

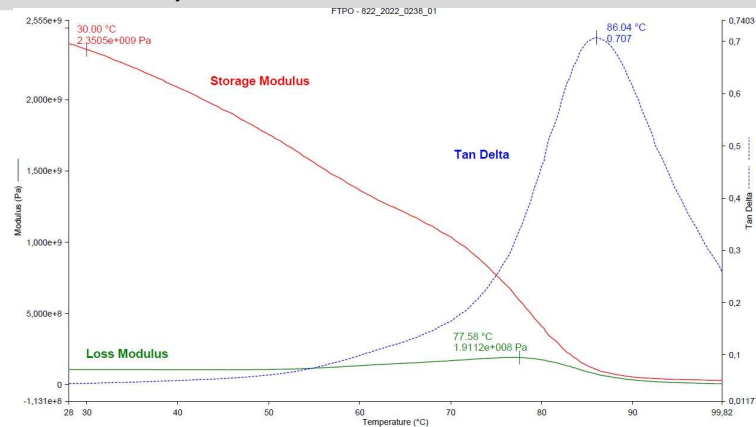
GEMG100 - PVC + AL Technical Data sheet

Product description

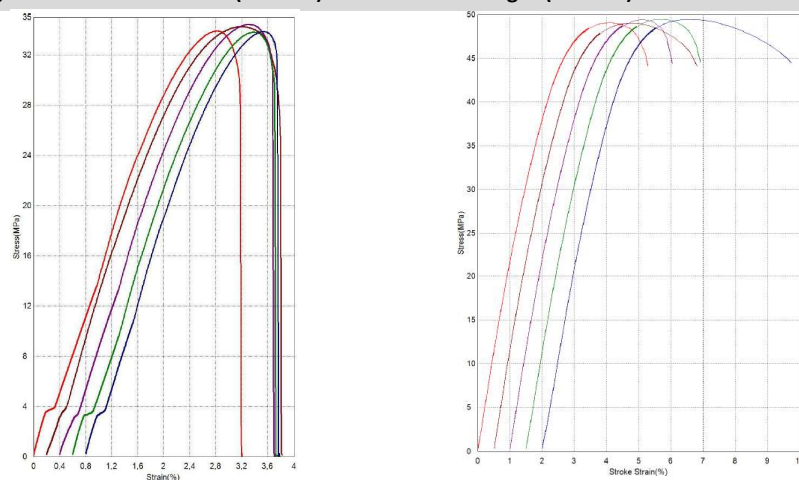
100 % recycled PVC/PVDC industrial waste material from pharmaceutical industry.

Rheological properties	Value	Unit	Test Standard
Melt flow index (175°C, 10kg)	0,09	g/10	ISO 1133
Mechanical properties	Value	Unit	Test Standard
Flexural modulus	2,2	GPa	ISO 178
Flexural strength	49,2	MPa	ISO 178
Flexural strain at flexural strength	4,3	%	ISO 178
Tensile modulus	2,2	GPa	ISO 527, 1BA
Tensile strength	34,1	MPa	ISO 527, 1BA
Strain at tensile strength	2,9	%	ISO 527, 1BA
Nominal strain at break	3,1	%	ISO 527, 1BA
Impact strength at 25 °C (Charpy)	16,3	kJ/m ²	ISO 179
Notched impact strength at 25 °C (Charpy)	3,8	kJ/m ²	ISO 179
Thermal properties	Value	Unit	Test Standard
Glass transition temperature	76,2	°C	ISO 11357-3
Melting temperature	114,0	°C	ISO 11357-3
Degradation temperature	271/311/447	°C	ISO 6964
Ash content	13,0	%	ISO 6964

Dynamic mechanical analysis



σ-ε diagram – tensile test – left (ISO 527) in flexural test – right (ISO 178)



Screw speed	low
100 % recycled PVC/PVDC industrial waste material from pharmaceutical industry.	moderate
Injection speed	low
Hold pressure	low to moderate
Mould temperature	40 °C – 50 °C
Melt temperature*	max. 165 °C
Moisture content	max. 0,1 %
Drying	4 hours at 70 °C

* - higher melt temperature causes degradation

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