

Garathane™ X 96-320-B NAT

Polyvinyl Chloride Alloy
AlphaGary

Message:

GARATHANE X 96-320-B IS A PVC ALLOY FOOTWEAR COMPOUND

General Information			
Uses	Footwear		
RoHS Compliance	Contact manufacturer		
Appearance	Natural color		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21 - 1.25	g/cm ³	ASTM D792
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A	59 - 65		ASTM D2240
Shaw A, 15 seconds	51 - 57		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Taber Abrasion Resistance			
loss, 1000 cycles	0.450	%	
loss, 5000 cycles	2	%	
Ross Flex (-29°C, 6.35 mm)	20000		ASTM D1052
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain, 1.91 mm)	3.03	MPa	ASTM D412
Tensile Strength (1.91 mm)	9.38	MPa	ASTM D412
Tensile Elongation (Break, 1.91 mm)	370	%	ASTM D412
Aging	Nominal Value	Unit	
Change in Volume ¹			
23°C, 168 hr, in gasoline	-21	%	
23°C, 336 hr, in gasoline	-22	%	
23°C, 336 hr, in vegetable oil	-20	%	
75°C, 168 hr, in vegetable oil	-22	%	
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-50.0	°C	ASTM D746
Injection	Nominal Value	Unit	
Rear Temperature	143	°C	
Middle Temperature	149	°C	
Front Temperature	154	°C	
Nozzle Temperature	166	°C	
Processing (Melt) Temp	160 - 166	°C	

Injection instructions		
Zone 4: 320°FZone 5: 320°F		
Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	143	°C
Cylinder Zone 2 Temp.	149	°C
Cylinder Zone 3 Temp.	154	°C
Cylinder Zone 4 Temp.	160	°C
Cylinder Zone 5 Temp.	160	°C
Adapter Temperature	166	°C
Melt Temperature	160 - 166	°C
NOTE		
1.	Thickness: 75 mil	

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