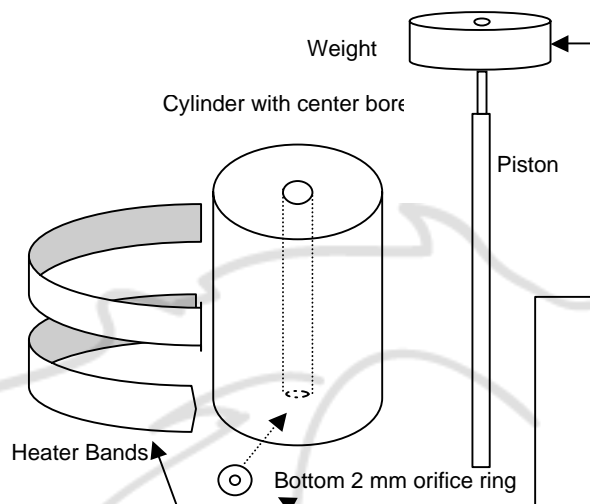


Extrusion Plastometer (MFI, MFR, MI)



M.F.I. = Melt Flow Index

M.I. = Melt Index

M.F.R. = Melt Mass-Flow Rate

M.V.R. = Melt Volume-Flow Rate

At a set: Temperature, opening and weight (load).

How many grams of resin are pushed through the opening in 10 minutes?

ASTM D1238

Conditions	Temperature °C (°F)	Weight/Load Kg	
A	125	0.325	
B	125	2.16	
C	150	2.16	
D	190	0.325	
Etc...			
I	230 (446)	3.8	ABS
AL	220 (428)	10	ABS
K	275 (527)	0.325	Nylon 6/6
O	300 (572)	1.2	PC
Q	235 (455)	1	Nylon 6
AV	280 (536)	2.16	PBT
Thru BE			



Tinius Olsen



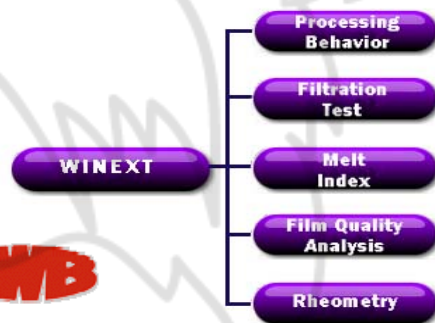
Dynisco

Rheometry

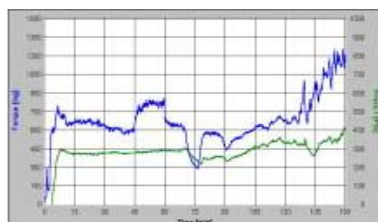
Information given in Poise



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Torque & Pressure Extrusion Curve

Rheologic Study of a Polymer

