

Alpha PVC GM 5065 NATURAL

Polyvinyl Chloride

AlphaGary

Message:

A 105°C RATED, LEAD & CADMIUM FREE, UL-94 V-2 MOLDING COMPOUND

General Information			
Features	Low (to no) lead content		
	Calcium content, low (to none)		
RoHS Compliance	Contact manufacturer		
Appearance	Natural color		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28 - 1.32	g/cm ³	ASTM D792
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 15 sec)	65 - 77		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (1.02 mm)	10.3	MPa	ASTM D412
Tensile Elongation (Break, 1.02 mm)	300	%	ASTM D412
Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air ¹ (136°C, 168 hr)	-20	%	UL Unspecified
Change in Ultimate Elongation in Air ² (136°C, 168 hr)	-20	%	UL Unspecified
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-27.0	°C	ASTM D746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.02 mm)	V-2		UL 94
Oxygen Index (3.18 mm)	25	%	ASTM D2863
Injection	Nominal Value	Unit	
Rear Temperature	149	°C	
Middle Temperature	154	°C	
Front Temperature	160	°C	
Nozzle Temperature	171	°C	
Processing (Melt) Temp	160 - 171	°C	

Injection instructions			
Zone 4: 330°FZone 5: 330°FMaterial should not sit stagnant for prolong periods of time.			

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.	166	°C
Adapter Temperature	166	°C
Melt Temperature	160 - 171	°C

Extrusion instructions

Material should not sit stagnant for prolong periods of time.

NOTE

1. Thickness: 40 mil
2. Thickness: 40 mil

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Recommended distributors for this material

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