Determination of the fracture resistance of ductile polymers: the ESIS TC4 recent experience

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	obtainable with the application of this testing scheme to ductile polymers has been assessed by means of multi-laboratory RR testing exercises, started in 2011. An ESIS TC4 reference draft protocol was prepared and ten laboratories participated in the RR activities. The present work describes the load separation criterion-based testing procedure recently examined by ESIS TC4, and gives a summary of the results obtained in the RR activities, which appear encouraging.

Title:

Determination of the fracture resistance of ductile polymers: the ESIS TC4 recent experience

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ABSTRACT

Round-robin (RR) tests carried out under the direction of the Technical Committee 4, "Polymers, Polymer Composites and Adhesives", of the European Structural Integrity Society (ESIS TC4) showed that the multi-specimen methodology employed for the construction of the crack growth resistance curve (J vs crack extension, Δa) of polymers often does not provide reliable data, because of the uncertainties associated with the measurement of Δa. With this in mind, the ESIS TC4 attention has been more recently focused on the analysis of a testing scheme based on the load separation criterion, which does not require the measurement of Δa. With the aim to employ this new approach into a standardized procedure, the degree of reproducibility of the results obtainable with the application of this testing scheme to ductile polymers has been assessed by means of multi-laboratory RR testing exercises, started in 2011. An ESIS TC4 reference draft protocol was prepared and ten laboratories participated in the RR activities. The present work describes the load separation criterion-based testing procedure recently examined by ESIS TC4, and gives a summary of the results obtained in the RR activities, which appear encouraging.

INTRODUCTION

For determining the low-rate fracture resistance of ductile polymers, for which the application of standard linear elastic fracture mechanics (LEFM) tests fails, the material crack growth resistance (J_R) curve (J vs crack extension, Δa), developed within the frame of elastic-plastic fracture mechanics (EPFM), is generally employed. This is usually constructed by means of a multi-specimen approach (procedure[1] developed by ESIS TC4, that is the Technical Committee 4, "Polymers, Polymer Composites and Adhesives", of the European Structural Integrity Society[2], and ASTM D6068-10 *Standard Test Method for Determining J-R Curves of Plastic Materials*[3]). Specific ESIS TC4 round-robin, RR, tests showed that the uncertainties associated with the measurement of Δa often make this approach unreliable. Further, in many cases, an initiation fracture resistance parameter, J_{Ic}, cannot be obtained. With this in mind, the attention of ESIS TC4 has been recently paid to the analysis of a single-specimen testing scheme based on the load separation criterion (LSC), which does not require the measurement of Δa (see Agnelli et al.[4]). This approach would allow to: (i.) determine a material initiation fracture resistance parameter, $J_{I,lim}$; (ii.) provide a rough measure of Δa produced during the fracture test, in the plastic region. In order to assess the degree of reproducibility of the results obtainable with the application of this method, in view of its possible employment in a standardized procedure, a multi-laboratory activity has started in September 2011 under the direction of ESIS TC4, with Università degli Studi di Brescia (Italy) as the coordinating laboratory. Ten laboratories (indicated in the authors' affiliation list) have participated in this activity, organized on three consecutive RR testing exercises (RR1 to RR3). RR1 consisted in a preliminary work aimed at setting the key-points for the preparation of the reference draft testing protocol[5], which was prepared in 2013 and then further reviewed in 2015. In RR2 and RR3, this protocol (called RR protocol hereafter) was applied to the fracture characterization of polymeric materials that exhibit a ductile behavior,

but different degrees of stiffness and strength (from standard tensile tests). The outcomes were used to enhance the robustness of the method and to improve the protocol itself. The examined materials are: an acrylonitrile-butadiene-styrene (ABS) and a high-impact polystyrene (HIPS), in RR2 (the RR2 results are presented in Agnelli et al.[4]); a rubber-toughened polybutylene terephthalate (RT-PBT) and a linear low-density polyethylene (LLDPE), in RR3. The present work describes the LSC-based testing procedure examined by ESIS TC4, and gives a summary of the results obtained during the RR activities.

THE LSC-BASED TESTING METHOD

The method described in the RR protocol[5], founded on the LSC proposed by Ernst[6], derives from Sharobeam and Landes' works published in the early 90's on metals[7,8]. The LSC assumes that, for a defined specimen geometry, material and constraint, the load, P, recorded in a fracture test in the plastic region can be mathematically represented as the product of two independent functions, as equation (1) shows:

$$P = G\left(\frac{b}{W}\right) \cdot H\left(\frac{u_{pl}}{W}\right) \quad (1)$$

where $G(b/W)$ and $H(u_{pl}/W)$ are the geometry and the material deformation functions, respectively, W is the specimen width, b the specimen uncracked ligament length (that is W - a, with a that indicates the crack length), and u_{pl} is the plastic displacement (that is the plastic component of the total displacement, u). The applicability of the LSC to polymeric materials, during both blunting and crack propagation phase, has been demonstrated (see: Bernal, Cassanelli and Frontini,[9,10] Bernal, Montemartini and Frontini,[11] Morhain and Velasco,[12,13] Salazar and Rodriguez,[14] Baldi, Agnelli and Riccò[15]).

The testing method described in the RR protocol[5] is based on the construction of the "load separation parameter curve", S_{sb} curve, from tests in single edge notched in bending, SE(B), configuration (see figure 1). It requires the execution of two tests, on a sharp-notched

(sN) specimen and on a blunt-notched (bN) specimen. A schematic representation of a sharp and of a blunt notch is in figure 1. In the sN specimen fracture propagation occurs, whereas in the bN specimen crack growth is hindered. From the load, P, vs displacement, u, curves obtained from quasi-static tests on a sN and a bN specimen, the separation parameter, S_{sb}, is determined as:

$$S_{sb}(u_{pl}) = \left.\frac{P_s}{P_b}\right|_{u_{pl}} \quad (2)$$

where P_s and P_b are load values read on P vs u_{pl} curves of sN and bN specimen, respectively, at a given value of plastic displacement, u_{pl}, which, in the protocol here examined, is determined for each specimen as:

$$u_{pl} = u - P \cdot C_0 \quad (3)$$

C_0 being the initial elastic compliance of the specimen. With reference to u_{pl} determined according to equation (3), that is from C_0, it is worth pointing out that: (i.) for the sN specimen, in the crack propagation phase, u_{pl} data assume a nominal character in consideration of the fact that the true u_{pl} data should be evaluated from the actual compliance, C, that increases during the crack growth phase, but is not known [the determination of C would require test interruption and the measurement of Δa (see Appendix, where true u_{pl} data determined from C have been used for the verification of the LSC validity for RT-PBT)]; (ii.) in consideration of the viscoelastic nature of polymeric materials, u_{pl} represents the "non-elastic" component of the total displacement, u, which for these materials is in general the sum of three contributions: elastic, viscoelastic and plastic. Preliminary investigations specifically carried out by the laboratory of Brescia showed that, to the aims of the testing method here examined (RR protocol[5]), u_{pl} data evaluated from C_0 can be successfully used. It is expected that S_{sb} curve, that is S_{sb} plotted against u_{pl}, shows a "plateau" region, where S_{sb} maintains an almost constant value ($S_{sb,plateau}$), followed by a decreasing S_{sb} region. The former region corresponds to the crack blunting phase and the latter to the crack propagation

phase, in the fracture process of the sN specimen. The point between these two regions (called limit point), at $u_{pl} = u_{pl,lim}$, corresponds to fracture initiation (or pseudo-initiation, by considering that for ductile polymers fracture initiation can be a complex progressive process[16]). J-integral value at $u_{pl,lim}$, that is $J_{I,lim}$, which can be taken as a material pseudo-initiation fracture resistance parameter in place of the more conventional $J_{0.2}$ computed by the J_R curve (see the ESIS TC4 procedure[1]), is evaluated as:

$$J_{I,lim} = \frac{2 \cdot U_{lim,c}}{B \cdot (W - a_0)} \quad (4)$$

where $U_{lim,c}$ is the energy up to the limit point, corrected for indentation (see the ESIS TC4 procedure[1]), and B, W and a_0, the thickness, width and initial crack length of the sN specimen, respectively.

Further, the normalized separation parameter curve (R_S curve), i.e. R_S vs u_{pl}, is traced (R_S is obtained as the ratio of S_{sb} over $S_{sb,plateau}$), and the parameter m_S determined in the region of fracture propagation as:

$$m_S = -\left.\frac{dR_S}{du_{pl}}\right|_{u_{pl} > u_{pl,lim}} \quad (5)$$

It has been showed[4] that parameter m_S, which is a specimen characteristic (i.e. dependent on both specimen geometry and material), provides an indication of the crack advancement produced per unit of u_{pl} and could be used, as a "ductility index", to classify the fracture propagation processes by the amount of crack growth occurring within the plastic region. The higher the value of m_S, the higher is Δa per unit of u_{pl}; if $m_S \rightarrow 0$ the process is governed by crack blunting.

Further details concerning this methodology can be found in Agnelli et al.[4] and in the RR protocol[5].

EXPERIMENTAL

Materials ABS, HIPS and LLDPE were provided by Versalis SpA (Mantova, Italy), whereas RT-PBT by Radici Novacips SpA (Villa d'Ogna, Bergamo, Italy). Table 1 reports the supply-form of the materials, their basic mechanical properties and the nominal dimensions of the SE(B) specimens used in the RR fracture tests. For ABS, HIPS and RT-PBT the fracture resistance $J_{0.2}$ data are also indicated. They were obtained from the J_R curve constructed by the application of the ESIS TC4 multi-specimen approach[1] on specimens having the same geometry and dimensions of the RR tests (for ABS and HIPS, $J_{0.2}$ data are from Agnelli et al.[4]; for RT-PBT, J_R curve is reported in Appendix).

Each laboratory prepared and tested at least three sN and one bN specimens for each of the materials considered. The notching techniques were freely chosen by the laboratory, following the guide-lines provided by the RR protocol[5]. For LLDPE, two sets of specimens (#a and #b), differing in size, were examined. This was done in order to explore, for this very ductile polymer (which also showed the lowest degrees of stiffness and strength among the materials examined), how the results obtainable by the application of the RR protocol could be affected by the specimen size (geometrical constraint). All the experiments were performed by means of universal testing machines, at ≈ 23°C and with a crosshead rate of 1 mm/min. The data were processed according to the RR protocol[5], and the results (consisting in S_{sb} curve and data of $J_{I,lim}$ and m_S, for each sN specimen tested) sent to the laboratory of Brescia for the comparative analysis.

The applicability of the LSC to styrenic polymers and polyolefins have been examined in several literature works; by contrast, to the authors' knowledge, the applicability of the LSC to rubber-toughened PBT has never been checked. Therefore, before starting the RR activity on the RT-PBT, the validity of the LSC has been experimentally verified (see Appendix).

RESULTS AND DISCUSSION

Figures 2*A* and 2*B* report $J_{I,lim}$ and m_S results, respectively, for the various materials examined. Each datum reported is the mean value obtained by averaging all the data from the various laboratories. The datum considered for each laboratory is the average of the data obtained from the various sN specimens tested at the laboratory.

The degree of repeatability of the results within the same laboratory was generally higher than that of reproducibility (represented by the data of standard deviation reported in figure 2). Results with a very high degree of repeatability could be obtained, and this emerges clearly from figures 3*A*-*E*, in which the R_S curves of different nominally identical sN specimens of a given material, obtained at a given (selected) laboratory, are compared (the curves are vertically shifted for clarity). Figure 3*A* refers to specimens of HIPS tested at laboratory #9; figure 3*B* to ABS tested at laboratory #10; figure 3*C* to RT-PBT tested at laboratory #1 (the R_S curves are reported both shifted and not); figures 3*D* and 3*E* to specimens of LLDPE with size #a and #b, respectively, tested at laboratory #5 (laboratory numbers according to the authors' affiliation list). In figures 3*A* and 3*B*, the R_S curve indicated with an asterisk has been built at Brescia, from the raw data provided by the laboratory that performed the tests. This was done, within the RR2 activities, just to check if the data processing procedure described in the RR protocol[5] had been properly applied by the laboratory. Figure 3*C* shows the R_S curves obtained at Brescia (laboratory #1) from six sN specimens of RT-PBT, tested up to different levels of displacement (the rhomb indicates, for each sN specimen test record, the point at which the fracture test was interrupted, that is called final point). If not shifted vertically, these curves overlap well, and they practically draw one single curve in which the plateau region that extends up to the limit point is clearly visible. For the LLDPE, the degree of repeatability of the results generally resulted lower

with respect to the other materials, as it can be observed in figure 3*E*. This is related to the fact that LLDPE was largely the most hard-to-characterize material. Even if relatively high displacement values were reached (especially with size #b – ref. to figure 3*E*), necessary also in consideration of the low Young's modulus of the material, reliable plateau regions could not be clearly identified in the S_{sb} curves of the sN specimens tested. This indicates that, in the tests on the SE(B) specimens of the LLDPE here examined, the crack blunting phase cannot be distinguished from the crack propagation phase, and valid initiation fracture resistance data ($J_{I,lim}$) could not be obtained.

Focussing the attention on HIPS, ABS and RT-PBT for which data of both $J_{I,lim}$ and m_S have been obtained, it can be observed that the degree of reproducibility for the latter data is largely higher than that for the former data (see figures 2*A* and 2*B*). This suggests that, with respect to the fracture propagation phase, which m_S parameter refers to, fracture initiation/early-stages of crack growth, which $J_{I,lim}$ refers to, are less reproducible (at a macroscopic scale). Examination of the results collected from the various laboratories seems to indicate that the scattering observed for $J_{I,lim}$ data is related to a combination of (i.) testing and (ii.) data analysis aspects.

(i.) In relation to testing, the results suggest that the quality of the notch of the sN specimens played an important role. As underlined by Salazar et al.[17] and Martinez et al.[18], the influence of the sharp notch quality on the determination of the initiation fracture resistance of polymeric materials, in plane strain conditions, *via* both LEFM and EPFM methods, is still not fully understood. Within ESIS TC4, a RR exercise aimed at identifying the most suitable notching technique for the preparation of the notched specimens for the execution of plane strain LEFM tests is currently underway[2]. The outputs of this RR activity will be used, at a later stage, as a basis for the investigation of the effects of the sharp notch quality in J-testing of ductile polymers.

(ii.) With regard to data analysis, the results clearly point out that a crucial role is played by the determination of the initial specimen compliance, C_0. In addition, the procedure described in the RR protocol[5] for the identification of the limit point on the S_{sb} curve can be further improved. Within ESIS TC4, specific activities aimed at examining carefully these aspects are in progress. More specifically, a RR exercise aimed at evaluating the reproducibility degree of data of initial elastic compliance, C_0, of SE(B) specimens of polymeric materials that exhibit a ductile behavior is currently underway.

Even if the degree of scattering observed for $J_{I,lim}$ data is higher than that of m_S data, it can be acceptable within the field of fracture mechanics tests. Interestingly, not only for HIPS and ABS (as already pointed out by Agnelli et al.[4]), but also for RT-PBT, $J_{I,lim}$ value is lower than the value of the technological $J_{0.2}$ parameter read on the J_R curve (see Table 1 and Appendix). This suggests that the LSC-based approach here examined is able to provide data of fracture resistance more conservative with respect to $J_{0.2}$. It is worth noting, also, that for each material, the value of $J_{I,lim}$ verified the size criteria proposed in the ESIS TC4 protocol[1] for critical J-values, and this would indicate that the $J_{I,lim}$ values refer to a plane strain state at the crack tip, and that plasticity in the ligament is not excessive.

Figure 4 shows the R_S curves constructed at the laboratory of Brescia in compliance with the RR protocol, for the SE(B) specimens of the different materials examined (one single curve for each material). For LLDPE, only the curve of size #b, which refers to specimens with a width-to-thickness ratio closer to those of the specimens of the other materials, is reported. The differences among the fracture processes of the various specimens emerge clearly. Interestingly, by comparing the R_S curves of RT-PBT and HIPS (that is at fixed specimen dimensions, see Table 1), it can be observed that the extension of the plateau region of the curve is larger for the former than for the latter. This indicates that the higher fracture resistance obtained for RT-PBT with respect to HIPS ($J_{I,lim}$ of RT-PBT is ≈ 3 times

that of HIPS, see figure 2*A*) can be related also to the fact that the blunting-to-fracture transition, in the fracture process of a sN specimen, occurs at a level of u_{pl} that is higher for the former than for the latter.

The analysis of the fracture process based on the application of the RR protocol[5] brings to light, for the LLDPE, a behavior remarkably different from that of the other ductile polymeric materials examined. For the construction of the R_S curve of LLDPE, in absence of a reliable $S_{sb,plateau}$, following the protocol[5], the value of S_{sb} at u_{pl} = 0.5 mm was used in place of $S_{sb,plateau}$. The low values of m_S obtained (see figure 2*B*) clearly suggest that the process is governed by blunting: irrespective of the specimen size considered, either #a or #b, crack growth produced per unit of u_{pl} is very small. The high degree of scattering obtained for m_S data suggests that its fracture process is not easily reproducible, contrary to what observed for the other materials for which standard deviations of m_S are quite small. This is one of the reason why a reliable J_R curve could not be constructed for this material (see Table 1), for which, furthermore, valid data of Δa could not be obtained by the inspection of the fracture surface produced. Even if valid fracture resistance data ($J_{I,lim}$) have not been determined for LLDPE, the testing procedure here examined was able to highlight, through m_S determination, that a testing scheme based on the propagation of a crack cannot be successfully applied to this material, working on SE(B) specimens with dimensions as in Table 1. It would be necessary to use different specimen geometry/dimensions, or to resort to another testing approach that does not require the use of pre-cracked specimens, such as cutting tests (see Patel, Blackman and Williams[19]).

The results obtained for RT-PBT and LLDPE, in RR3, strengthen the idea, outlined by Agnelli et al.[4], to attribute a key-role to m_S parameter in the fracture characterization of ductile polymers. The uncertainties associated with the measurement of Δa, which impair the construction of the J_R curve, can have various causes: instrumental, methodological or related

to the intrinsic fracture behavior of the material. The measurement of Δa is typically based on the optical analysis of the fracture surface generated during the test, and the greatest difficulty is associated with the correct evaluation of the crack front, that defines the region on the fracture face characteristic of actual crack growth. More specifically, the obtainment of reliable Δa data can be particularly arduous if, depending on the material, the crack growth produced in the fracture test is very limited, or it is overshadowed by blunting (that is the case of the LLDPE here examined), or it is complicated by the occurrence of specific phenomena, such as multiple cracking. Results obtained in the RR exercise here reported show that the application of the RR protocol[5], which in principle requires only two tests, is effective at distinguishing, through m_S parameter, fracture processes governed by blunting ($m_S \rightarrow 0$) from processes where the crack growth actually occurs (with $m_S > 0$). With this in mind, m_S might be used as a key-parameter in a criterion to check *a priori* if the application of the multi-specimen approach for J_R curve construction (founded on the measurement of Δa) to specimens with given geometry and dimensions is likely to fail. More specifically, with reference to SE(B) specimens (that is the testing geometry considered in this work), a critical value of m_S ($m_{S,c}$) might be fixed and used according to this scheme:

- the LSC-based procedure is applied to a ductile polymer in the form of specimens with given dimensions, and the values of m_S and $J_{I,lim}$ are determined (the possibility that the S_{sb} plateau region is not clearly identified and, therefore, that $J_{I,lim}$ is not evaluated cannot be ruled out);

- if $m_S > m_{S,c}$: the value of $J_{I,lim}$ obtained is taken as the fracture resistance of the material (if the size criteria proposed for critical J-values in the ESIS TC4 protocol[1] are verified), and the application of the multi-specimen approach for J_R curve construction might be attempted;

- if $m_S \leq m_{S,c}$: $J_{I,lim}$ (if determined) cannot be considered valid and the multi-specimen approach for J_R construction cannot be applied; in this case, either the specimen dimensions

are modified and new LSC-based tests performed, or a different testing scheme that is not based on the use of pre-cracked specimens (e.g., cutting tests[19]) is employed.

Of course, the analysis of the source of the errors in the measurement of Δa deserves a special consideration. To this aim, specific ESIS TC4 activities are currently being developed. More specifically, inter-laboratory RR exercises focused on the instrumental and methodological aspects related to the optical analysis of the fracture surface for Δa evaluation will be organized. The possibility to resort to non-contact techniques (e.g. digital image correlation) for the indirect monitoring of the crack advancement during the fracture test will be also considered.

CONCLUSIONS

The results obtained in the ESIS TC4 RR activity on the use of LSC in J-testing of ductile polymers are encouraging. The method under development has been successfully applied to ductile polymers that exhibit different degrees of stiffness and strength (ABS, HIPS, RT-PBT and LLDPE). It allows determining a material pseudo-initiation fracture resistance parameter ($J_{I,lim}$), as well as a crack propagation parameter (m_S). The results suggest that this latter parameter can have a key-role in a criterion to check a priori if the multi-specimen approach for J-testing (the ESIS TC4 procedure[1] or the ASTM D6068[3]) applied to a ductile polymer (with given specimen geometry and dimensions) is likely to fail. The RR activity is still in progress, and special attention is being given to this latter outcome.

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APPENDIX: Construction of J_R curve and verification of the LSC validity for RT-PBT

The J_R curve was constructed according to the ESIS TC4 procedure[1]. The same specimen geometry and dimensions (sN specimen, Table 1) and testing conditions (crosshead rate and temperature) of the RR tests were used. Figure A.1 shows: the experimental (Δa; J) data points fitted by the power law best fitting curve; the exclusion lines; the blunting line, traced according to the following analytical expression:

$$J = 2 \cdot m \cdot \sigma_y \cdot \Delta a \qquad (A.1)$$

where a value of m = 1 was used. The points on the J_R fitting curve corresponding to $J_{0.2}$ (that is at Δa = 0.2 mm) and to J_{bl} (that is at the intersection with the blunting line) are also indicated. The value of $J_{0.2}$ is reported in Table 1; J_{bl} resulted of 1.39 kJ/m^2.

As underlined by Sharobeam and Landes[8], if the load is separable during the fracture propagation phase, S_{sb} data evaluated at different levels of u_{pl} (when the crack is growing), should lie on one single curve, if plotted against the actual values of b/W. For such verification, the sN specimens having the highest geometrical similarity among the specimens tested for the construction of the J_R curve (which are those whose R_S curves are reported in figure 3*C*) were selected, and their P vs u curves and Δa data at the final point considered. Differently from what done in the application of the RR protocol, in this analysis the actual values of u_{pl} at the final points, where the crack length, a, is $a_0 + \Delta a$, were used. These u_{pl} data were evaluated from the actual specimen elastic compliance, $C(a/W)$, indirectly calculated by using the following expression[20]:

$$C(a/W) = \frac{2 \cdot [f(a/W)]^2 \cdot \Phi(a/W)}{E_{fract} \cdot B} \qquad (A.2)$$

where f(a/W) and Φ(a/W) are tabulated functions[21]. The value of E_{fract}, which resulted of 1400 ± 50 MPa, was previously determined by applying equation (A.2) – inverted – to the data of a_0/W and C_0 (corrected by taking into account the specimen indentation compliance – see the ESIS TC4 procedure[1]) of all the specimens used for the J_R curve construction.

Figure A.2 shows the (b/W; S_{sb}) data points corresponding to the final points of the sN specimens test records considered. For S_{sb} determination, the bN specimen test record of the RR experiments was used. These (b/W; S_{sb}) data points, which are associated with different values of u_{pl}, draw one single trend, and this indicates that u_{pl} has no contribution on the value of S_{sb} and, therefore, that the LSC is valid during crack propagation. For SE(B) configuration, the geometry function, G(b/W), can be expressed as (see Sharobeam and Landes[7]):

$$G\left(\frac{b}{W}\right) = \left(\frac{b}{W}\right)^{\eta_{pl}} \quad (A.3)$$

Therefore, a power law best fitting curve – linear in the bi-logarithmic plot of figure A.2 – was forced on the fracture propagation data points. According to equation (A.3), the slope of the fitting line is η_{pl}, which results of 1.8. The difference between this value and the theoretical value of 2 derived by Rice, Paris and Merkle[22] for η_{pl}, and widely adopted in literature, is very similar to those observed in other literature works in which values of η_{pl} were determined experimentally (see: Sharobeam and Landes,[8] Bernal, Montemartini and Frontini,[11] Baldi, Agnelli and Riccò,[15] Baldi and Riccò[23]). Interestingly, the fitting curve passes very close to the theoretical point with S_{sb} = 1, that corresponds to a crack length in the sN specimen equal to the stationary crack length of the bN specimen.

The material deformation function, $H(u_{pl}/W)$, that characterizes the material during fracture propagation was then constructed – see equation (1). Following Sharobeam and Landes[8], it was built by referring to the normalized load, P_N, that was evaluated as:

$$P_N\left(\frac{u_{pl}}{W}\right) = \frac{P\left(\frac{u_{pl}}{W}\right)}{B \cdot W \cdot G\left(\frac{b}{W}\right)} \quad (A.4)$$

η_{pl} = 1.8 was used in the expression of G(b/W). Figure A.3 shows the values of P_N calculated at the final point of each sN specimen test record, plotted against the corresponding values of u_{pl}/W. A power law best fitting curve was forced to the experimental data points (this curve is

known as "material key curve", see Agnelli et al.[24]). In Figure A.3, the P_N vs u_{pl}/W curve obtained from the P vs u curve of the bN specimen, which exhibits only blunting, is also reported. Interestingly, the material deformation function during the fracture propagation phase has the same form as during the blunting phase, and this is the experimental verification of the assumption on which the LSC is founded.

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Table 1 – Supply-form of the materials examined and their basic mechanical properties (Young's modulus, E, and tensile yield stress, σ_y); nominal dimensions of SE(B) specimens used in the fracture tests; $J_{0.2}$ data

Material (RR)	**Supply-form**	**Basic mechanical properties[a]**		**SE(B) specimen dimensions[b]**			**$J_{0.2}$, kJ/m^2**
		E, MPa	**σ_y, MPa**	**B, mm**	**W, mm**	**a_0/W**	
HIPS (RR2)	injection moulded dumb-bells[c]	1760	18	4	10	0.6	2.84
ABS (RR2)	6 mm thick compression moulded plates	2500	44	6	12	0.6	5.71
RT-PBT (RR3)	injection moulded dumb-bells[c]	1450	31	4	10	0.6	6.58
LLDPE[d] (RR3)	10 mm thick injection moulded plates	250	8	10	10 (#a) 20 (#b)	0.6	-[e]

Note:
[a]From quasi-static tests at room temperature.
[b]B, thickness; W, width; a_0, initial crack length (in bN specimen, notch tip radius of 1 mm); span used in fracture tests, S = 4W [ref. to figure (1)]
[c]According to ISO 3167:2014 *Plastics -- Multipurpose test specimens*; central narrow portion (with dimensions 80x10x4 mm^3) used for SE(B) specimen preparation.
[d]Two sets of SE(B) specimens (#a and #b) used.
[e]Not measured (J_R curve not constructed).

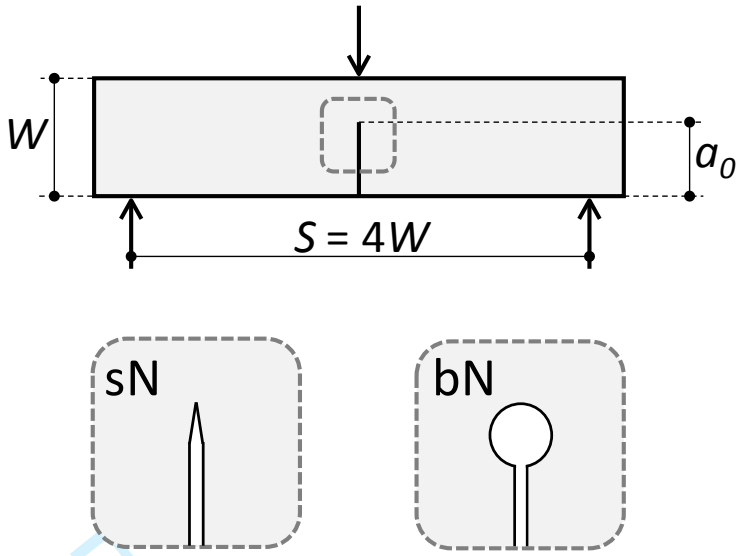

Figure 1 – Schematic representation of a SE(B) specimen. *S* is the span. Sharp (of a sharp-notched, sN, specimen) and blunt (of a blunt-notched, bN, specimen) notches are also represented; the blunt notch is of key-hole type.

A

$J_{I,lim,m}$ [kJ/m²]				
-	-	4.6 ± 1.03 (22%)	4.09* ± 0.630 (15%)	1.53* ± 0.251 (16%)

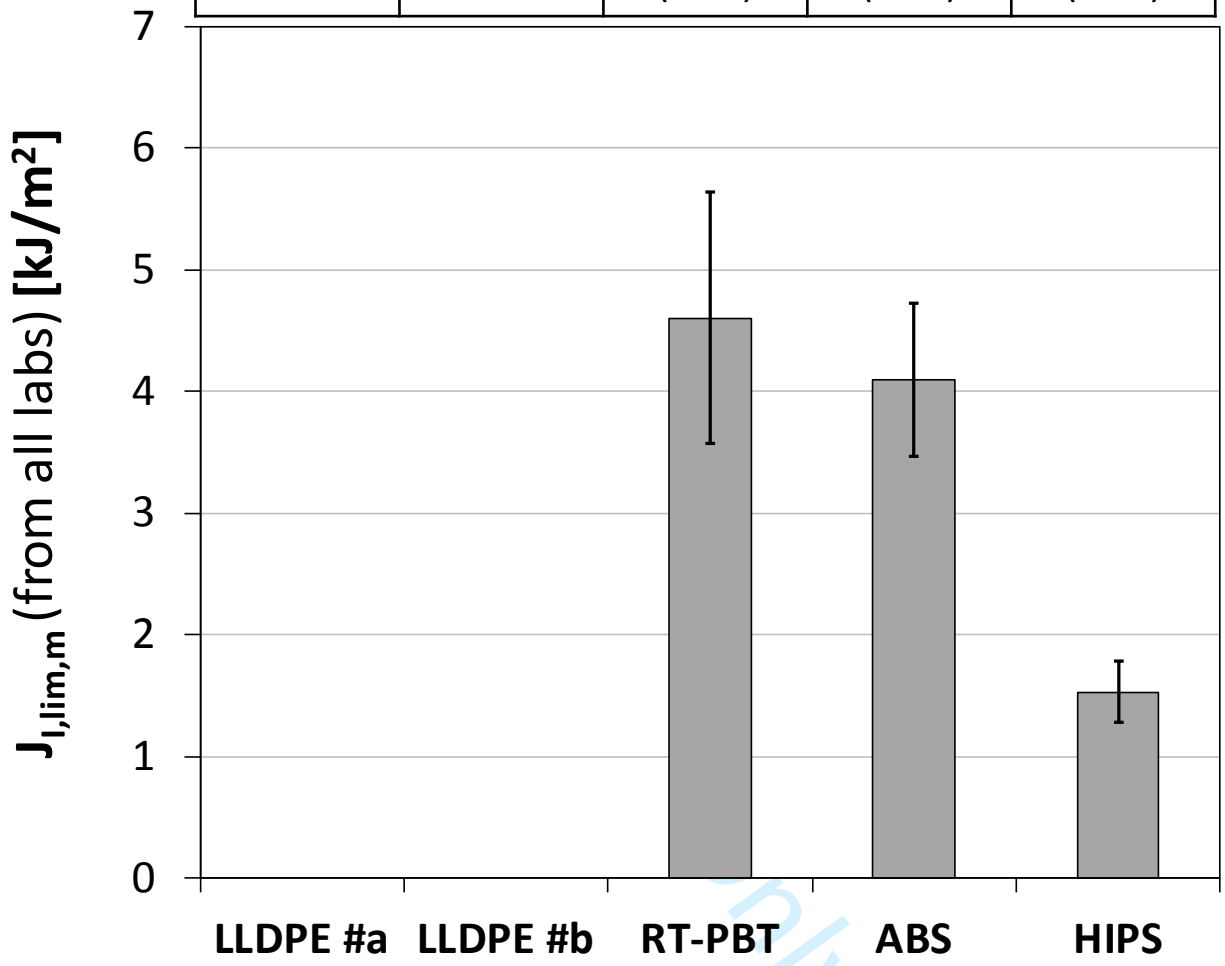

Figure 2*A*

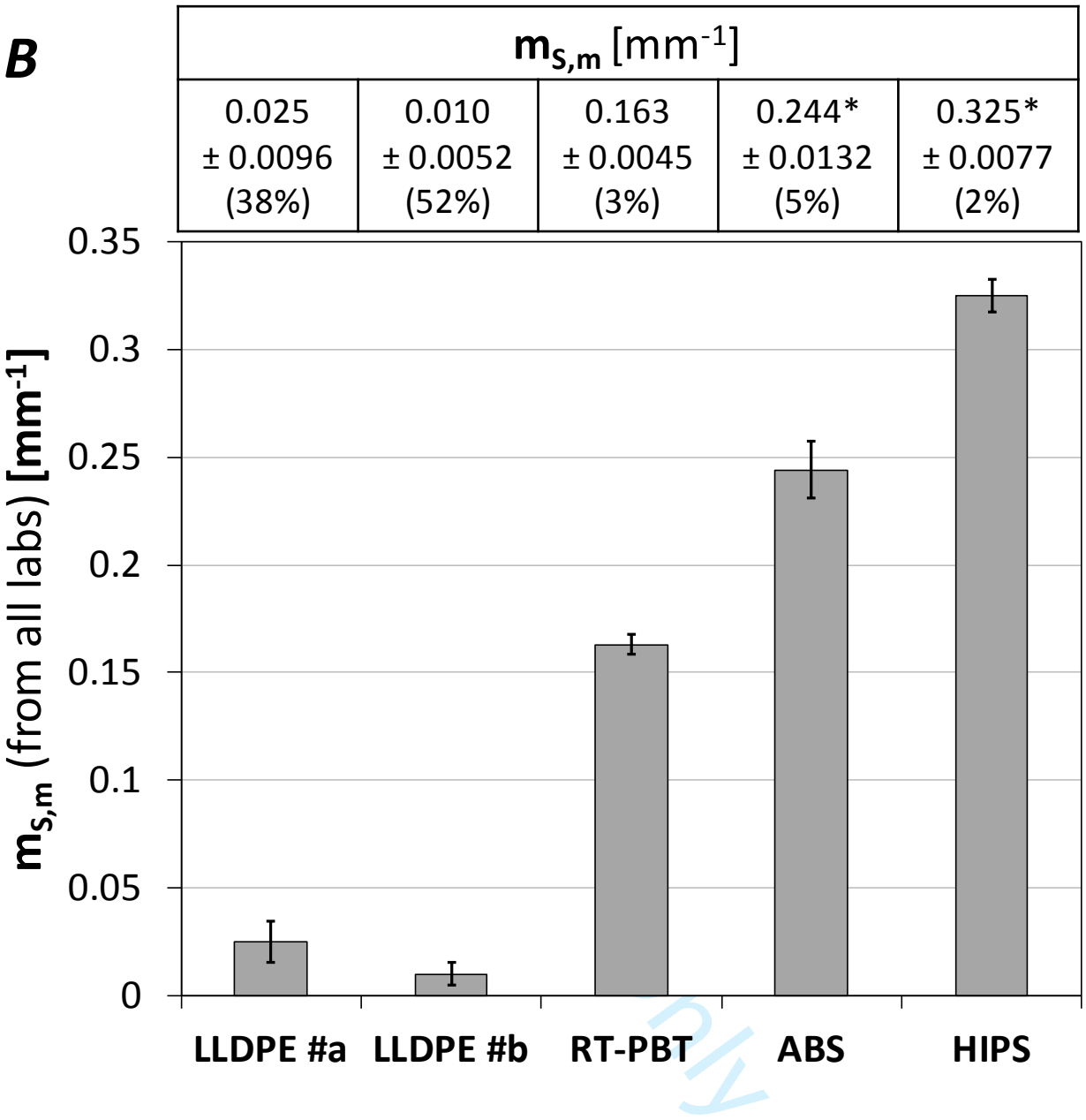

Figure 2*B*

Figure 2 – Mean values (± standard deviation) of (*A*) $J_{I,lim}$ and (*B*) m_S for the various materials examined, obtained by averaging all the (mean) data from the various laboratories (ref. to Table 1 for the dimensions of the specimens). Values in brackets indicate the standard deviation expressed as percentage of the corresponding mean value. For LLDPE valid $J_{I,lim}$ data could not be obtained (see text). Data with an asterisk are from Agnelli et al.[4]

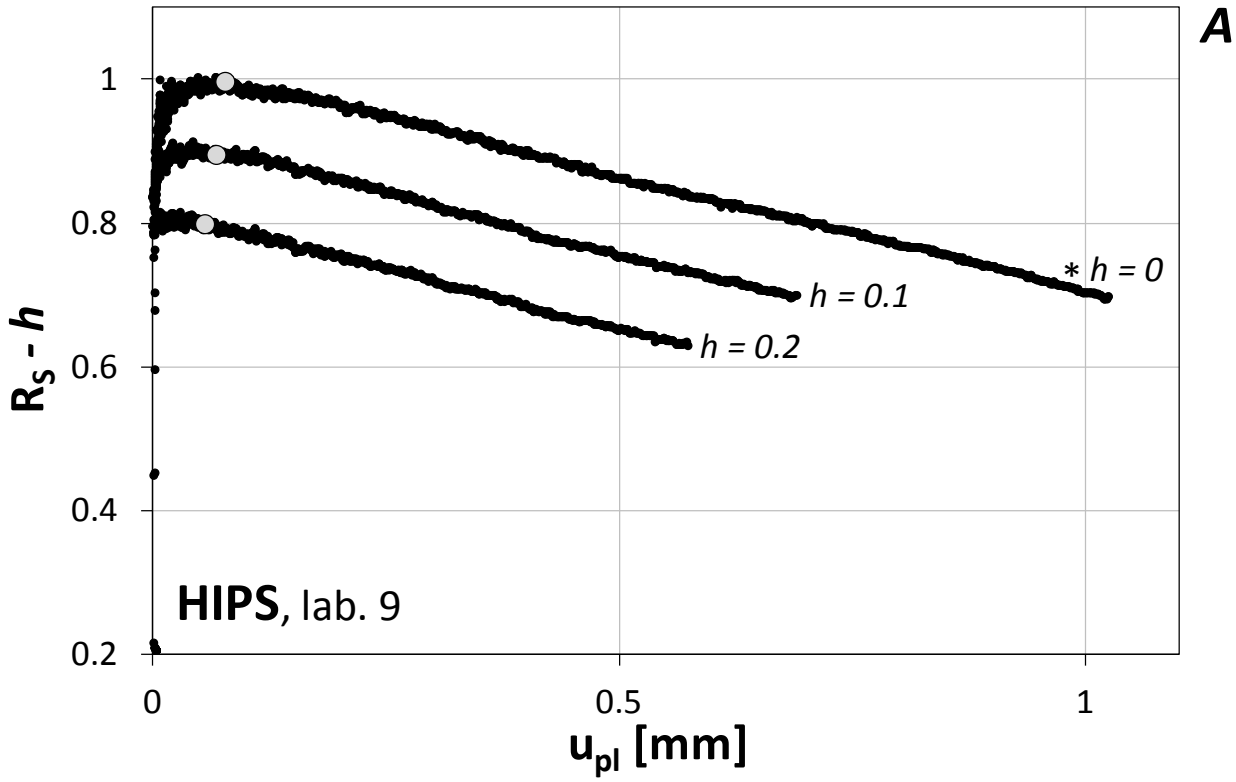

Figure 3*A*

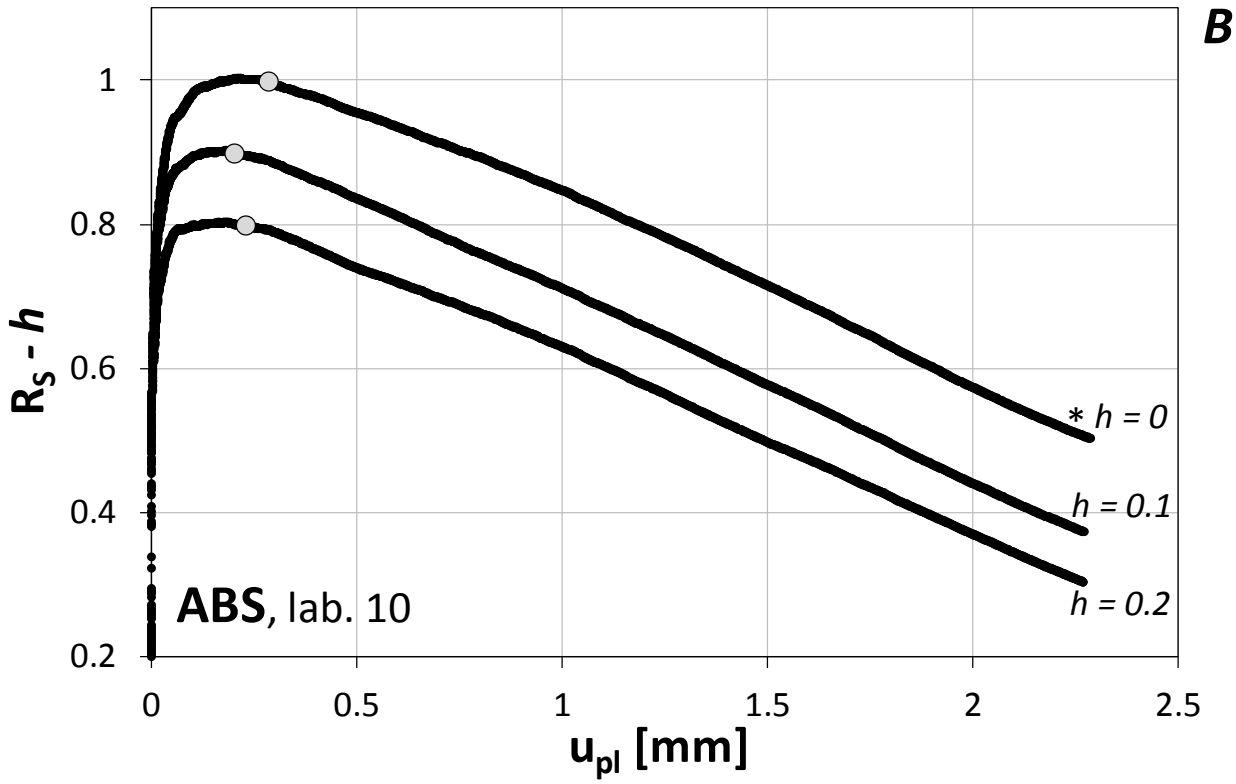

Figure 3*B*

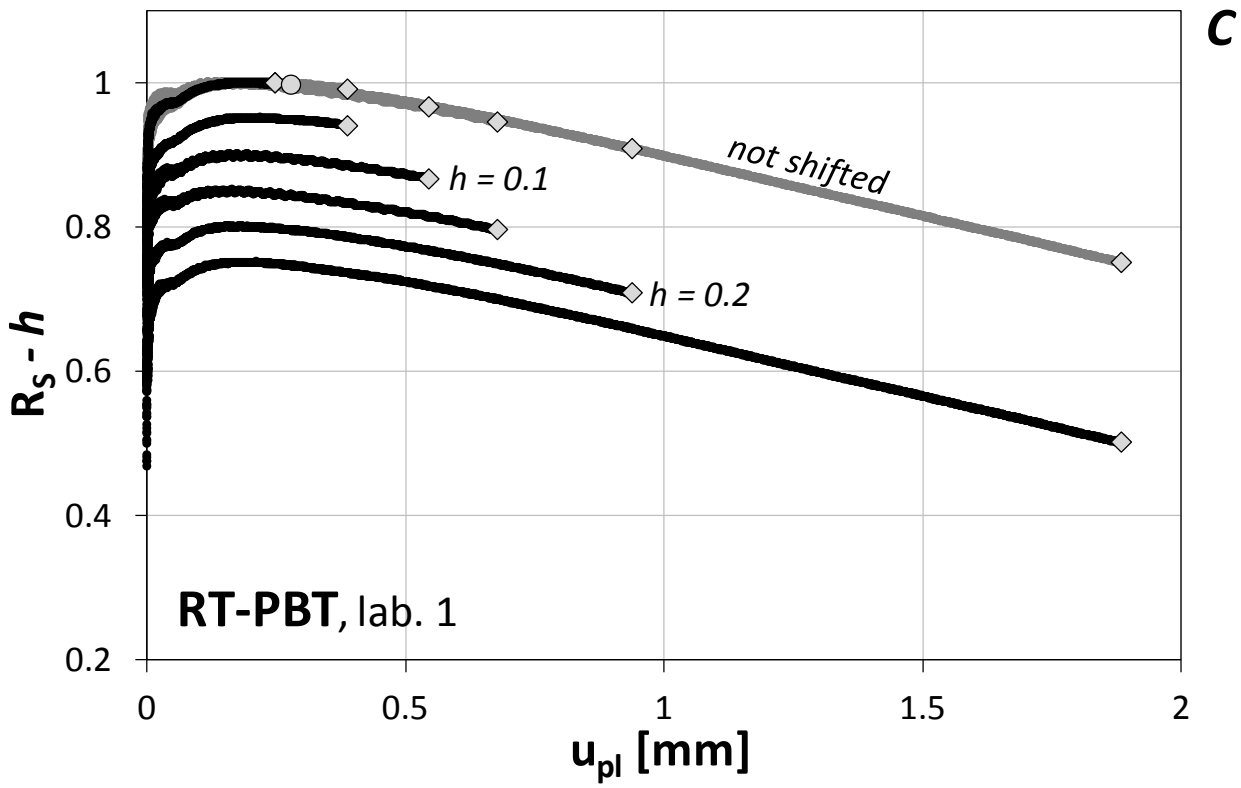

Figure 3*C*

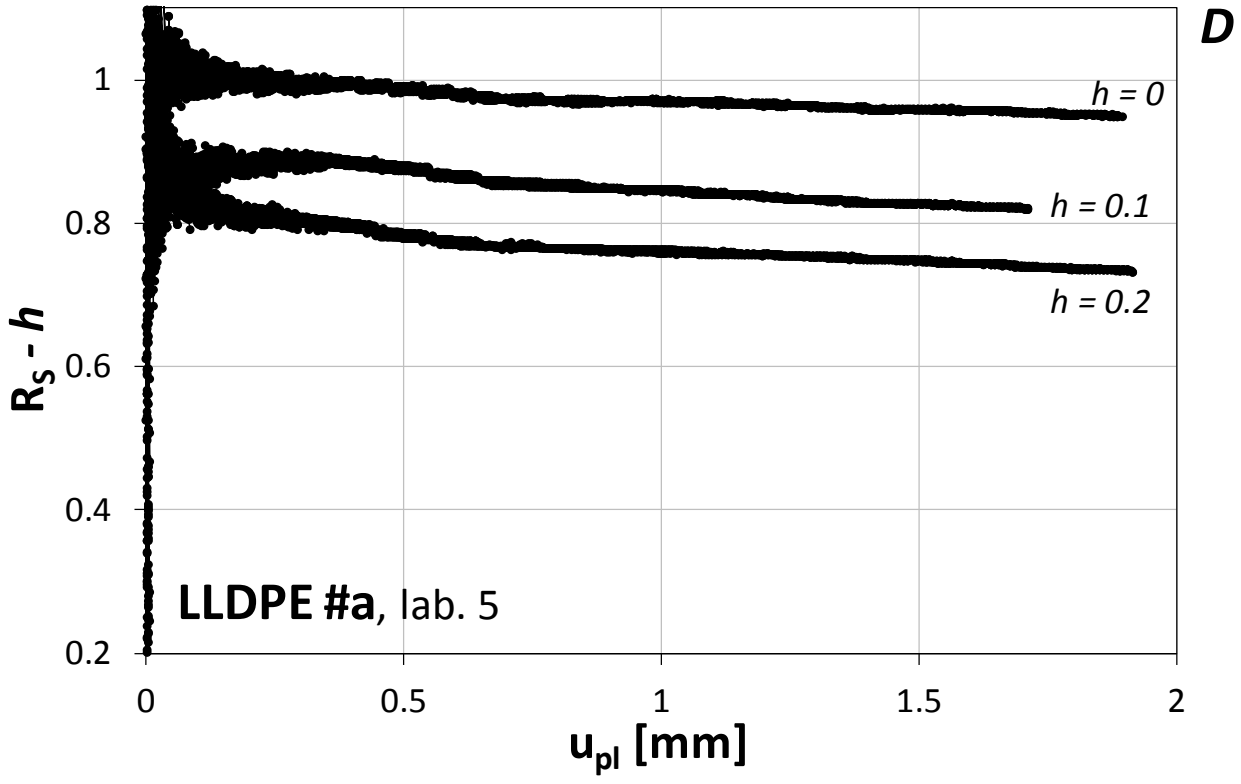

Figure 3*D*

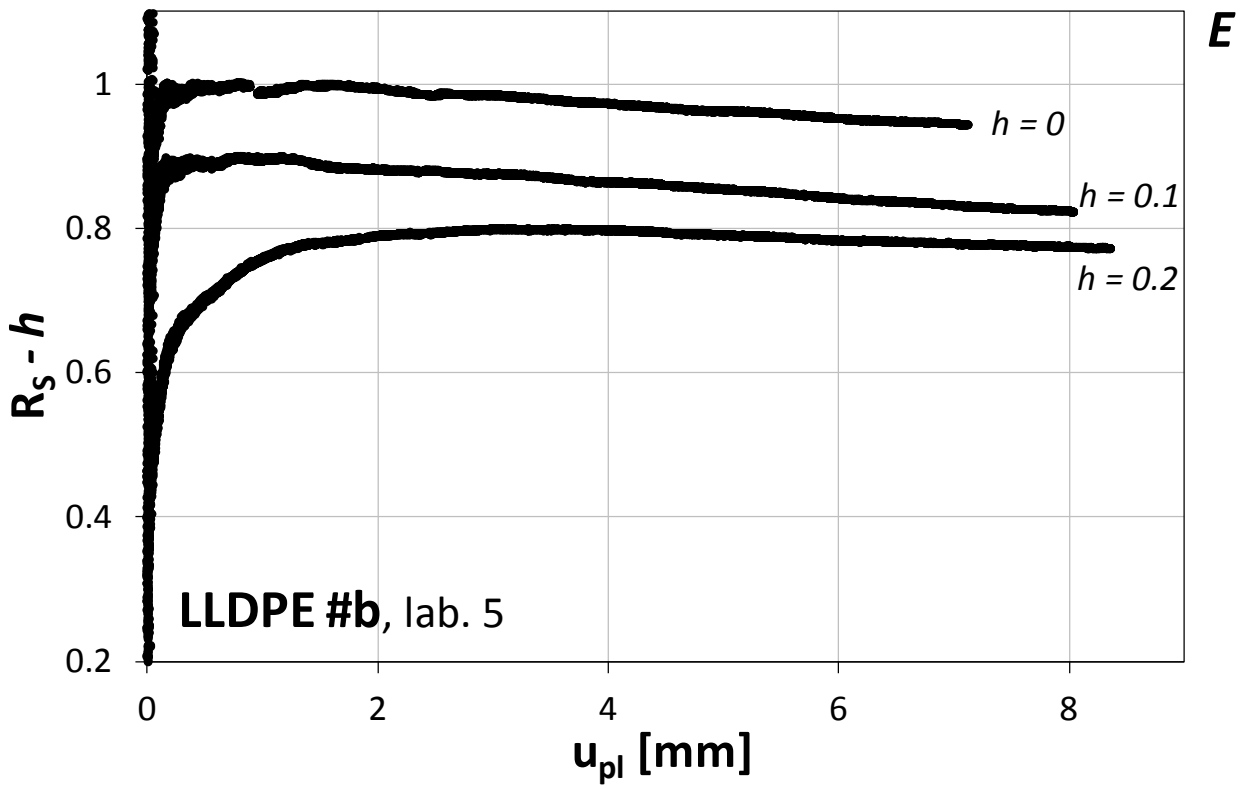

Figure 3*E*

Figure 3 – R_S curves of different nominally identical sN specimens of: (*A*) HIPS, from lab. 9; (*B*) ABS, from lab. 10; (*C*) RT-PBT, from lab. 1; (*D*) and (*E*) LLDPE, #a and #b, respectively, from lab. 5. The curves are vertically shifted by an *h*-factor. In (*A*), (*B*) and (*C*), grey circle indicates the limit point. In (*C*), the curves are represented also as not shifted (in grey); rhomb indicates the final point (that is the point at which the test was interrupted). See text for the asterisk in (*A*) and (*B*).

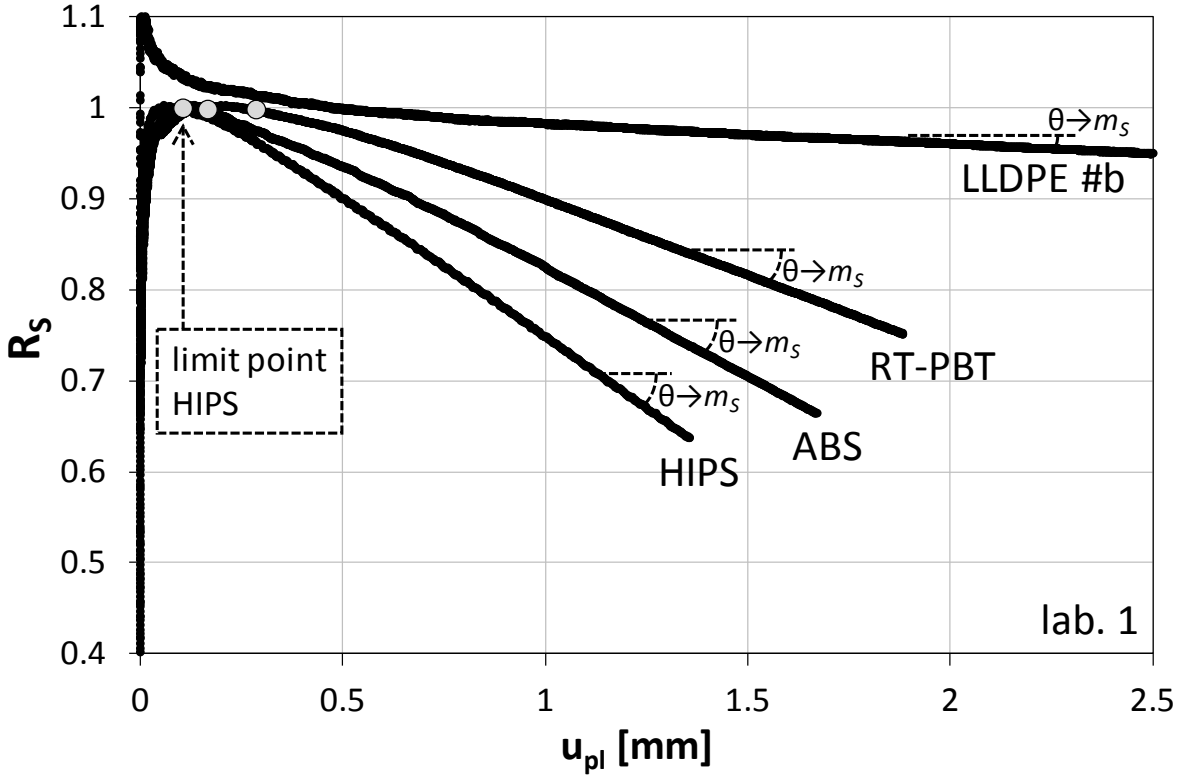

Figure 4 – R_S curves obtained, at lab. 1, from the fracture tests on the various materials examined (one curve for each material; ref. to Table 1 for the dimensions of the specimens). Grey circle indicates the limit point on the R_S curves of HIPS, ABS and RT-PBT. For each curve, m_S is also represented.

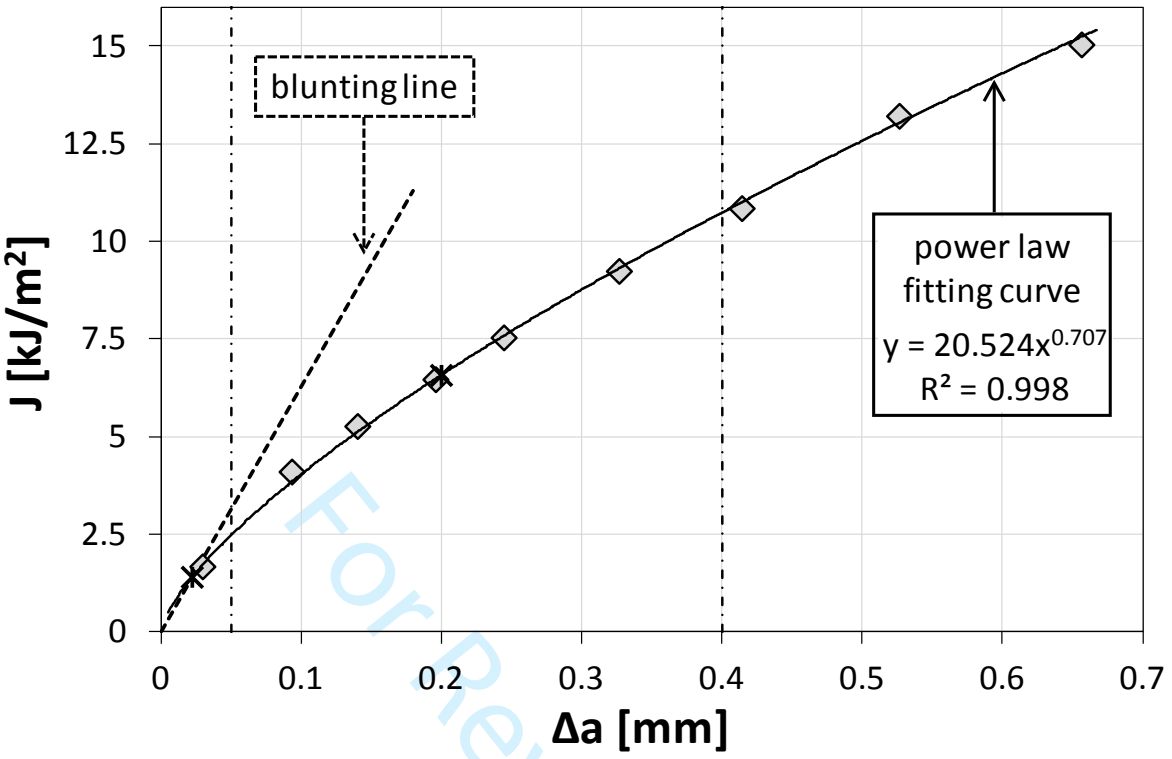

Figure A.1 – J_R curve of RT-PBT, constructed according to the ESIS TC4 procedure.[1] The experimental (Δa; J) data points (rhomb), the power law best fitting curve (solid line), the exclusion lines (vertical dash-dot lines), the blunting line (dashed line) and the points on the fitting curve corresponding to J_{bl} and $J_{0.2}$ (asterisk) – see text – are indicated. The equation of the power law best fitting curve and the correlation coefficient of the fitting (R^2) are also reported.

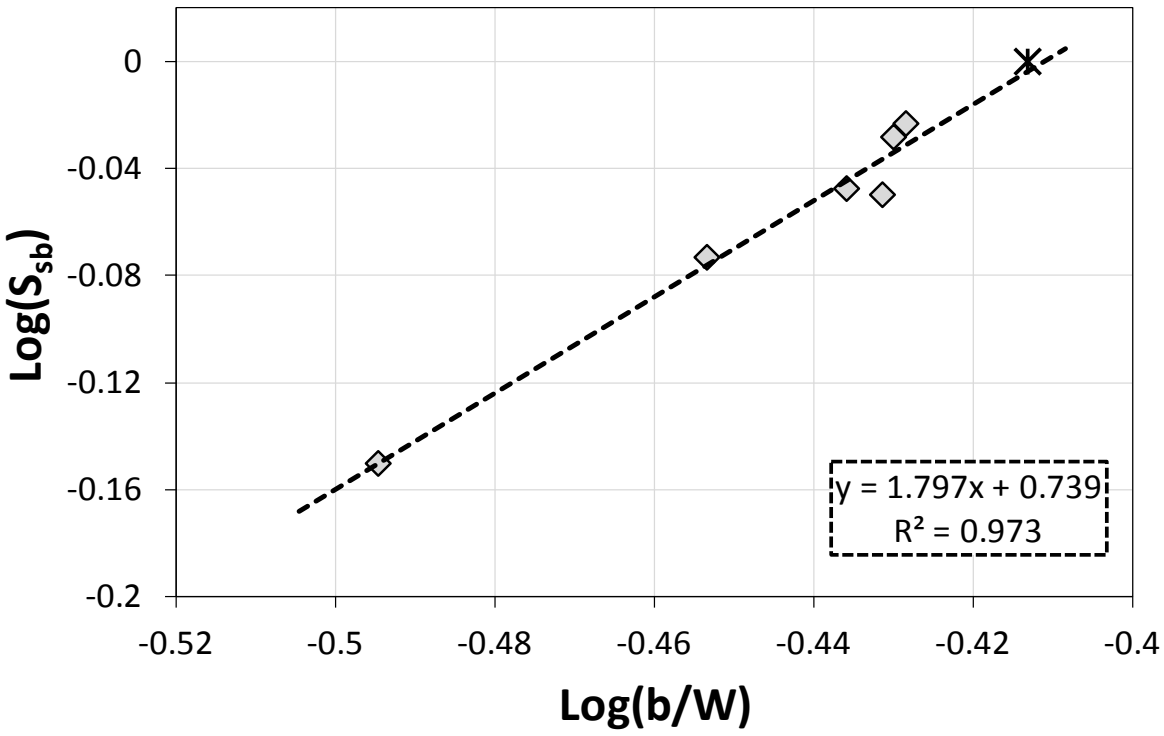

Figure A.2 – Separation parameter, S_{sb}, evaluated at the final point of each sN specimen test record of RT-PBT examined (R_S curves in figure 3*C*), plotted against the corresponding value of the actual remaining ligament length divided by the specimen width, *b/W* (rhomb). Dashed line indicates the power law best fitting curve forced to the experimental (*b/W*; S_{sb}) data at final points. The theoretical point with $S_{sb} = 1$ (asterisk) – see text – is indicated. The equation of the fitting curve and the correlation coefficient of the fitting (R^2) are also reported.

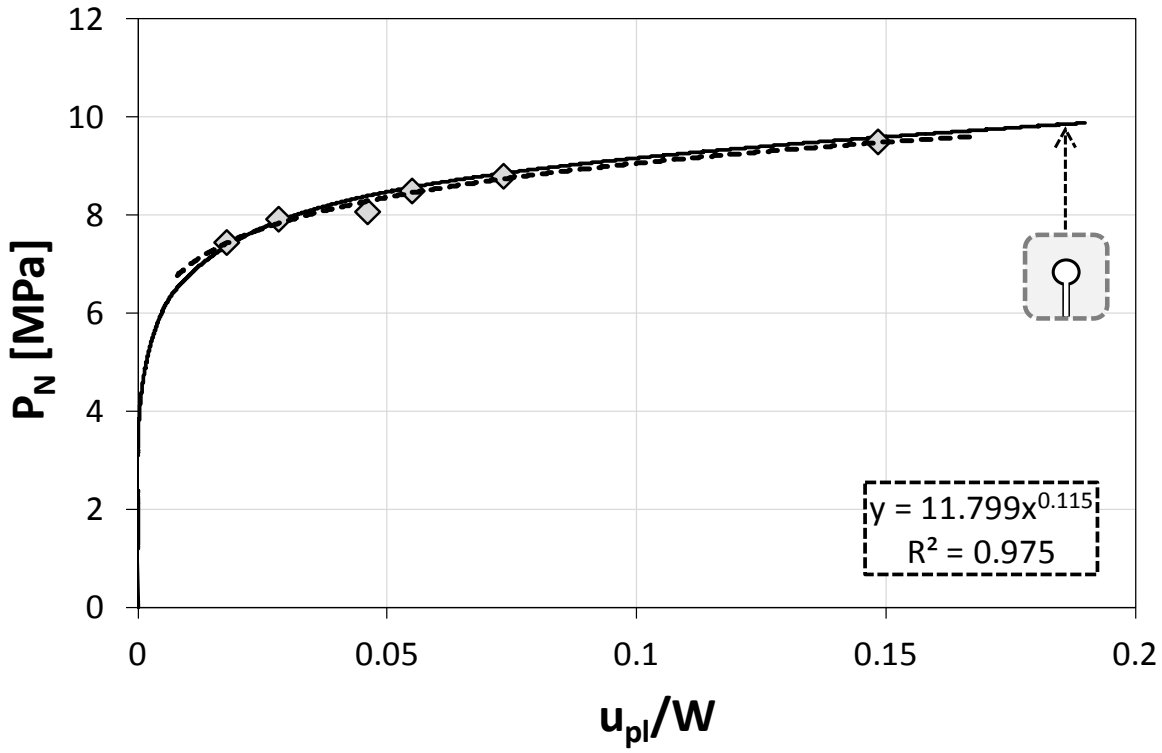

Figure A.3 – Normalized load, P_N, calculated at the final point of each sN specimen test record of RT-PBT examined (R_S curves in figure 3*C*), plotted against the corresponding value of u_{pl}/W (rhomb). Dashed line indicates the power law best fitting curve forced to the experimental (u_{pl}/W; P_N) data, whose equation and correlation coefficient (R^2) are also reported. Solid line indicates the P_N vs u_{pl}/W curve obtained from the bN specimen of RT-PBT.