



Geon™ HTX M6215

Polyvinyl Chloride Alloy

Key Characteristics

General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• General Purpose	• High Flow	• Medium Impact Resistance
Uses	• Appliances • Automotive Applications • Business Equipment	• Construction Applications • Electrical/Electronic Applications • General Purpose	• Telecommunications
Automotive Specifications	• CHRYSLER MS-DC-28 Type B	• GM GMP.PVC.034	
Forms	• Pellets		

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.26	1.26	ASTM D792
Spiral Flow	34.0 in	86.4 cm	
Molding Shrinkage - Flow	2.0E-3 to 5.0E-3 in/in	0.20 to 0.50 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Modulus ²	340000 psi	2340 MPa	ASTM D638
Tensile Strength ² (Yield)	6400 psi	44.1 MPa	ASTM D638
Tensile Elongation ² (Break)	60 %	60 %	ASTM D638
Flexural Modulus	347000 psi	2390 MPa	ASTM D790
Flexural Strength	10700 psi	73.8 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact			ASTM D256A
32°F (0°C), 0.125 in (3.18 mm), Injection Molded	3.0 ft·lb/in	160 J/m	
73°F (23°C), 0.125 in (3.18 mm), Injection Molded	5.0 ft·lb/in	270 J/m	
Hardness	Typical Value (English)	Typical Value (SI)	Test Method
Durometer Hardness (Shore D)	80	80	ASTM D2240
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 66 psi (0.45 MPa), Unannealed, 0.250 in (6.35 mm)	172 °F	77.8 °C	ASTM D648
Deflection Temperature Under Load 66 psi (0.45 MPa), Annealed, 0.250 in (6.35 mm)	189 °F	87.2 °C	ASTM D648
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed, 0.250 in (6.35 mm)	163 °F	72.8 °C	ASTM D648
Deflection Temperature Under Load 264 psi (1.8 MPa), Annealed, 0.250 in (6.35 mm)	185 °F	85.0 °C	ASTM D648
RTI Elec	122 °F	50.0 °C	UL 746

Thermal	Typical Value (English)	Typical Value (SI)	Test Method
RTI Imp	122 °F	50.0 °C	UL 746
RTI Str	122 °F	50.0 °C	UL 746
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating (0.06 in (1.6 mm), ALL)	• V-0 • 5VA	• V-0 • 5VA	UL 94
Additional Information	Typical Value (English)	Typical Value (SI)	
CSA Flammability ³ (63.0 mil (1.60 mm))	• V-0 • 5VA	• V-0 • 5VA	

It is recommended that the compound pellets be dried for 3 to 4 hours at 150 deg. F.

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Processing (Melt) Temp	395 to 410 °F	202 to 210 °C

Notes

¹ Typical values are not to be construed as specifications.

² Type I, 0.20 in/min (5.1 mm/min)

³ All Colors



Beyond Polymers.

Better Business Solutions.™