

# Tuf-Stif 2804

Rigid Polyvinyl Chloride

Axiall Corporation

## Message:

Tuf-Stif 2804 is a rigid polyvinyl chloride material. This product is available in North America. The main characteristics of Tuf-Stif 2804 are: flame retardant/rated flame.

| General Information                                     |               |                   |             |
|---------------------------------------------------------|---------------|-------------------|-------------|
| Physical                                                | Nominal Value | Unit              | Test Method |
| Specific Gravity                                        | 1.60          | g/cm <sup>3</sup> | ASTM D792   |
| Hardness                                                | Nominal Value | Unit              | Test Method |
| Rockwell Hardness (R-Scale)                             | 104           |                   | ASTM D785   |
| Durometer Hardness (Shore D)                            | 80            |                   | ASTM D2240  |
| Mechanical                                              | Nominal Value | Unit              | Test Method |
| Tensile Modulus                                         | 4140          | MPa               | ASTM D638   |
| Tensile Strength (Yield)                                | 46.2          | MPa               | ASTM D638   |
| Flexural Modulus                                        | 4650          | MPa               | ASTM D790   |
| Flexural Strength                                       | 86.2          | MPa               | ASTM D790   |
| Impact                                                  | Nominal Value | Unit              | Test Method |
| Notched Izod Impact (23°C)                              | 53            | J/m               | ASTM D256   |
| Thermal                                                 | Nominal Value | Unit              | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed) | 71.0          | °C                | ASTM D648   |
| CLTE - Flow                                             | 3.8E-5        | cm/cm/°C          | ASTM D696   |
| Flammability                                            | Nominal Value |                   | Test Method |
| Flame Rating (3.18 mm)                                  | V-0           |                   | UL 94       |
| Extrusion                                               | Nominal Value | Unit              |             |
| Cylinder Zone 1 Temp.                                   | 149           | °C                |             |
| Cylinder Zone 2 Temp.                                   | 154           | °C                |             |
| Cylinder Zone 3 Temp.                                   | 160           | °C                |             |
| Cylinder Zone 4 Temp.                                   | 166           | °C                |             |
| Cylinder Zone 5 Temp.                                   | 171           | °C                |             |
| Adapter Temperature                                     | 179           | °C                |             |
| Melt Temperature                                        | 188 - 199     | °C                |             |
| Die Temperature                                         | 179           | °C                |             |
| Extrusion instructions                                  |               |                   |             |

Screw L/D: 60"/2.5"Extr. L/D: 24:1Screen Pack: 20/40 mesh (with breaker plate)

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