

Axiall PVC SP-5034

Rigid Polyvinyl Chloride

Axiall Corporation

Message:

Georgia Gulf SP-5034 is a rigid vinyl injection molding compound designed for fittings and parts of similar configuration where maximum burst strength is required. Georgia Gulf 5034 is ideally suited for large diameter fittings. Georgia Gulf 5034 is listed with NSF under Standard 14, and meets Standard 61 health effects requirements.

General Information			
Uses	Fittings		
	Plumbing Parts		
Agency Ratings	NSF 14		
	NSF 61		
UL File Number	E53006		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.36	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.20 to 0.40	%	ASTM D955
PVC Cell Classification	12454-B		ASTM D1784
Flow Ratio (199 to 204°C)	120		
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2760	MPa	ASTM D638
Tensile Strength	48.3	MPa	ASTM D638
Flexural Modulus	3100	MPa	ASTM D790
Flexural Strength	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-20°C, 3.18 mm	37	J/m	
23°C, 3.18 mm	80	J/m	
Gardner Impact (23°C)	36.2	J	ASTM D3029
Drop Impact Resistance (23°C)	114	J/cm	ASTM D4226
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	74.0	°C	
1.8 MPa, Unannealed	70.0	°C	
Flammability	Nominal Value	Unit	Test Method

Oxygen Index	38	%	ASTM D2863
Injection	Nominal Value	Unit	
Drying Temperature	65.6	°C	
Drying Time	2.0 to 4.0	hr	
Drying Time, Maximum	6.0	hr	
Suggested Shot Size	35 to 75	%	
Suggested Max Regrind	50	%	
Rear Temperature	163	°C	
Middle Temperature	174 to 191	°C	
Front Temperature	182 to 193	°C	
Nozzle Temperature	177 to 193	°C	
Processing (Melt) Temp	202 to 210	°C	
Mold Temperature	15.6 to 48.9	°C	
Injection Pressure	82.7 to 138	MPa	
Holding Pressure	48.3 to 82.7	MPa	
Back Pressure	0.345 to 1.38	MPa	
Screw Speed	25 to 80	rpm	
Clamp Tonnage	3.4	kN/cm ²	
Screw L/D Ratio	16.0:1.0 to 24.0:1.0		
Screw Compression Ratio	1.5:1.0 to 2.5:1.0		

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