

Axiall PVC UV-7160

Rigid Polyvinyl Chloride

Axiall Corporation

Message:

Georgia Gulf UV-7160 is a rigid vinyl injection molding compound characterized by excellent flow, toughness, heat and stability, color hold, and surface appearance. This combinations of outstanding attributes make it an ideal material choice for Class A appearance parts such as monochrome computer monitor housings, computer keyboard enclosures, and appliance parts.

General Information			
UL YellowCard	E53006-243381		
Features	Good heat aging resistance Good color stability High liquidity Thermal stability, good Good toughness Good appearance		
Uses	Computer components Home appliance components		
UL File Number	E53006		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.30 - 0.40	%	ASTM D955
Outdoor Suitability	f1		UL 746C
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2410	MPa	ASTM D638
Tensile Strength	41.4	MPa	ASTM D638
Flexural Modulus	2590	MPa	ASTM D790
Flexural Strength	75.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-20°C, 3.18 mm	53	J/m	ASTM D256
23°C, 3.18 mm	750	J/m	ASTM D256
Dart Drop Impact (23°C, 12.7 mm)	25.3	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648

0.45 MPa, not annealed	70.0	°C	ASTM D648
1.8 MPa, not annealed	74.0	°C	ASTM D648
Flammability	Nominal Value	Unit	Test Method
	V-0		
Flame Rating	5VA		UL 94
Oxygen Index	36	%	ASTM D2863

Additional Information

UL Flame Spread Index, ASTM E162: RP-50Flow Ratio, Georgia Gulf Test, Distance/Wall Thickness, 390-400°F: 215

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 Re grind	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 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	

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