

SMOKEGUARD™ IV 1320 NATURAL

Polyvinyl Chloride

AlphaGary

Message:

A HIGH PERFORMANCE, 60°C RATED, LEAD FREE, LOW SMOKE PVC COMPOUND DESIGNED FOR DEMANDING APPLICATIONS WHERE PVDF WOULD TYPICALLY BE USED.

General Information			
Features	Low (to no) lead content		
	Low smoke		
Appearance	Natural color		
Forms	Particle		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.70 - 1.74	g/cm ³	ASTM D792
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw D	69 - 75		ASTM D2240
Shaw D, 15 seconds	58 - 64		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D412
0.381 mm	18.6	MPa	ASTM D412
1.91 mm	16.5	MPa	ASTM D412
Tensile Elongation			ASTM D412
Fracture, 1.91mm	210	%	ASTM D412
Fracture, 0.381mm	190	%	ASTM D412
Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air ¹ (100°C, 168 hr)	-20	%	UL Unspecified
Change in Ultimate Elongation in Air ² (100°C, 168 hr)	-29	%	UL Unspecified
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-9.00	°C	ASTM D746
Electrical	Nominal Value	Unit	Test Method
Dielectric Constant (23°C, 100 MHz)	3.40		ASTM D150
Dissipation Factor (23°C, 100 MHz)	0.014		ASTM D150
Flammability	Nominal Value	Unit	Test Method
Oxygen Index (3.18 mm)	57	%	ASTM D2863
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	160	°C	

Cylinder Zone 2 Temp.	166	°C
Cylinder Zone 3 Temp.	171	°C
Cylinder Zone 4 Temp.	174	°C
Cylinder Zone 5 Temp.	174	°C
Adapter Temperature	177	°C
Melt Temperature	182 - 188	°C
Die Temperature	177	°C
Extruder Screw Compression Ratio	3.0:1.0	

Extrusion instructions

Melt temperature is critical, at elevated temperatures foaming may occur. It may be necessary to adjust barrel temp to attain the desired melt temp. Material should be dried prior to use

NOTE

1. Thickness: 15 mil
2. Thickness: 15 mil

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