

Alpha PVC 3006-90 CLEAR 0217

Flexible Polyvinyl Chloride

AlphaGary

Message:

ALPHA PVC 3006-90 CLEAR is a flexible vinyl compound produced with FDA sanctioned raw materials. Designed with high flow for injection molding, PVC 3006 features sparkling clarity, high thermal stability, and easy mold release. The formula is available in a wide range of hardnesses and is the preferred grade for such demanding applications as drip chambers, tubing caps and connectors.

General Information			
Features	High liquidity		
	Definition, high		
	Thermal stability, good		
	Good demoulding performance		
Uses	Shield		
	Connector		
Agency Ratings	FDA not rated		
RoHS Compliance	Contact manufacturer		
Appearance	Clear/transparent		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.26 - 1.30	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/21.6 kg)	120	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 10 seconds, 3.18mm	87 - 93		ASTM D2240
Shaw A, 15 seconds, 6.35mm	86 - 92		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus - 100% Secant	12.4	MPa	ASTM D638
Tensile Strength	17.2	MPa	ASTM D638
Tensile Elongation (Break)	270	%	ASTM D638
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	3.00	°C	ASTM D746
Vicat Softening Temperature	66.0	°C	ASTM D1525
Injection	Nominal Value	Unit	
Rear Temperature	143	°C	

Middle Temperature	154	°C
Front Temperature	160	°C
Nozzle Temperature	171	°C
Processing (Melt) Temp	166 - 177	°C

Injection instructions

Zone 4: 330°F Zone 5: 330°F

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	143	°C
Cylinder Zone 2 Temp.	154	°C
Cylinder Zone 3 Temp.	160	°C
Cylinder Zone 4 Temp.	166	°C
Cylinder Zone 5 Temp.	166	°C
Adapter Temperature	171	°C
Melt Temperature	166 - 177	°C

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