



# Geon™ Vinyl Rigid Molding M3815

## Rigid Polyvinyl Chloride

### Key Characteristics

General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• General Purpose • High Flow • High Gloss • High Impact Resistance		
Uses	• Appliances • Business Equipment	• Construction Applications • Electrical/Electronic Applications	• General Purpose • Telecommunications
Agency Ratings	• NSF 51	• NSF 61	
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		

### Technical Properties <sup>1</sup>

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.34	1.34	ASTM D792
Spiral Flow	44.0 in	112 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 <sup>2</sup>	340000 psi	2340 MPa	ASTM D638
Tensile Strength <sup>2</sup> (Yield)	6000 psi	41.4 MPa	ASTM D638
Tensile Elongation <sup>2</sup> (Break)	35 %	35 %	ASTM D638
Flexural Modulus	340000 psi	2340 MPa	ASTM D790
Flexural Strength	9500 psi	65.5 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact			ASTM D256A
0°F (-18°C), 0.125 in (3.18 mm), Injection Molded	2.0 ft·lb/in	110 J/m	
32°F (0°C), 0.125 in (3.18 mm), Injection Molded	5.0 ft·lb/in	270 J/m	
73°F (23°C), 0.125 in (3.18 mm), Injection Molded	13 ft·lb/in	690 J/m	
Hardness	Typical Value (English)	Typical Value (SI)	Test Method
Durometer Hardness (Shore D)	79	79	ASTM D2240
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi (0.45 MPa), Unannealed, 0.250 in (6.35 mm)	162 °F	72.2 °C	
Deflection Temperature Under Load			ASTM D648
66 psi (0.45 MPa), Annealed, 0.250 in (6.35 mm)	167 °F	75.0 °C	
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.250 in (6.35 mm)	156 °F	68.9 °C	

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Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Annealed, 0.250 in (6.35 mm)	163 °F	72.8 °C	ASTM D648
RTI Elec	122 °F	50.0 °C	UL 746
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			UL 94
0.0550 in (1.40 mm), ALL	V-0	V-0	
0.0630 in (1.60 mm), ALL	5VA	5VA	
Additional Information	Typical Value (English)	Typical Value (SI)	
CSA Flammability <sup>3</sup> (63.0 mil (1.60 mm))	• V-0 • 5VA	• V-0 • 5VA	

**Processing Information**

Injection	Typical Value (English)	Typical Value (SI)
Processing (Melt) Temp	390 to 410 °F	199 to 210 °C

**Notes**

<sup>1</sup> Typical values are not to be construed as specifications.

<sup>2</sup> Type I, 2.0 in/min (51 mm/min)

<sup>3</sup> All Colors

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