

Axial PVC CL-6380

Rigid Polyvinyl Chloride

Axial Corporation

Message:

Georgia Gulf CL-6380 is a clear fittings compound. Georgia Gulf 6380 is ideally suited for use where visual monitoring of the process is needed. Georgia Gulf 6380 is listed with NSF under Standard 14, and meets Standard 61 Health effect requirements.

General Information			
Uses	Fittings		
	Spas		
	Swimming Pools		
Agency Ratings	NSF 14		
	NSF 61		
UL File Number	E53006		
Appearance	Clear/Transparent		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35 to 1.39	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.20 to 0.40	%	ASTM D955
PVC Cell Classification	11443		ASTM D1784
Flow Ratio ¹ (199 to 204°C)	150		Internal Method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2760	MPa	ASTM D638
Tensile Strength	49.6	MPa	ASTM D638
Flexural Modulus	2960	MPa	ASTM D790
Flexural Strength	89.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-20°C, 3.18 mm	37	J/m	
23°C, 3.18 mm	53	J/m	
Gardner Impact (23°C)	36.2	J	ASTM D3029
Drop Impact Resistance (23°C)	111	J/cm	ASTM D4226
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	71.7	°C	

1.8 MPa, Unannealed	70.0	°C
Flammability	Nominal Value	Test Method
Flame Rating	V-0	UL 94
Injection	Nominal Value	Unit
Drying Temperature	65.6	°C
Drying Time	2.0 to 4.0	hr
Drying Time, Maximum	6.0	hr
Suggested Shot Size	35 to 75	%
Suggested Max Regrind	50	%
Rear Temperature	163	°C
Middle Temperature	174 to 191	°C
Front Temperature	182 to 193	°C
Nozzle Temperature	177 to 193	°C
Processing (Melt) Temp	199 to 204	°C
Mold Temperature	15.6 to 48.9	°C
Injection Pressure	82.7 to 138	MPa
Holding Pressure	48.3 to 82.7	MPa
Back Pressure	0.345 to 1.38	MPa
Screw Speed	25 to 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	
NOTE		

1. Distance/Wall Thickness

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