

Axiall PVC UV-6676

Rigid Polyvinyl Chloride

Axiall Corporation

Message:

Georgia Gulf UV-6676 is a weatherable, high flow injection molding compound, specially formulated for outdoor UV exposure. This compound was designed to be used in various accessory parts, such as fence post caps, rain gutter parts, deck parts, etc.

General Information			
UL YellowCard	E53006-243318		
Features	Good UV resistance		
	High liquidity		
	Good weather resistance		
Uses	Construction hardware		
UL File Number	E53006		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.40	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.30 - 0.40	%	ASTM D955
Outdoor Suitability	f2		UL 746C
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	97		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2210	MPa	ASTM D638
Tensile Strength	40.0	MPa	ASTM D638
Flexural Modulus	2280	MPa	ASTM D790
Flexural Strength	65.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-20°C, 3.18 mm	53	J/m	ASTM D256
23°C, 3.18 mm	960	J/m	ASTM D256
Dart Drop Impact (23°C)	14.7	J	ASTM D3029
Drop Impact Resistance (23°C)	89.0	J/cm	ASTM D4226
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	72.0	°C	ASTM D648
1.8 MPa, not annealed	70.0	°C	ASTM D648
RTI Elec (1.50 mm)	85.0	°C	UL 746
RTI Imp (1.50 mm)	90.0	°C	UL 746

RTI (1.50 mm)	85.0	°C	UL 746
Flammability	Nominal Value	Unit	Test Method
	V-0		
Flame Rating	5VA		UL 94
Oxygen Index	35	%	ASTM D2863
Additional Information			
Flow Ratio, Georgia Gulf Test Method, Distance/Wall Thickness, 390-400°F: 230			
Injection	Nominal Value	Unit	
Drying Temperature	65.6	°C	
Drying Time	2.0 - 4.0	hr	
Drying Time, Maximum	6.0	hr	
Suggested Shot Size	35 - 75	%	
Suggested Max Regrind	50	%	
Rear Temperature	163	°C	
Middle Temperature	174 - 191	°C	
Front Temperature	182 - 193	°C	
Nozzle Temperature	177 - 193	°C	
Processing (Melt) Temp	202 - 210	°C	
Mold Temperature	15.6 - 48.9	°C	
Injection Pressure	82.7 - 138	MPa	
Holding Pressure	48.3 - 82.7	MPa	
Back Pressure	0.345 - 1.38	MPa	
Screw Speed	25 - 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		

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