Axiall PVC HH-2000

Rigid Polyvinyl Chloride

Axiall Corporation

Message:

Georgia Gulf HH-2000 is a high heat/high flow injection molding grade PVC alloy with a price/performance niche between high flow vinyl and utility engineering thermoplastics. It combines excellent flow, and toughness, and heat deflection/heat sag characteristics that are a marked improvement over standard vinyl. In addition, HH-2000 has excellent heat and light stability, color hold, and surface appearance, making it an ideal candidate for Class A appearance parts requiring good heat warpage resistance such as color computer monitor housings.

General Information			
UL YellowCard	E53006-243368		
Features	Low warpage Impact resistance, good Good UV resistance Workability, good Good heat aging resistance Good color stability High liquidity Heat resistance, high Good toughness Good appearance		
UL File Number	E53006		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.25	g/cm³	ASTM D792
Molding Shrinkage - Flow	0.40 - 0.60	%	ASTM D955
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	44.8	MPa	ASTM D638
Flexural Modulus	2410	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	53	J/m	ASTM D256
23°C, 3.18 mm	210	J/m	ASTM D256
Drop Impact Resistance (23°C)	116	J/cm	ASTM D4226
Thermal	**Nominal Value**	**Unit**	**Test Method**

Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	80.0	°C	ASTM D648
1.8 MPa, not annealed	76.0	°C	ASTM D648
Flammability	**Nominal Value**	**Unit**	**Test Method**
	V-0		
Flame Rating	5V		UL 94
Oxygen Index	30	%	ASTM D2863

Additional Information

Flow Ratio, Georgia Gulf Test Method, Distance/Wall Thickness, 390-400°F: 210

Injection	Nominal Value	Unit
Drying Temperature	60.0 - 71.1	°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^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	

Injection instructions

Drying in a dehumidifying dryer is recommended to ensure optimum processing characteristics.

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection.All rights belong to the original authors. If any infringement occurs, please contact us immediately.

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


WECHAT