

Alpha PVC 3006R-90 CLEAR 000X

Flexible Polyvinyl Chloride

AlphaGary

Message:

3006R-90 Clear 000X is a flexible vinyl compound produced with FDA sanctioned raw materials. Designed with high melt flow for injection molding and easy mold release, this formula showed exceptional resistance to radiation sterilization and passed USP Class VI biocompatibility tests for medical devices. 3006R-90 Clear 000X is recommended for use in drip chambers, tubing caps and connectors.

General Information	
Features	Radiation disinfection
	High liquidity
	Biocompatibility
	Good demoulding performance
Uses	Shield
	Connector
	Medical/nursing supplies
Agency Ratings	FDA not rated
	USP Class VI
RoHS Compliance	Contact manufacturer
Appearance	Clear/transparent
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25 - 1.29	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	1.8	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 10 seconds, 3.18mm	87 - 93		ASTM D2240
Shaw A, 15 seconds, 6.35mm	86 - 92		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus - 100% Secant	12.8	MPa	ASTM D638
Tensile Strength (1.91 mm)	21.9	MPa	ASTM D638
Tensile Elongation (Break, 1.91 mm)	290	%	ASTM D638
Elastomers	Nominal Value	Unit	Test Method
Tear Strength ¹	75.3	kN/m	ASTM D1004

Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-22.0	°C	ASTM D746
Injection	Nominal Value	Unit	
Rear Temperature	143	°C	
Middle Temperature	154	°C	
Front Temperature	160	°C	
Nozzle Temperature	171	°C	
Processing (Melt) Temp	166 - 177	°C	
Injection instructions			
Zone 4: 330°F Zone 5: 330°F			
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	143	°C	
Cylinder Zone 2 Temp.	154	°C	
Cylinder Zone 3 Temp.	160	°C	
Cylinder Zone 4 Temp.	166	°C	
Cylinder Zone 5 Temp.	166	°C	
Adapter Temperature	171	°C	
Melt Temperature	166 - 177	°C	
NOTE			
1.	Graves		

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