

Axiall PVC HF-6597

Rigid Polyvinyl Chloride

Axiall Corporation

Message:

Georgia Gulf HF-6597 is a high flow PVC compound designed for thin wall parts and multi-cavity molds. It is ideally suited for a variety of electrical and appliance applications.

General Information			
UL YellowCard	E53006-243317		
Features	High liquidity		
Uses	Thin wall parts		
	Electrical/Electronic Applications		
	Home appliance components		
UL File Number	E53006		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.40	g/cm ³	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)	97		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2690	MPa	ASTM D638
Tensile Strength	41.4	MPa	ASTM D638
Flexural Modulus	2480	MPa	ASTM D790
Flexural Strength	67.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-20°C, 3.18 mm	80	J/m	ASTM D256
23°C, 3.18 mm	800	J/m	ASTM D256
Dart Drop Impact (23°C)	14.7	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	72.0	°C	ASTM D648
1.8 MPa, not annealed	70.0	°C	ASTM D648
RTI Elec	90.0	°C	UL 746
RTI Imp	85.0	°C	UL 746
RTI	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			
Flow Ratio, Georgia Gulf Test Method, Distance/Wall Thickness, 390-400°F: 230			
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 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		

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