

Axiall PVC SP-7221

Rigid Polyvinyl Chloride

Axiall Corporation

Message:

Georgia Gulf SP-7221 is a high impact rigid vinyl compound designed for water distribution systems. The product is NSF listed under Standard 14.

General Information			
Features	High Impact Resistance		
Uses	Piping		
Agency Ratings	NSF 14		
UL File Number	E53006		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.40 to 0.50	%	ASTM D955
PVC Cell Classification	14223-D		ASTM D1784
Flow Ratio ¹ (199 to 204°C)	130		Internal Method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	97		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2410	MPa	ASTM D638
Tensile Strength	42.7	MPa	ASTM D638
Flexural Modulus	2590	MPa	ASTM D790
Flexural Strength	68.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-20°C, 3.18 mm	69	J/m	
23°C, 3.18 mm	750	J/m	
Gardner 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, Unannealed	74.0	°C	
1.8 MPa, Unannealed	71.0	°C	
Flammability	Nominal Value	Unit	Test Method
Oxygen Index	36	%	ASTM D2863
Injection	Nominal Value	Unit	
Drying Temperature	65.6	°C	
Drying Time	2.0 to 4.0	hr	

Drying Time, Maximum	6.0	hr
Suggested Shot Size	35 to 75	%
Suggested Max Regrind	50	%
Rear Temperature	163	°C
Middle Temperature	174 to 191	°C
Front Temperature	182 to 193	°C
Nozzle Temperature	177 to 193	°C
Processing (Melt) Temp	202 to 210	°C
Mold Temperature	15.6 to 48.9	°C
Injection Pressure	82.7 to 138	MPa
Holding Pressure	48.3 to 82.7	MPa
Back Pressure	0.345 to 1.38	MPa
Screw Speed	25 to 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. Distance/Wall Thickness

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

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

