

Axiall PVC MP-6585

Rigid Polyvinyl Chloride

Axiall Corporation

Message:

Georgia Gulf MP-6585 is an electrical grade rigid vinyl injection molding compound possessing good strength, stiffness, toughness, and flow. In addition, it has excellent processing stability and surface appearance. It carries a 94 V-0 flammability rating.

General Information			
UL YellowCard	E53006-243316		
Features	Rigid, good		
	High strength		
	Good liquidity		
	Good stability		
	Good toughness		
	Good appearance		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.30 - 0.40	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2480	MPa	ASTM D638
Tensile Strength	41.4	MPa	ASTM D638
Flexural Modulus	2620	MPa	ASTM D790
Flexural Strength	75.8	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	530	J/m	ASTM D256
Dart Drop Impact (23°C)	36.2	J	ASTM D3029
Drop Impact Resistance (23°C)	116	J/cm	ASTM D4226
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	75.0	°C	ASTM D648
1.8 MPa, not annealed	70.0	°C	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating	V-0		UL 94

Oxygen Index	36	%	ASTM D2863
Additional Information			
Flow Ratio, Georgia Gulf Test Method, Distance/Wall Thickness, 390-400°F: 180			
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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