

# Axiall PVC SP-7107

Rigid Polyvinyl Chloride

Axiall Corporation

Message:

Georgia Gulf SP-7107 is a general purpose, electrical grade rigid vinyl injection molding compound characterized by excellent flow, heat stability, color hold, and surface appearance. This makes it an ideal choice for applications such as electrical outlet boxes, terminal strip housings, and appliance parts.

General Information			
UL YellowCard	E53006-243380		
Features	Impact resistance, good		
	Good UV resistance		
	Good color stability		
	High liquidity		
	Good chemical resistance		
	Thermal stability, good		
	Good appearance		
	Flame retardancy		
Uses	Electrical components		
	Electrical housing		
	Home appliance components		
	General		
UL File Number	E53006		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow	0.30 - 0.40	%	ASTM D955
Outdoor Suitability	f1		UL 746C
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2620	MPa	ASTM D638
Tensile Strength	41.4	MPa	ASTM D638
Flexural Modulus	2760	MPa	ASTM D790
Flexural Strength	75.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-20°C, 3.18 mm	59	J/m	ASTM D256

23°C, 3.18 mm	800	J/m	ASTM D256
Dart Drop Impact (23°C, 12.7 mm)	20.8	J	ASTM D3029
Drop Impact Resistance (23°C)	129	J/cm	ASTM D4226
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	74.0	°C	ASTM D648
1.8 MPa, not annealed	70.0	°C	ASTM D648
RTI Elec (1.40 mm)	90.0	°C	UL 746
RTI Imp (1.40 mm)	85.0	°C	UL 746
RTI (1.40 mm)	90.0	°C	UL 746
Flammability	Nominal Value	Unit	Test Method
	V-0		
Flame Rating	5VA		UL 94
Oxygen Index	36	%	ASTM D2863
Additional Information			
UL Flame Spread Index, ASTM-E162: RP-42Flow Ratio, Georgia Gulf Test, Distance/Wall Thickness, 390-400°F: 215			
Injection	Nominal Value	Unit	
Drying Temperature	65.6	°C	
Drying Time	2.0 - 4.0	hr	
Drying Time, Maximum	6.0	hr	
Suggested Shot Size	35 - 75	%	
Suggested Max Regrind	50	%	
Rear Temperature	163	°C	
Middle Temperature	174 - 191	°C	
Front Temperature	182 - 193	°C	
Nozzle Temperature	177 - 193	°C	
Processing (Melt) Temp	202 - 210	°C	
Mold Temperature	15.6 - 48.9	°C	
Injection Pressure	82.7 - 138	MPa	
Holding Pressure	48.3 - 82.7	MPa	
Back Pressure	0.345 - 1.38	MPa	
Screw Speed	25 - 80	rpm	
Clamp Tonnage	3.4	kN/cm <sup>2</sup>	
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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