

polyvic® IM-1208-GL 06

Semi-Rigid Polyvinyl Chloride

Unipack Plasindo

Message:

PVC Compound Semi Rigid
IM-1208-GL 06, high clarity with little bit bluish, designed for injection products.
Features
Low Impact Strength
High Clarity
Processing Methode
Blow Molding
Typical Applications
Bottle

General Information			
Features	Semi Rigid		
	Definition, high		
Uses	Pipe fittings		
Appearance	Transparent-Light Blue		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.50	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	17		ASTM D785
Durometer Hardness (Shore D)	74		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	30.7	MPa	ASTM D638
Tensile Elongation (Break)	160	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	5.65	kJ/m ²	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	40.5	°C	ASTM D648
Vicat Softening Temperature	66.2	°C	ASTM D256
Flammability	Nominal Value	Unit	Test Method
Burning Rate	4.3	mm/min	ASTM D635
Optical	Nominal Value	Unit	Test Method
Transmittance	88.1	%	ASTM D1003
Injection	Nominal Value	Unit	
Rear Temperature	145 - 150	°C	
Middle Temperature	150 - 155	°C	

Front Temperature	155 - 160	°C
Nozzle Temperature	165 - 170	°C
Injection Rate	Moderate	
Back Pressure	0.500 - 0.800	MPa
Screw Speed	30 - 60	rpm

Injection instructions

Die pin temperature : 170—175°C

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