

# Axiall PVC 3014

Rigid Polyvinyl Chloride

Axiall Corporation

Message:

Georgia Gulf 3014 is a base for use of wood flour up to 40 percent.

| General Information                                     |                            |                   |             |
|---------------------------------------------------------|----------------------------|-------------------|-------------|
| Features                                                | Good dimensional stability |                   |             |
|                                                         | Impact resistance, good    |                   |             |
|                                                         | Good chemical resistance   |                   |             |
|                                                         | Good toughness             |                   |             |
|                                                         | Flame retardancy           |                   |             |
| Physical                                                | Nominal Value              | Unit              | Test Method |
| Specific Gravity                                        | 1.38                       | g/cm <sup>3</sup> | ASTM D792   |
| PVC Cell Classification                                 | 1200433                    |                   | ASTM D4216  |
| PVC Cell Classification                                 | 12444                      |                   | ASTM D1784  |
| Hardness                                                | Nominal Value              | Unit              | Test Method |
| Durometer Hardness (Shore D)                            | 78                         |                   | ASTM D2240  |
| Mechanical                                              | Nominal Value              | Unit              | Test Method |
| Tensile Modulus                                         | 2620                       | MPa               | ASTM D638   |
| Tensile Strength (Yield)                                | 48.3                       | MPa               | ASTM D638   |
| Flexural Modulus                                        | 3100                       | MPa               | ASTM D790   |
| Flexural Strength                                       | 82.7                       | MPa               | ASTM D790   |
| Impact                                                  | Nominal Value              | Unit              | Test Method |
| Notched Izod Impact (23°C, 3.18 mm)                     | 64                         | J/m               | ASTM D256   |
| Thermal                                                 | Nominal Value              | Unit              | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed) | 65.6                       | °C                | ASTM D648   |
| CLTE - Flow                                             | 6.8E-5                     | cm/cm/°C          | ASTM D696   |
| Extrusion                                               | Nominal Value              | Unit              |             |
| Cylinder Zone 1 Temp.                                   | 163 - 168                  | °C                |             |
| Cylinder Zone 2 Temp.                                   | 163 - 168                  | °C                |             |
| Cylinder Zone 3 Temp.                                   | 163 - 168                  | °C                |             |
| Cylinder Zone 4 Temp.                                   | 163 - 168                  | °C                |             |
| Cylinder Zone 5 Temp.                                   | 163 - 168                  | °C                |             |
| Melt Temperature                                        | 185 - 193                  | °C                |             |
| Die Temperature                                         | 168 - 182                  | °C                |             |
| Extrusion instructions                                  |                            |                   |             |

Melt Pressure: 2000 psiBreaker Plate: RingUp to 40% Wood Flour Size 40 to 80 MeshDry to <8% moisture in flour.

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