

Axiall PVC HHP-190

Rigid Polyvinyl Chloride

Axiall Corporation

Message:

Georgia Gulf HHP-190 is a special purpose profile extrusion alloy designed for application requiring the following properties:

Heat Resistance & Thermal Stability

Impact Strength and toughness

Colorability

UV Color Stability

Dimensional Stability

Chemical Resistance.

General Information			
Features	Good dimensional stability		
	Impact resistance, good		
	Good color stability		
	Good coloring		
	Good chemical resistance		
	Heat resistance, medium		
	Thermal stability, good		
	Good toughness		
Forms	Particle		
Processing Method	Profile extrusion molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Durometer Hardness (Shore D)	80		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2410	MPa	ASTM D638
Tensile Strength (Yield)	46.2	MPa	ASTM D638
Flexural Modulus	2410	MPa	ASTM D790
Flexural Strength	76.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	530	J/m	ASTM D256
Tensile Impact Strength	96.7	kJ/m ²	ASTM D1822
Drop Impact Resistance	133	J/cm	ASTM D4226
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	96.1	°C	ASTM D648
1.8 MPa, not annealed	87.8	°C	ASTM D648

CLTE - Flow	7.4E-5	cm/cm/°C	ASTM D696
Extrusion	Nominal Value	Unit	
Drying Temperature	76.7	°C	
Drying Time	2.0 - 6.0	hr	
Cylinder Zone 1 Temp.	149	°C	
Cylinder Zone 2 Temp.	154	°C	
Cylinder Zone 3 Temp.	160	°C	
Cylinder Zone 4 Temp.	166	°C	
Cylinder Zone 5 Temp.	171	°C	
Melt Temperature	188 - 199	°C	
Die Temperature	177	°C	
Extrusion instructions			

Georgia Gulf HHP-190 is mildly hygroscopic. Drying before extrusion is recommended at 170°F for 2 to 6 hours to ensure optimum performance and surface characteristics. Recommended Extruder Size and Screw Design: For Screw L/D of 60"/2.5"

Extr. L/D: 24:1

Feed Flights: 5

Feed Depth: 0.500 to 0.575 in

Metering Flights: 5 to 12

Metering Depth: 0.200 to 0.210 in

Comp. Ratio: 2.0 to 2.5

For Screw L/D of 84"/3.5"

Extr. L/D: 24:1

Feed Flights: 5

Feed Depth: 0.600 to 0.700 in

Metering Flights: 5 to 12

Metering Depth: 0.240 to 0.280 in

Comp. Ratio: 2.0 to 2.5

Other Barrel Temperatures: Gate Temperature: 350°F After start-up, temperature adjustments up or down may be necessary until extrusion impact, surface, and die flow are acceptable. Adjustments in 5°F increments are recommended. Normally Zone 1 temperature should not be varied since feed rate may be affected. If a screen pack is used, a 20/40 mesh combination should be sufficient.

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Recommended distributors for this material

Susheng Import & Export Trading Co., Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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