

Axiall PVC MP-6510

Rigid Polyvinyl Chloride

Axiall Corporation

Message:

Georgia Gulf MP-6510 is a maximum properties electrical grade PVC injection molding compound possessing excellent strength and toughness. In addition, it has good processing stability and surface appearance. It carries a UL 94 V-0/5VA flammability rating, as well as a UL RTI rating.

General Information			
UL YellowCard	E53006-243315		
Features	Rigid, good		
	High strength		
	Good processing stability		
	Good liquidity		
	Good toughness		
	Excellent appearance		
Uses	Electrical components		
Agency Ratings	UL 94		
UL File Number	E53006		
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
Outdoor Suitability	f1		UL 746C
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	160	J/m	ASTM D256
23°C, 3.18 mm	960	J/m	ASTM D256
Dart Drop Impact ¹ (23°C)	22.6	J	ASTM D3029
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
RTI Elec (1.40 mm)	90.0	°C	UL 746
RTI Imp (1.40 mm)	85.0	°C	UL 746
RTI (1.40 mm)	90.0	°C	UL 746
Flammability	Nominal Value	Unit	Test Method

V-0

Flame Rating	5VA		UL 94
Oxygen Index	36	%	ASTM D2863

Additional Information

Flow Ratio (Distance/Wall Thickness), Georgia Gulf Test Method, 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	

NOTE

1. Method f, geometry FB

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

