

Axiall PVC HHW-191(6191)

Rigid Polyvinyl Chloride

Axiall Corporation

Message:

AXIALl's Georgia Gulf HHW-191 (6191) is a special purpose profile extrusion alloy designed for applications requiring the following properties:

- Weatherable
- Impact Strength / Toughness
- Heat Resistance and Thermal Stability
- Chemical Resistance

General Information			
Features	Impact resistance, good		
	Good chemical resistance		
	Good weather resistance		
	Heat resistance, high		
	Thermal stability, good		
	Good toughness		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	g/cm³	ASTM D792
PVC Cell Classification	15335		ASTM D1784
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Durometer Hardness (Shore D)	80		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2410	MPa	ASTM D638
Tensile Strength (Yield)	46.2	MPa	ASTM D638
Flexural Modulus	2410	MPa	ASTM D790
Flexural Strength	75.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	530	J/m	ASTM D256
Tensile Impact Strength	94.6	kJ/m²	ASTM D1822
Drop Impact Resistance	1600	J/cm	ASTM D4226
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	88.3	°C	ASTM D648
CLTE - Flow	7.0E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating (1.5 mm)	V-1		UL 94
Extrusion	Nominal Value	Unit	
Drying Temperature	77	°C	

Drying Time	2.0 - 6.0	hr
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.	171	°C
Die Temperature	177	°C

Extrusion instructions

Gate Temperature: 350°F

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