

Generic PVC, Rigid

Rigid Polyvinyl Chloride

Generic

Message:

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General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.30 - 1.47	g/cm ³	ASTM D792
23°C	1.32 - 1.62	g/cm ³	ISO 1183
--	0.801 - 0.802	g/cm ³	ASTM D1505
Apparent Density	0.52 - 0.65	g/cm ³	ASTM D1895
Melt Mass-Flow Rate (MFR) (190°C/21.6 kg)	1.4 - 60	g/10 min	ASTM D1238
Spiral Flow	54.9 - 119	cm	
Molding Shrinkage - Flow (23°C)	0.35 - 0.41	%	ASTM D955
K-Value (23°C)	64.9 - 65.3		ISO 1628-2
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (23°C)	89 - 117		ASTM D785
Durometer Hardness			
23°C	75 - 85		ASTM D2240
23°C	44 - 84		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2170 - 3380	MPa	ASTM D638
Tensile Strength			
Yield, 23°C	38.3 - 50.5	MPa	ASTM D638
Yield, 23°C	37.9 - 45.4	MPa	ISO 527-2
Fracture, 23°C	41.1 - 50.8	MPa	ASTM D638
Fracture, 23°C	32.0 - 42.4	MPa	ISO 527-2
23°C	12.5 - 50.5	MPa	ASTM D638
Tensile Elongation			
Fracture, 23°C	2.6 - 190	%	ASTM D638
Fracture, 23°C	78 - 150	%	ISO 527-2
Flexural Modulus (23°C)	2290 - 3210	MPa	ASTM D790
Flexural Strength			
23°C	65.3 - 94.1	MPa	ASTM D790
Yield, 23°C	61.6 - 87.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.9 - 21	kJ/m ²	ISO 179

Notched Izod Impact (23°C)	16 - 1100	J/m	ASTM D256
Unnotched Izod Impact (23°C)	50 - 170	J/m	ASTM D256
Dart Drop Impact (23°C)	14.7 - 36.2	J	ASTM D3029
Tensile Impact Strength (23°C)	12.8 - 191	kJ/m ²	ASTM D1822
Drop Impact Resistance (23°C)	6.67 - 202	J/cm	ASTM D4226
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	64.7 - 81.3	°C	ASTM D648
0.45 MPa, annealed	69.6 - 81.4	°C	ASTM D648
1.8 MPa, not annealed	58.6 - 76.5	°C	ASTM D648
1.8 MPa, annealed	61.5 - 78.3	°C	ASTM D648
Vicat Softening Temperature			
--	74.8 - 99.0	°C	ASTM D1525
--	71.5 - 89.9	°C	ISO 306
Melting Temperature	166 - 184	°C	
CLTE - Flow	5.3E-5 - 7.6E-5	cm/cm/°C	ASTM D696
Thermal Conductivity (23°C)	0.16	W/m/K	ASTM C177
RTI Elec	50.0 - 95.4	°C	UL 746
RTI Imp	50.0 - 85.0	°C	UL 746
RTI	50.0 - 95.4	°C	UL 746
Flammability	Nominal Value	Unit	Test Method
Oxygen Index	35 - 38	%	ASTM D2863
Optical	Nominal Value	Unit	Test Method
Transmittance	73.5 - 87.9	%	ASTM D1003
Haze	3.8 - 6.1	%	ASTM D1003
Injection	Nominal Value	Unit	
Rear Temperature	162 - 163	°C	
Middle Temperature	182	°C	
Front Temperature	187 - 188	°C	
Nozzle Temperature	185	°C	
Processing (Melt) Temp	200 - 206	°C	
Mold Temperature	32.0 - 32.2	°C	
Injection Pressure	108 - 110	MPa	
Back Pressure	0.839 - 0.866	MPa	
Screw Speed	52 - 53	rpm	
Injection instructions			
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Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	149 - 166	°C	
Cylinder Zone 2 Temp.	154 - 166	°C	
Cylinder Zone 3 Temp.	160 - 177	°C	

Cylinder Zone 4 Temp.	166 - 182	°C
Melt Temperature	182 - 188	°C
Die Temperature	175 - 191	°C

Extrusion instructions

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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

