

Tuf-Stif 2802

Rigid Polyvinyl Chloride

Axial Corporation

Message:

Georgia Gulf Tuf-Stif 2802 is a special purpose rigid PVC profile extrusion compound designed for applications requiring improved toughness as compared to Tuf-Stiff, rigidity/stiffness, dimensional stability, durability, colorability, flame retardance, and chemical resistance.

General Information			
UL YellowCard	E53006-243303		
Features	Good dimensional stability		
	Rigid, good		
	Good coloring		
	Good chemical resistance		
	Durability		
	Good toughness		
	Flame retardancy		
Forms	Particle		
Processing Method	Profile extrusion molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.51	g/cm ³	ASTM D792
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	104		ASTM D785
Durometer Hardness (Shore D)	80		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4830	MPa	ASTM D638
Tensile Strength (Yield)	44.8	MPa	ASTM D638
Flexural Modulus	4830	MPa	ASTM D790
Flexural Strength	83.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	110	J/m	ASTM D256
Drop Impact Resistance	111	J/cm	ASTM D4226
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	74.0	°C	ASTM D648
CLTE - Flow	3.8E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating (3.18 mm)	V-0		UL 94
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	149	°C	
Cylinder Zone 2 Temp.	154	°C	

Cylinder Zone 3 Temp.	160	°C
Cylinder Zone 4 Temp.	166	°C
Cylinder Zone 5 Temp.	171	°C
Melt Temperature	188 - 199	°C
Die Temperature	179	°C

Extrusion instructions

Georgia Gulf Tuf-Stif 2802 can be processed on conventional rigid vinyl equipment. Recommended Extruder Size and Screw Design: For Screw L/D of 60"/2.5"-Extr. L/D: 24:1-# Feed Flights: 5-Feed Depth: 0.500 to 0.575 in-# Metering Flights: 5 to 12-Metering Depth: 0.200 to 0.210 in-Comp. Ratio: 2.0 to 2.5 For Screw L/D of 84"/3.5"-Extr. L/D: 24:1-# Feed Flights: 5-Feed Depth: 0.600 to 0.700 in-# Metering Flights: 5 to 12-Metering Depth: 0.240 to 0.280 in-Comp. Ratio: 2.0 to 2.5 Other Barrel Temperatures: Gate Temperature: 355°F After start-up, temperature adjustments up or down may be necessary until extrusion impact, surface, and die flow are acceptable. Adjustments in 5°F increments are recommended. Normally Zone 1 temperature should not be varied since feed rate may be affected. A 20/40 mesh screen pack with breaker plate is recommended.

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