

# Westlake PVC CL-7053

Westlake Chemical Corporation - Rigid Polyvinyl Chloride

Friday, September 20, 2019

## General Information

### Product Description

AXIALL's Georgia Gulf CL-7053 is a clear, high flow vinyl compound designed for a variety of end-use molding applications.

### General

Material Status	• Commercial: Active
Availability	• North America
Features	• High Flow
Appearance	• Clear/Transparent
Forms	• Pellets
Processing Method	• Injection Molding

## ASTM & ISO Properties<sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.33	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow	0.30 to 0.40	%	ASTM D955
Flow Ratio <sup>2</sup> (199 to 204°C)	200		Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2620	MPa	ASTM D638
Tensile Strength	45.5	MPa	ASTM D638
Flexural Modulus	2760	MPa	ASTM D790
Flexural Strength	75.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
0°C, 3.18 mm	80	J/m	
23°C, 3.18 mm	530	J/m	
Gardner Impact (23°C)	21.7	J	ASTM D3029
Drop Impact Resistance (23°C)	138	J/cm	ASTM D4226
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	97		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	70.0	°C	
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed	68.0	°C	
Flammability	Nominal Value	Unit	Test Method
Flame Rating	V-0		UL 94
Oxygen Index	34	%	ASTM D2863

## Processing Information

Injection	Nominal Value	Unit
Drying Temperature	66	°C
Drying Time	2.0 to 4.0	hr
Drying Time, Maximum	6.0	hr
Suggested Shot Size	35 to 75	%

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Injection	Nominal Value	Unit
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	16 to 49	°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 <sup>2</sup>
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	

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> Distance/Wall Thickness