

# Axiall PVC NR-5009

Rigid Polyvinyl Chloride

Axiall Corporation

## Message:

Georgia Gulf NR-5009 is a high flow rigid, fitting-grade vinyl compound designed for small gated, thin walled parts. The compound is characterized by excellent processability, which includes color hold, regrind stability, and surface appearance. NR-5009 is NSF listed for DMV and pressure fittings applications.

General Information			
UL YellowCard	E53006-243377		
Features	Workability, good		
	Good color stability		
	High liquidity		
	Excellent appearance		
Uses	Thin wall parts		
	Accessories		
Agency Ratings	NSF 14		
	NSF 61		
UL File Number	E53006		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.39	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow	0.20 - 0.30	%	ASTM D955
PVC Cell Classification	12454-B		ASTM D1784
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2830	MPa	ASTM D638
Tensile Strength	50.3	MPa	ASTM D638
Flexural Modulus	2900	MPa	ASTM D790
Flexural Strength	89.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-20°C, 3.18 mm	37	J/m	ASTM D256
23°C, 3.18 mm	59	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	71.0	°C	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating	V-0		UL 94
Oxygen Index	38	%	ASTM D2863
Additional Information			
Flow Ratio, Georgia Gulf Test Method, Distance/Wall Thickness, 390-400°F: 170			
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 <sup>2</sup>	
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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