



**International
Standard**

ISO 5603

**Rubber, vulcanized — Determination
of adhesion to wire cord**

*Caoutchouc vulcanisé — Détermination de l'adhérence à un câble
métallique*

**Fifth edition
2024-04**

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Contents

Page

Foreword	iv
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Principle	2
5 Materials	2
6 Apparatus	2
7 Calibration	9
8 Test piece	9
8.1 Form	9
8.2 Dimensions	11
8.3 Preparation	11
8.3.1 General	11
8.3.2 Method 1	11
8.3.3 Method 2	12
8.3.4 Both methods	12
9 Procedure	12
10 Expression of results	14
11 Test report	14
Annex A (normative) Calibration schedule	15

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 document 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).

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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 45, *Rubber and rubber products*, Subcommittee SC 2, *Testing and analysis*.

This fifth edition cancels and replaces the fourth edition (ISO 5603:2017), which has been technically revised.

The main changes are as follows:

- the normative references have been updated.

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.

Rubber, vulcanized — Determination of adhesion to wire cord

WARNING 1 — Persons using this document should be familiar with normal laboratory practice. 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 national regulatory conditions.

WARNING 2 — Certain procedures specified in this document might involve the use or generation of substances, or the generation of waste, that could constitute a local environmental hazard. Reference should be made to appropriate documentation on safe handling and disposal after use.

1 Scope

This document specifies two methods for determining the adhesion strength of vulcanized rubber to wire cord which is embedded in the rubber.

The two methods do not necessarily give the same results.

They are applicable primarily to test pieces prepared in the laboratory under standard conditions and used for the development and control of materials and processes utilized in the manufacture of products reinforced with wire cord.

NOTE The methods can also be used for single wire, for example bead wire.

Method 1 reduces the dependence of the measured adhesion on the modulus and strength properties of the rubber.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 2393, *Rubber test mixes — Preparation, mixing and vulcanization — Equipment and procedures*

ISO 5893, *Rubber and plastics test equipment — Tensile, flexural and compression types (constant rate of traverse) — Specification*

ISO 18899:2013, *Rubber — Guide to the calibration of test equipment*

ISO 23529, *Rubber — General procedures for preparing and conditioning test pieces for physical test methods*

3 Terms and definitions

No terms and definitions are listed in this document.

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/>

4 Principle

The adhesion strength is determined by measuring the force required to pull out a single cord from the surrounding rubber of a prepared test piece. The force is directed along the axis of the cord, using a test jig containing a suitably chosen circular- or square-shaped hole to ensure uniformity of stress.

Test pieces of cord and rubber are prepared together by vulcanizing them under pressure.

In method 1, the exterior surface of the rubber is suitably reinforced.

In method 2, such reinforcement is not employed.

5 Materials

5.1 Wire cord, conforming to the specification of the bonding system to be investigated. If no specification is given, brass-plated steel cord of construction $(1 \times 3 \times 0,15) \text{ mm} + (6 \times 0,27) \text{ mm}$ or of construction $(7 \times 4 \times 0,22) \text{ mm}$ shall be used.

NOTE The sizes of the cords are defined here in terms of their diameter and the number of component wires, starting from the centre core of the cord.

For quality control of cord, it shall be tested in the condition received, i.e. neither cleaned nor dried.

It is essential that the wire cord be stored in a dry atmosphere to prevent any surface deterioration. Storage can conveniently be carried out in an airtight container which also contains a desiccating material (for example, silica, SiO_2). The container shall only be opened when removing wire cord and shall then be closed immediately. It is also essential that the cord not be contaminated with dust from the desiccating material.

5.2 Unvulcanized rubber compound, conforming to the specification of the bonding system to be investigated. Whenever possible, the rubber shall be freshly milled. If for any reason the rubber cannot be remilled, the surface shall be freshened by wiping with a solvent and allowed to dry. The preferred solvent is heptane, but a suitable alternative could be a petroleum solvent with a distillation range of about 65°C to 125°C ; these solvents shall possess a maximum residue on evaporation of $3 \text{ mg per } 100 \text{ cm}^3$ of solvent. The compound shall be stored at a standard laboratory temperature of $(23 \pm 2)^\circ\text{C}$ or $(27 \pm 2)^\circ\text{C}$ prior to use. It can be in the form of a calendered sheet of suitable thickness and shall be protected by a dark-coloured polyethylene film.

5.3 Reinforcement material, to stiffen the rubber block. This applies only to method 1. The reinforcement can either be a sheet metal strip treated with adhesive promoter (when the thickness t is at least $0,5 \text{ mm}$) or a strip of rigid rubberized steel cord fabric. A suitable fabric is one containing steel cords of high bending stiffness, for example, one of construction $(1 \times 3 \times 0,30) \text{ mm} + (6 \times 0,38) \text{ mm}$ [when the thickness t is $(2,5 \pm 0,1) \text{ mm}$ maximum].

6 Apparatus

6.1 Mould, capable of producing a test piece in which a multiplicity of cords is embedded equally spaced along its length. Different moulds are employed for the two methods.

a) Method 1

The mould is of a semi-follow-on type to obtain maximum consolidation of rubber around the cord during the pressing stage, but thereafter becomes a fixed-cavity mould.

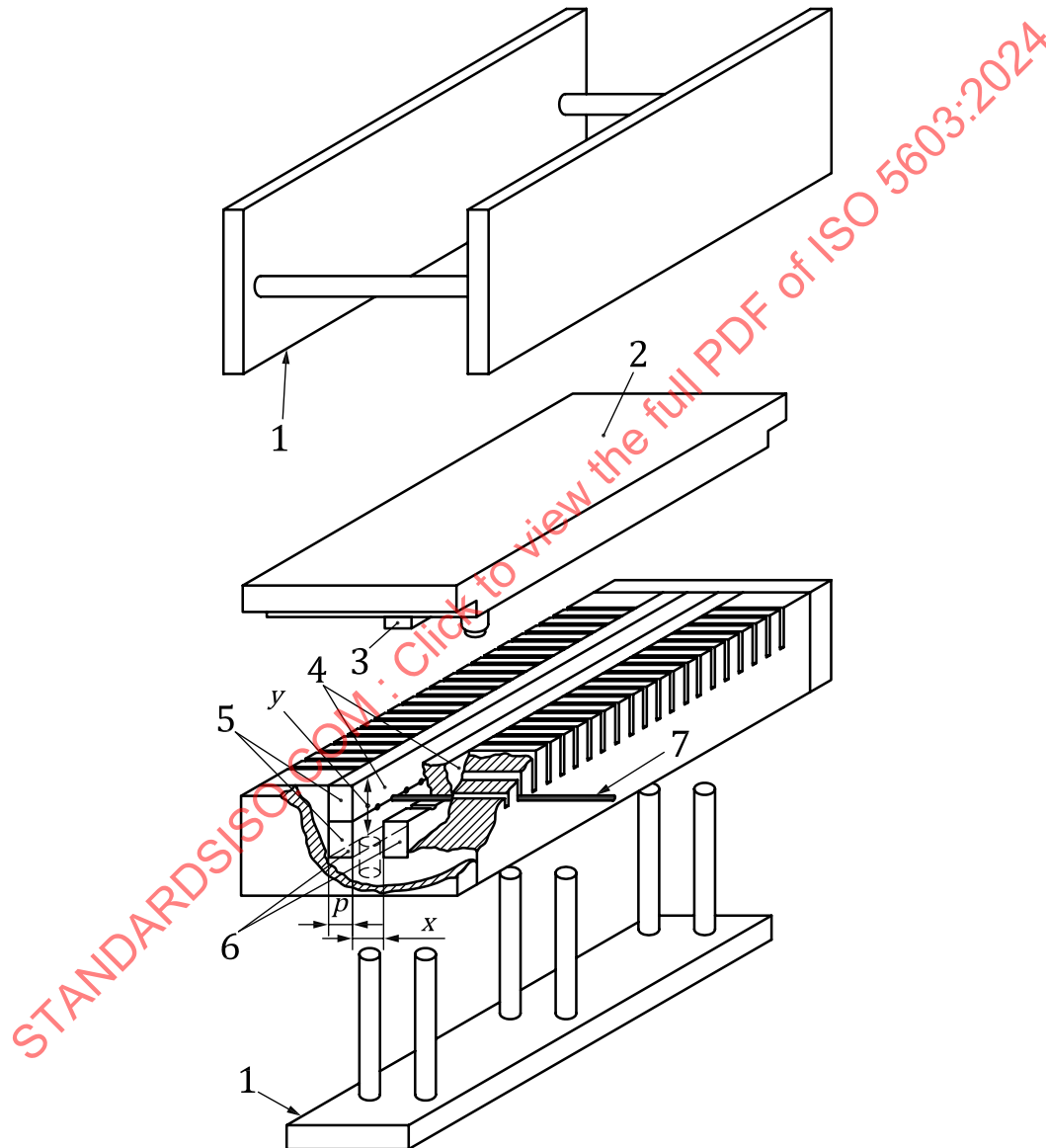
One suitable mould designed to accommodate steel cord fabric reinforcement is shown in [Figure 1](#). This mould produces test pieces of length 310 mm containing 21 cords, but similar moulds employing other numbers of cords greater than nine are acceptable. The mould dimension x will depend on the embedded length of test piece required (which is governed by the diameter of wire cord used, see [8.2](#)). The mould shall

be provided with pairs of inserts or spacers to obtain the different lengths of cord embedment. Dimension y is sufficiently great to allow the incorporation of excess rubber during moulding (see 8.3.1).

Another suitable mould designed to accommodate steel strip reinforcement is shown in Figure 2. A tensioning device for the cords can be used with this mould. Figure 3 details some mould dimensions and describes the exchangeable steel spacers which are required for different cord sizes for the moulds shown in Figures 1 and 2.

Any mould producing test pieces of the correct dimensions and applying the moulding force directly on to the rubber, for example by use of a suitable spring, is also acceptable.

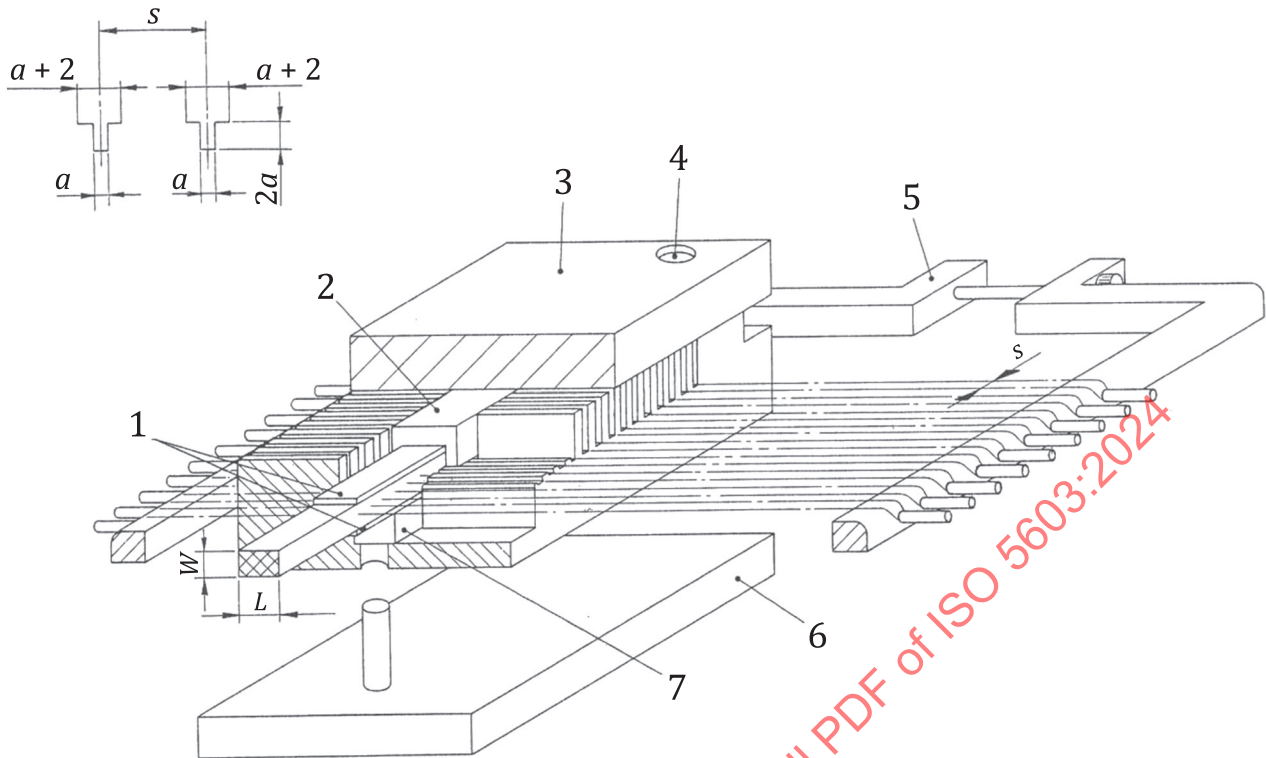
If desired, the moulds can impart suitable features on to the moulded test piece to facilitate cord centring during subsequent testing.



Key

- | | | | |
|---|--------------------|---|-----------------------|
| 1 | extraction tool | 5 | pair of steel spacers |
| 2 | semi-follow-on lid | 6 | bottom spacers |
| 3 | ram | 7 | steel cord |
| 4 | top spacers | | |

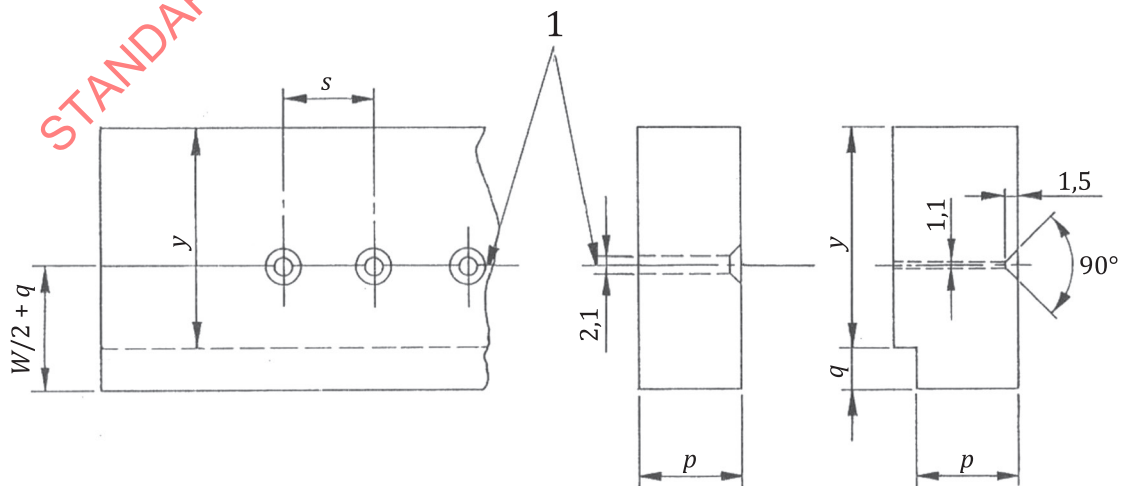
Figure 1 — Layout of one type of semi-follow-on mould and its extraction tools for method 1



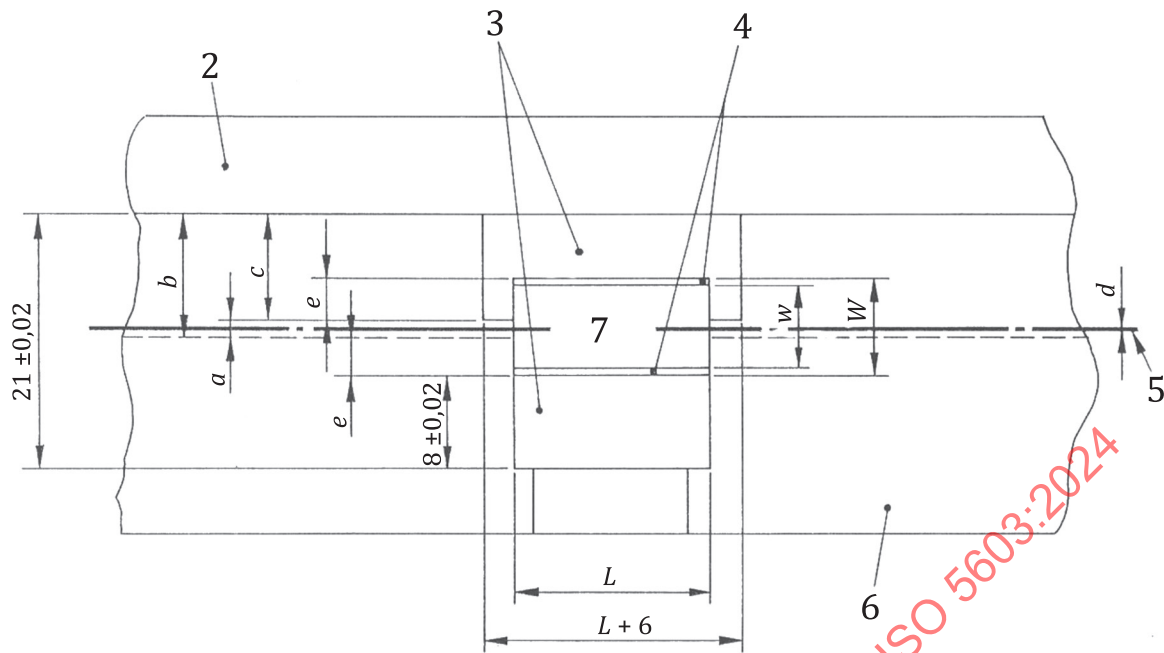
Key

- 1 metal reinforcement sheets (thickness t)
- 2 upper ledge/spacer
- 3 cover plate
- 4 centring bolts
- 5 tensioning frame
- 6 extraction tool
- 7 lower edge
- a Detail of cross-section of slot (for dimension a , see [Figure 3](#)).

Figure 2 — Layout of a second type of semi-follow-on mould and its extraction tool for method 1



a) Spacers for the mould in [Figure 1](#)

b) Exchange ledges/spacers for the mould in [Figure 2](#)

Cord diameter d	Details of ledge chosen			
	a	b	c	e
$\geq 0,5$ but $< 0,7$	$0,7 \pm 0,02$	$9,85 \pm 0,2$	$9,15 \pm 0,02$	$3,15 \pm 0,02$
$\geq 0,7$ but $< 1,0$	$1,0 \pm 0,02$	$10,0 \pm 0,2$	$9,0 \pm 0,02$	$3,0 \pm 0,02$
$\geq 1,0$ but $< 1,4$	$1,4 \pm 0,02$	$10,2 \pm 0,2$	$8,8 \pm 0,02$	$2,8 \pm 0,02$
$\geq 1,4$ but $< 1,7$	$1,8 \pm 0,02$	$10,4 \pm 0,2$	$8,6 \pm 0,02$	$2,6 \pm 0,02$

$$a = b - c \quad \text{is the slot width}$$

$$b \quad \text{is the slot depth}$$

$$2e + a = w + 2t = W$$

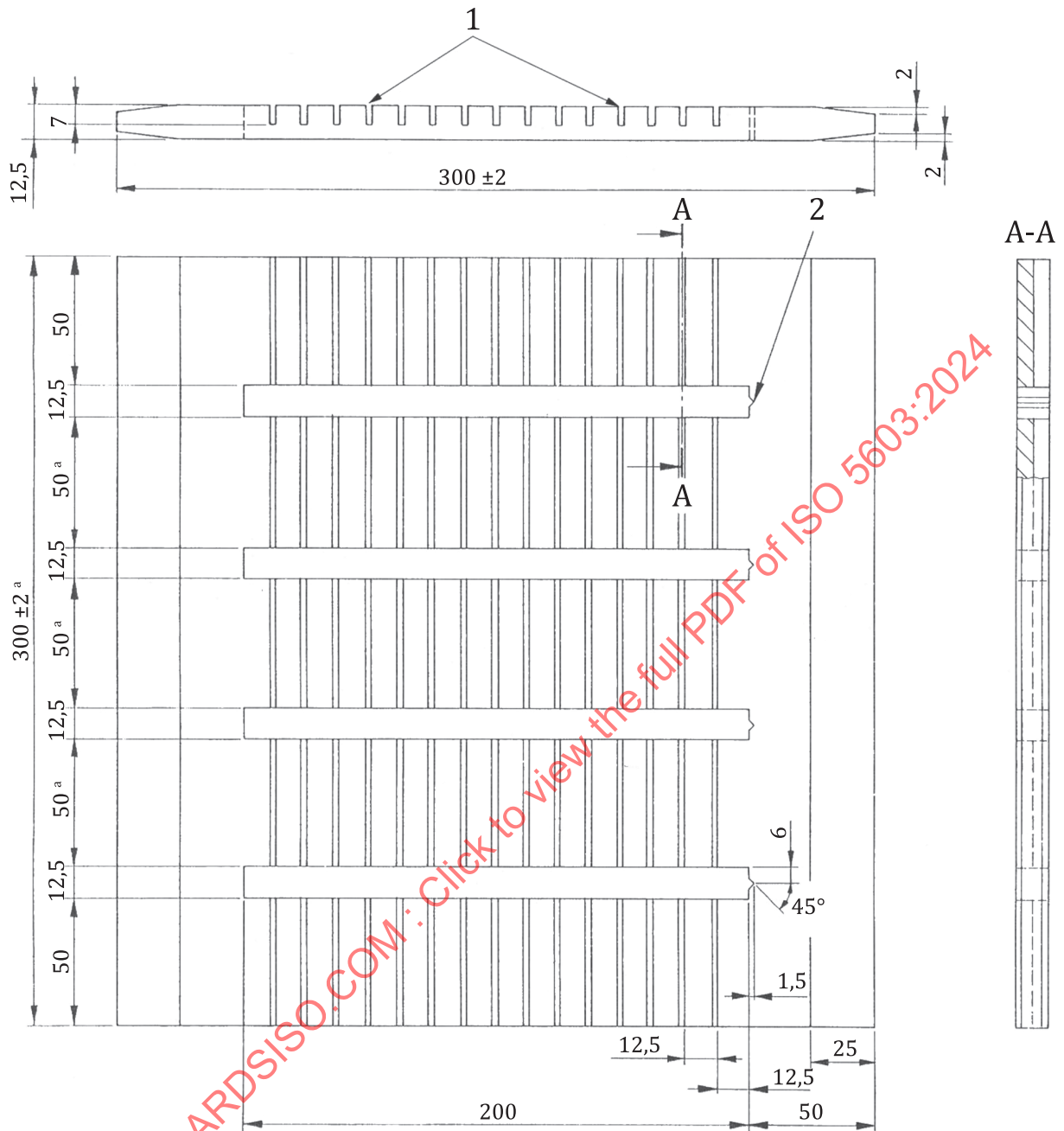
$$e = 21 - (b + 8) = 13 - b$$

Key

- | | | | |
|---|---|---|-----------------|
| 1 | split line | 5 | cord |
| 2 | cover plate | 6 | main mould body |
| 3 | ledges/spacers | 7 | rubber |
| 4 | metal reinforcement sheets (thickness t) | | |

Figure 3 — Details of spacers used in the two types of semi-follow-on mould for method 1**b) Method 2**

The mould is described in [Figures 4](#) and [5](#). The mould is designed to produce four test blocks (each of length 200 mm) with the preferred dimensions (see [8.2](#)), each containing 15 steel cords. When testing cords with a diameter equal to or less than 1,7 mm, the mould in [Figures 4](#) and [5](#) shall be used to produce blocks and, when testing cords with a diameter greater than 1,7 mm, the mould shall be suitably modified. If more than one-third of the cords break at the 12,5 mm embedment, it is advisable to reduce the embedment by use of a suitable mould insert. Moulds designed to produce any other number of test blocks of the required dimensions are acceptable, and moulds designed to produce blocks with different embedded cord lengths are permitted.

**Key**

- 1 15 slots (1,8 ± 0,1) mm wide
- 2 identification number

Tolerances (except where otherwise stated):

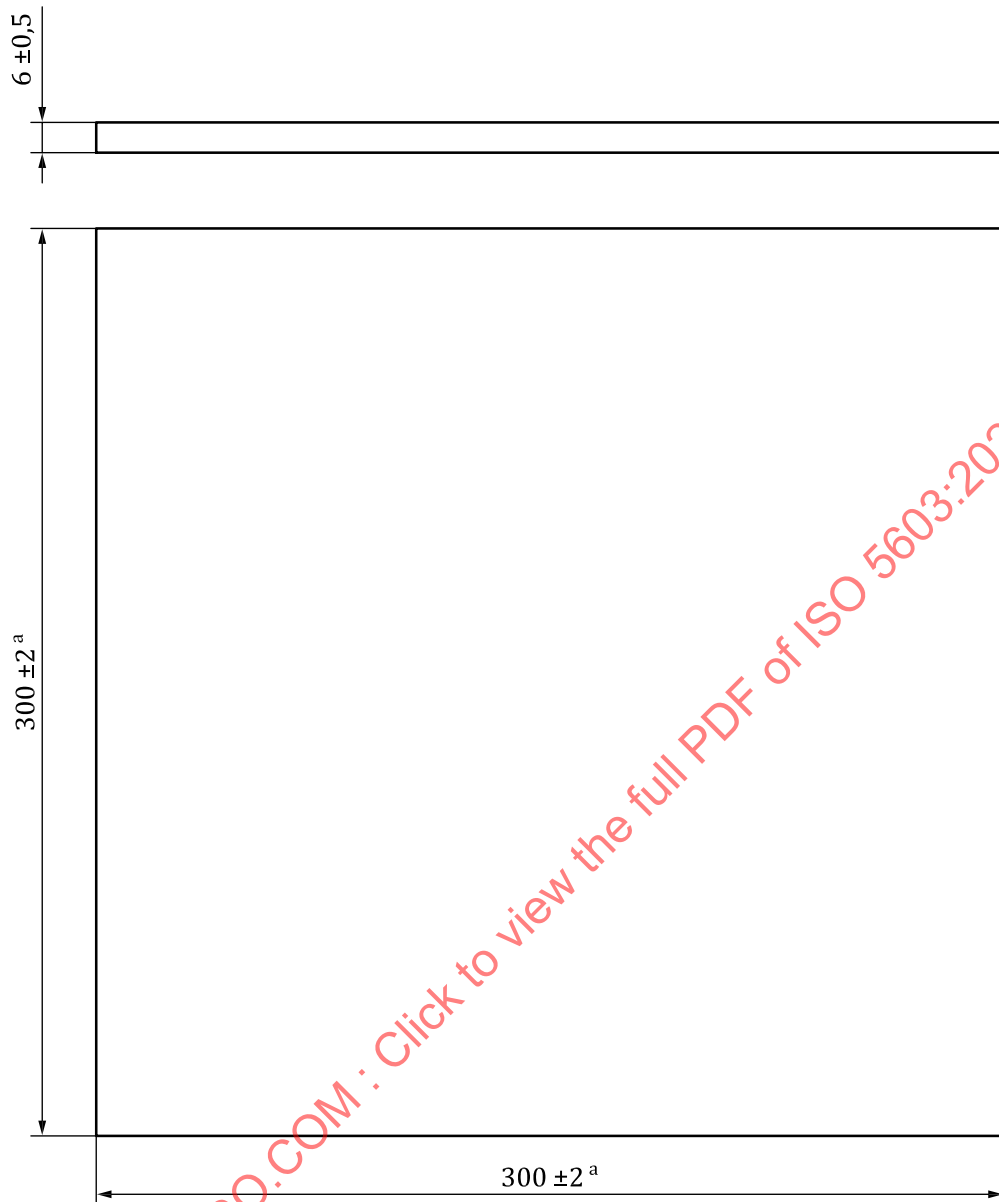
dimensions ±0,2;

angles ±2°

NOTE 1 The material is mild steel, it can be flash chrome-plated.

NOTE 2 Dimensions marked with an asterisk (*) can be altered to accommodate the test grips.

Figure 4 — Mould for method 2



NOTE 1 The material is mild steel.

NOTE 2 Number required: 2.

NOTE 3 Dimensions marked with an asterisk (*) can be altered to accommodate the test grips.

Figure 5 — Mould for method 2

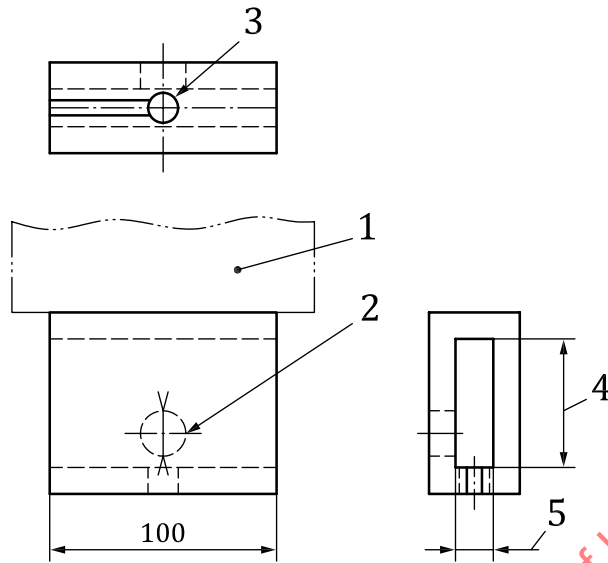
6.2 Vulcanizing press, large enough to take the mould. It shall conform to the requirements of ISO 2393 and shall be capable of applying a force of at least 100 kN.

6.3 Tensile-testing machine, conforming to the requirements of class 1 as defined in ISO 5893. It shall be capable of maintaining a rate of separation of the jaws at a constant value within the range 50 mm/min to 150 mm/min.

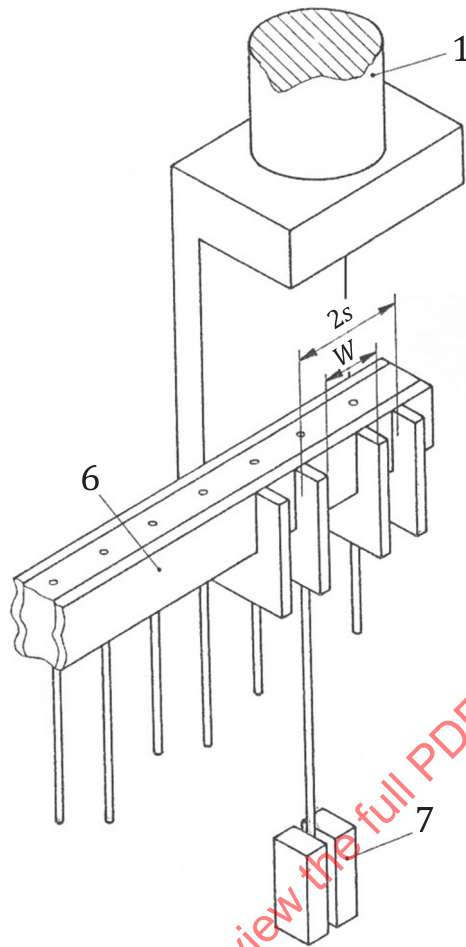
6.4 Fixture, for holding the test piece in the test machine. It shall possess a suitable slot to allow the test cord to reach the test hole: the hole dimensions shall depend on the test piece type (see 8.2). The fixture shall laterally support the test piece in a slide-fit and shall permit accurate centring of the applied load (i.e.

cord position) during testing. If desired, the fixture can possess particular features to facilitate the centring of the test cord in the test hole. Suitable types of fixture are depicted in [Figure 6](#).

Dimensions in millimetres



a) Fixture with circular hole



b) Fixture for testing with square hole, showing test arrangement

Key

- | | | | |
|---|---|---|------------------------------|
| 1 | to fit one jaw of tensile-testing machine | 5 | to suit test piece width W |
| 2 | optional lateral hole with centring marks | 6 | test piece |
| 3 | slotted hole (diameter h) | 7 | cord clamp to fit second jaw |
| 4 | to suit dimension L | | |

Figure 6 — Typical fixtures

6.5 Jaws, for gripping the cord to be extracted in the test machine. These can be of the wedge, pneumatic, pneumatic/hydraulic or bollard type, arranged so that the force applied to the cord during testing is normal to the face of the test piece.

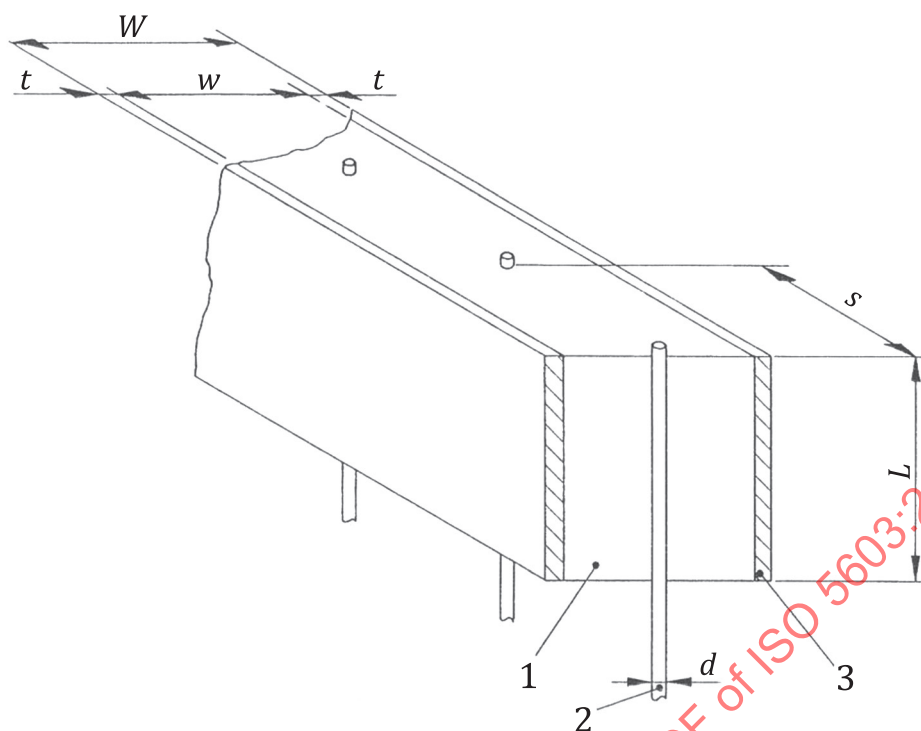
7 Calibration

The test apparatus shall be calibrated in accordance with [Annex A](#).

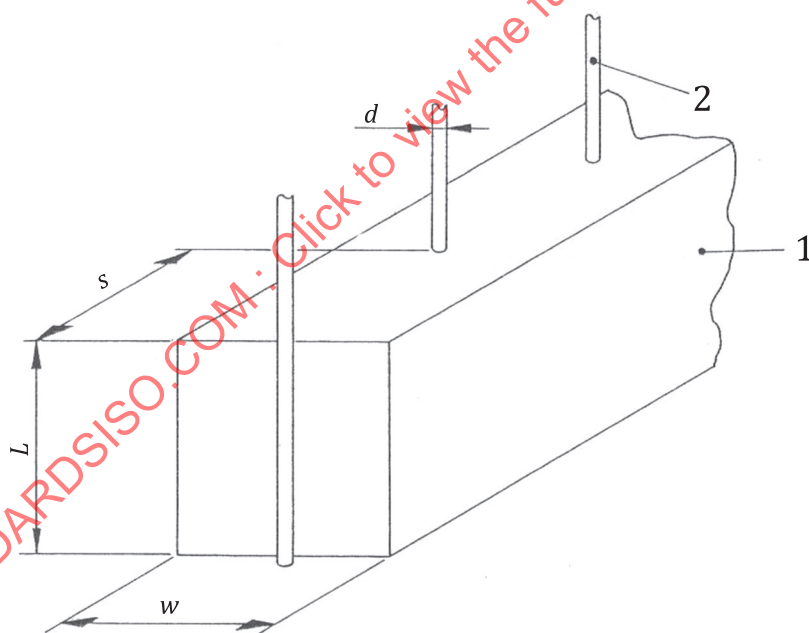
8 Test piece

8.1 Form

The test piece shall have one of the general forms shown in [Figure 7](#).



a) Method 1



b) Method 2

Key

- 1 rubber
- 2 wire cord
- 3 reinforcement strip of sheet metal or steel cord fabric

Figure 7 — Test pieces

8.2 Dimensions

Two types of test piece are specified for method 1, depending on the wire cord diameter. Their dimensions shall comply with [Table 1](#). The dimensions of the test piece for method 2 shall comply with [Table 2](#). For both methods, for cords with diameters below 0,5 mm or above 1,7 mm, or for smaller cords which experience cord breakages with rubber compounds showing very high adhesion strength, the same form of test piece shall be used, with the dimensions h and L suitably scaled.

Table 1 — Dimensions of test piece for method 1

Dimensions in millimetres

Type	Cord diameter d	Embedded length, L		Min. width of rubber between reinforcing sheets w_{\min}	Min. cord spacing S^a	Test hole diameter or diagonal h^a
		Using steel plate reinforcement	Using steel cord fabric reinforcement			
A	0,5 to 1,0	10,0	10,0	6,0 ^b	62,5 % of L	85 % of L
B	1,0 to 1,7	10,0	16,0	6,0 ^b	62,5 % of L	85 % of L

^a The minimum cord spacing S and the test hole diameter or diagonal h shall be read to the nearest 0,5 mm.

^b Greater widths are preferred when using steel cord fabric reinforcement.

Table 2 — Dimensions of test piece for method 2

Dimensions in millimetres

Cord diameter d	Embedded length L	Test piece width W	Min. cord spacing S	Test hole diameter h
0,5 to 1,7	12,5	12,5	12,5	12,5

8.3 Preparation

8.3.1 General

Prepare all materials before commencing the build-up of the test piece, so that the mould can be filled quickly at the proper time. The operator shall wear clean gloves during the preparation of test pieces. The cords, rubber and moulded test piece shall be properly identified throughout.

NOTE An approximately 5 % excess of rubber compound is employed so that the test piece is formed under pressure with accompanying rubber flow and consolidation.

8.3.2 Method 1

8.3.2.1 For each multiple-corded test piece prepare the following.

- Two pieces of reinforcement material, cut to the correct size to fit the mould.
- Two sets of rubber compound, cut to the correct sizes to fit the mould above and below the cords: the exact sizes of the top and bottom set will depend on the mould used. Each set can consist of one thick strip or of several thinner strips to make up the correct thickness. Remove any protective polyethylene film used during storage and, if necessary, freshen the surfaces with solvent (see [5.2](#)). If solvent is used, allow sufficient time for the surface to dry completely.
- Sufficient wire cords to occupy all stations in the mould. These shall be at least 300 mm long. Only touch the cords close to their ends, and not in the region to be moulded to the rubber. If required, the cord ends can be covered by a veneer or solder or cement to prevent fraying: if so, the solder shall be applied before cutting the wire cord off the spool. Alternatively, one endless cord can be used in conjunction with a suitable tensioning frame.

8.3.2.2 If required, preheat the mould, including all component parts, to about 100 °C.

8.3.3 Method 2

The test piece preparation procedure follows that of method 1, except that the mould spacers and the reinforcement strips are omitted, and that test piece construction prior to vulcanization is carried out on a special building rack similar to the mould (see [Figure 4](#)).

The unvulcanized formed test pieces shall be carefully removed from the building rack by pressing uniformly from the rear, placed in a desiccated container and stored at standard laboratory temperature, in accordance with ISO 23529, until vulcanization. Test pieces shall be vulcanized within a maximum of 12 h.

8.3.4 Both methods

Place the made-up mould in the press already set at the vulcanization temperature. Allow the mould to warm up so that the rubber temperature is about 100 °C and the rubber is ready to flow. Apply a force of at least 100 kN and maintain for the duration of the vulcanization.

NOTE In order to set the conditions to achieve a rubber temperature of 100 °C, it might be necessary to carry out a preliminary calibration using a thermocouple inserted into the rubber.

Either pass cooling water through the platens of the press for a suitable time, release the moulding force and remove the mould from the press, or allow the mould to cool after its removal from the press. Extract the test piece, using the relevant extraction tools, if appropriate, and avoiding any deformation of the test piece.

Examine the test piece to ensure that rubber has flowed completely along each cord-hole in the pairs of steel spacers for the method 1 test pieces.

Separate the blocks if appropriate. Trim off the shorter lengths of wire cord close to the surface of the rubber block and any spew or flash on the outer edges of the block. With test pieces for method 1, the flash near the cords need not be trimmed as it does not affect the test procedure or result; for method 2 test pieces, trim any flash with a razor blade or suitable clippers, taking care not to damage the cord or the body of the test piece.

The test piece shall be rested at standard laboratory temperature, in accordance with ISO 23529, for a minimum of 16 h before testing if no time is specified.

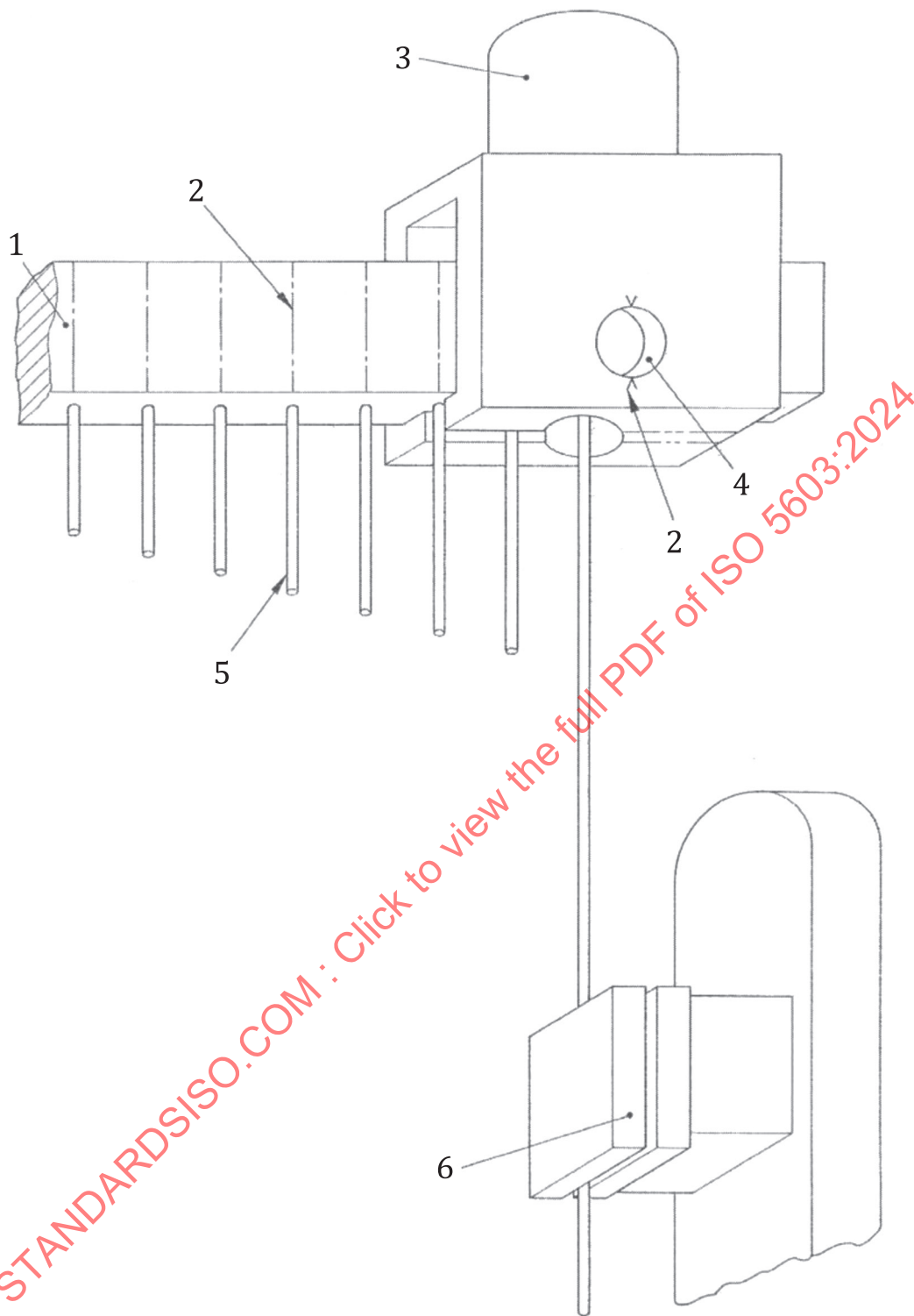
9 Procedure

Tests shall be performed at standard laboratory temperature in accordance with ISO 23529, unless otherwise specified.

Mount the test piece in the tensile-testing machine using the relevant fixture shown in [Figure 6](#). Carefully adjust the test piece so that the first wire cord is central in the hole, thus ensuring that the test tension will be uniformly distributed round the circumference of the cord (see [Figures 6](#) and [8](#)). This centring is facilitated by the use of the aligning features already mentioned in [6.1 a\)](#) and [6.4](#). Clamp the cord to be tested in the extraction jaws.

Apply tension by separating the extraction jaws from the fixture at a constant rate, between 50 mm/min and 150 mm/min, until the test piece breaks. Record the maximum force.

Repeat the procedure for each of the remaining cords in the test piece: at least 10 cords shall be tested.



Key

- | | | | |
|---|---|---|------------------------------|
| 1 | test piece | 4 | optional lateral hole |
| 2 | optional centring lines | 5 | wire cords |
| 3 | to fit one jaw of tensile-testing machine | 6 | cord clamp to fit second jaw |

NOTE Test arrangement can be inverted if required.

Figure 8 — Test arrangement (circular hole)