

Axiall PVC CL-7049

Rigid Polyvinyl Chloride

Axiall Corporation

Message:

Georgia Gulf CL-7049 is a clear, high impact vinyl compound formulated for medical and food contact uses.

General Information			
Features	Food Contact Acceptable		
	High Impact Resistance		
Uses	Medical/Healthcare Applications		
	Non-specific Food Applications		
Agency Ratings	FDA Unspecified Rating		
Appearance	Clear/Transparent		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.29	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.30 to 0.40	%	ASTM D955
Flow Ratio ¹ (199°C)	190		Internal Method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	95		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2410	MPa	ASTM D638
Tensile Strength	36.5	MPa	ASTM D638
Flexural Modulus	2140	MPa	ASTM D790
Flexural Strength	65.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
0°C, 3.18 mm	85	J/m	
11°C, 3.18 mm	590	J/m	
Gardner Impact (23°C)	21.7	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	70.0	°C	
1.8 MPa, Unannealed	65.0	°C	
Flammability	Nominal Value	Unit	Test Method
Flame Rating	V-0		UL 94
Oxygen Index	32	%	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	
NOTE		

1. Distance/Wall Thickness

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