

Axiall PVC CL-7053

Rigid Polyvinyl Chloride

Axiall Corporation

Message:

Georgia Gulf CL-7053 is a clear, high flow vinyl compound designed for a variety of end-use molding applications.

| General Information | | | |
|--|-------------------|-------------------|-----------------|
| UL YellowCard | E53006-243365 | | |
| Features | High Flow | | |
| Appearance | Clear/Transparent | | |
| Forms | Pellets | | |
| Processing Method | Injection Molding | | |
| Physical | Nominal Value | Unit | Test Method |
| Specific Gravity | 1.33 | g/cm ³ | ASTM D792 |
| Molding Shrinkage - Flow | 0.30 to 0.40 | % | ASTM D955 |
| Flow Ratio ¹ (199 to 204°C) | 200 | | Internal Method |
| Hardness | Nominal Value | Unit | Test Method |
| Rockwell Hardness (R-Scale) | 97 | | ASTM D785 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Modulus | 2620 | MPa | ASTM D638 |
| Tensile Strength | 45.5 | MPa | ASTM D638 |
| Flexural Modulus | 2760 | MPa | ASTM D790 |
| Flexural Strength | 75.8 | MPa | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact | | | ASTM D256 |
| 0°C, 3.18 mm | 80 | J/m | |
| 23°C, 3.18 mm | 530 | J/m | |
| Gardner Impact (23°C) | 21.7 | J | ASTM D3029 |
| Drop Impact Resistance (23°C) | 138 | J/cm | ASTM D4226 |
| Thermal | Nominal Value | Unit | Test Method |
| Deflection Temperature Under Load | | | ASTM D648 |
| 0.45 MPa, Unannealed | 70.0 | °C | |
| 1.8 MPa, Unannealed | 68.0 | °C | |
| Flammability | Nominal Value | Unit | Test Method |
| Flame Rating | V-0 | | UL 94 |
| Oxygen Index | 34 | % | ASTM D2863 |
| 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 | 202 to 210 | °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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