INTERNATIONAL STANDARD

ISO 1268-2

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Fibre-reinforced plastics — Methods of producing test plates —

Part 2: Contact and spray-up moulding

Plastiques renforcés de fibres — Méthodes de fabrication de plaques d'essai —

Partie 2: Moulage au contact et par projection

Reference number
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Annex

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 3.

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 part of ISO 1268 may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 1268-2 was prepared by Technical Committee ISO/TC 61, *Plastics*, Subcommittee SC 13, *Composites and reinforcement fibres*.

Together with the other parts (see below), this part of ISO 1268 cancels and replaces ISO 1268:1974, which has been technically revised.

ISO 1268 consists of the following parts, under the general title *Fibre-reinforced plastics — Methods of producing test plates*:

— *Part 1: General conditions*

— *Part 2: Contact and spray-up moulding*

— *Part 3: Wet compression moulding*

— *Part 4: Moulding of prepregs*

— *Part 5: Filament winding*

— *Part 6: Pultrusion moulding*

— *Part 7: Resin transfer moulding*

— *Part 8: Compression moulding of SMC and BMC*

— *Part 9: Moulding of GMT/STC*

The following additional parts are in preparation:

— *Part 10: Injection moulding of SMC and BMC — General principles and moulding of multipurpose test specimens*

— *Part 11: Injection moulding of SMC and BMC — Small plates*

Annex A of this part of ISO 1268 is for information only.

Fibre-reinforced plastics — Methods of producing test plates —

Part 2:
Contact and spray-up moulding

1 Scope

This part of ISO 1268 specifies methods for preparing reinforced plastics test plates either by contact moulding or by spray-up moulding.

It applies exclusively to glass reinforcements.

It is intended to be read in conjunction with ISO 1268-1.

2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this part of ISO 1268. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this part of ISO 1268 are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 1172, *Textile-glass-reinforced plastics — Prepregs, moulding compounds and laminates — Determination of the textile-glass and mineral-filler content — Calcination methods*.

ISO 1268-1, *Fibre-reinforced plastics — Methods of producing test plates — Part 1: General conditions*.

3 Health and safety

See ISO 1268-1.

4 Principle

4.1 Contact moulding

Reinforcement layers (as described in 5.1) are placed on a rigid flat plate and manually impregnated with liquid thermosetting resin. The resin is formulated in accordance with the manufacturer's instructions to attain cure within a period of time that allows completion of the lay-up, yet limits unnecessary exposure to the atmosphere. The glass fibre and resin are consolidated by means of a hand-operated roller.

This method is suitable for any thermosetting resin that cures at room temperature without the need for additional pressure to be applied.