi r^3 \rho}$           | $377 \frac{q_m}{\rho}$                 |                                        |
| Apparent viscosity, $\eta_{app}$ (Pa·s)         | $10^3 \frac{\pi r^4 p \rho}{8 h q_m}$ | $44 \times 10^{-3} \frac{p \rho}{q_m}$ | $88 \times 10^{-3} \frac{p \rho}{q_m}$ |

where

$r$  is the radius of the cylindrical tube of the die, in centimetres;

$h$  is the height of the cylindrical tube of the die, in centimetres;

$p$  is the test pressure, in kilopascals;

$q_m$  is the paste flow rate at pressure  $p$ , in grams per second (calculated as indicated in 5.1);

$\rho$  is the density of the paste at 23 °C, in grams per cubic centimetre.

NOTE 1 Strictly speaking, these formulae are applicable only to Newtonian fluids. Nevertheless, they have been applied to PVC pastes because they are easy to use and the values determined are sufficiently accurate for the purpose intended. The exact formulæ are given, for information, in Annex A.

NOTE 2 The shear force  $\sigma$  is equal to  $\eta\epsilon$  and can be calculated for each test pressure using the equation  $\sigma = pr/2h$ .

## 6 Expression of results

Indicate the apparent viscosity at each shear rate in the form of a table (see Figure 4).

Plot a graph showing the apparent viscosity (ordinate) versus the shear rate (abscissa). An example of such a curve is given in Figure 4.

## Test with Severs rheometer

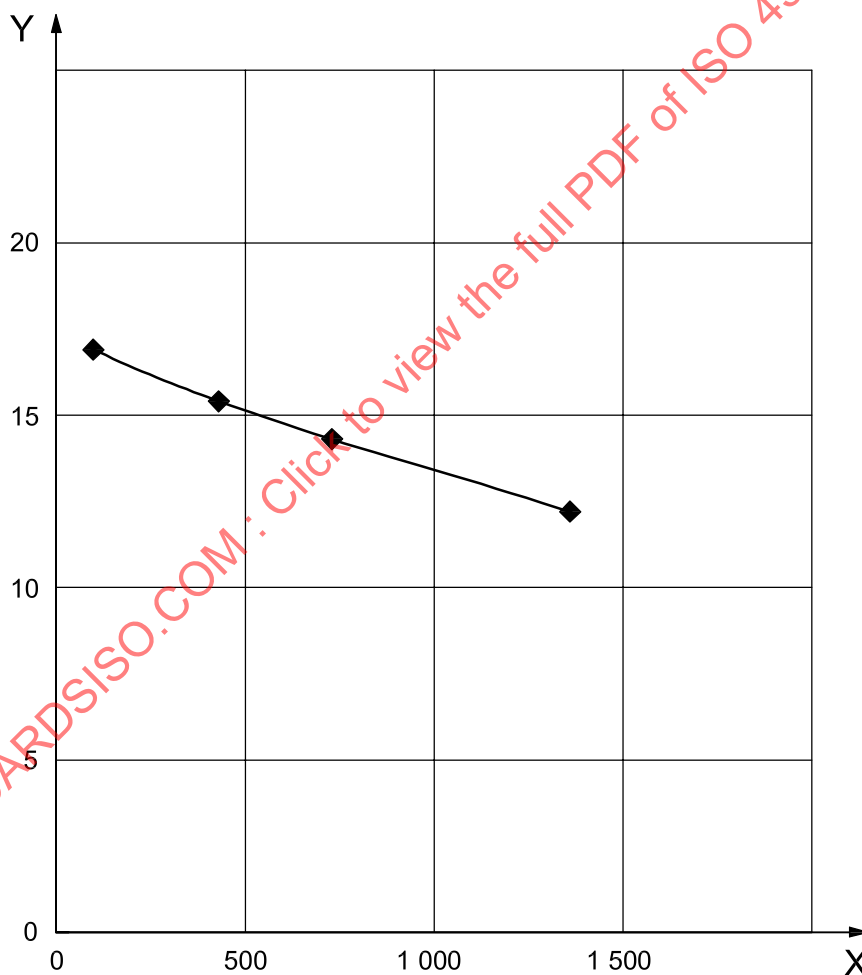
PVC paste "100 and 50"

$$\rho_{23} = 1,22 \text{ g/cm}^3$$

Die A

## Immediate measurement

|                     |                 |      |      |      |       |
|---------------------|-----------------|------|------|------|-------|
| $p$                 | kPa             | 100  | 400  | 630  | 1 000 |
| $q_m$               | g/s             | 0,32 | 1,40 | 2,38 | 4,44  |
| $\varepsilon$       | $\text{s}^{-1}$ | 98   | 430  | 730  | 1 360 |
| $\eta_{\text{app}}$ | Pa·s            | 16,9 | 15,4 | 14,3 | 12,2  |



## Key

X shear rate,  $\varepsilon$  ( $\text{s}^{-1}$ )Y apparent viscosity,  $\eta_{\text{app}}$  (Pa·s)

Figure 4 — Examples of presentation in tabular form and graphically of results obtained using the Severs rheometer

## 7 Test report

The test report shall include the following particulars:

- a) a reference to this International Standard;
- b) all details necessary for complete identification of the PVC paste polymer and plasticizer tested;
- c) the formula of the paste;
- d) the method by which the paste was prepared, i.e. planetary-mixer method or dissolver method;
- e) the density of the paste;
- f) the die used;
- g) the conditioning time at 23 °C before measurement;
- h) a table of the apparent viscosities at the various shear rates used;
- i) optionally, a graph of apparent viscosity versus shear rate.

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