

Alpha PVC 3019-40/45 CLEAR 0003

Flexible Polyvinyl Chloride

AlphaGary

Message:

3019-40/45 Clear 0003 is a PVC compound with rubber-like flexibility and softness. 3019-40/45 Clear 0003 is designed for injection molding and used for toys, novelties, earplugs and medical applications where super flexibility is essential and high gloss finish is desired.

General Information			
Features	Highlight		
	Good flexibility		
	Soft		
Uses	Toys		
	Medical/nursing supplies		
RoHS Compliance	Contact manufacturer		
Appearance	Clear/transparent		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11 - 1.15	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	220	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 10 seconds, 3.18mm	40 - 45		ASTM D2240
Shaw A, 15 seconds, 6.35mm	35 - 45		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus - 100% Secant (1.91 mm)	2.34	MPa	ASTM D638
Tensile Strength (1.91 mm)	8.27	MPa	ASTM D638
Tensile Elongation (Break, 1.91 mm)	530	%	ASTM D638
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-53.0	°C	ASTM D746
Injection	Nominal Value	Unit	
Rear Temperature	138	°C	
Middle Temperature	149	°C	
Front Temperature	154	°C	
Nozzle Temperature	160	°C	
Processing (Melt) Temp	157 - 168	°C	

Injection instructions

Zone 4: 320°F Zone 5: 320°F

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	138	°C
Cylinder Zone 2 Temp.	149	°C
Cylinder Zone 3 Temp.	154	°C
Cylinder Zone 4 Temp.	160	°C
Cylinder Zone 5 Temp.	160	°C
Adapter Temperature	160	°C
Melt Temperature	157 - 168	°C

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