Axiall PVC HHW-191

Rigid Polyvinyl Chloride

Axiall Corporation

Message:

Georgia Gulf HHW-191 is a special purpose profile extrusion alloy designed for applications requiring the following properties:
Excellent Weatherability
Impact Strength and Toughness
Colorability
Chemical Resistance
Heat Resistance and Thermal Stability
Dimensional Stability in Dark Colors

General Information			
UL YellowCard	E53006-243370		
Features	Good dimensional stability Good coloring Good chemical resistance Good weather resistance Heat resistance, medium Thermal stability, good Good toughness Medium impact resistance		
Forms	Particle		
Processing Method	Profile extrusion molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.24	g/cm³	ASTM D792
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	110		ASTM D785
Durometer Hardness (Shore D)	80		ASTM D2240
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2410	MPa	ASTM D638
Tensile Strength (Yield)	46.2	MPa	ASTM D638
Flexural Modulus	2410	MPa	ASTM D790
Flexural Strength	75.8	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C, 3.18 mm)	530	J/m	ASTM D256
Tensile Impact Strength	94.6	kJ/m²	ASTM D1822
Drop Impact Resistance	133	J/cm	ASTM D4226
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed)	88.3	°C	ASTM D648

CLTE - Flow	7.4E-5	cm/cm/°C	ASTM D696

Flammability	Nominal Value	Test Method
	V-1	

Flame Rating	V-0	UL 94

Extrusion	Nominal Value	Unit
Drying Temperature	76.7	°C
Drying Time	2.0 - 6.0	hr
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	177	°C

Extrusion instructions

Georgia Gulf HHW-191 is mildly hygroscopic. Drying before extrusion is recommended at 170°F for 2 to 6 hours to ensure optimum performance and surface characteristics.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: 350°FAfter 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.If a screen pack is used, a 20/40 mesh combination should be sufficient.

Recommended distributors for this material

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