

Alpha PVC GM 8015-M NATURAL LCF

Polyvinyl Chloride

AlphaGary

Message:

A LEAD / CADMIUM FREE, 105C DEGREE, UL94 V-0 RATED, ELECTRICAL GRADE MOLDING COMPOUND.

General Information			
Features	Low (to no) lead content		
	Calcium content, low (to none)		
Uses	Electrical/Electronic Applications		
RoHS Compliance	Contact manufacturer		
Appearance	Natural color		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33 - 1.37	g/cm ³	ASTM D792
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A	93 - 99		ASTM D2240
Shaw A, 15 seconds	87 - 93		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (1.91 mm)	15.9	MPa	ASTM D412
Tensile Elongation (Break, 1.91 mm)	300	%	ASTM D412
Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air ¹ (136°C, 168 hr)	-5.0	%	UL Unspecified
Change in Ultimate Elongation in Air ² (136°C, 168 hr)	-20	%	UL Unspecified
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-18.0	°C	ASTM D746
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	3.0E+14	ohms · cm	ASTM D257
Dielectric Constant (23°C, 100 MHz)	2.80		ASTM D150
Dissipation Factor (23°C, 100 MHz)	0.016		ASTM D150
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.50 mm	V-0		UL 94
3.00 mm	V-0		UL 94

Oxygen Index (3.18 mm)	31	%	ASTM D2863
Injection	Nominal Value	Unit	
Rear Temperature	154	°C	
Middle Temperature	166	°C	
Front Temperature	171	°C	
Nozzle Temperature	177	°C	
Processing (Melt) Temp	171 - 185	°C	
Injection instructions			
Zone 4: 350°F Zone 5: 350°F			
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	154	°C	
Cylinder Zone 2 Temp.	166	°C	
Cylinder Zone 3 Temp.	171	°C	
Cylinder Zone 4 Temp.	177	°C	
Cylinder Zone 5 Temp.	177	°C	
Adapter Temperature	177	°C	
Melt Temperature	171 - 185	°C	
NOTE			
1.	Thickness: 75 mil		
2.	Thickness: 75 mil		

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