



MARPOL
PC GP18
 Ethylene Vinyl Acetate



PRODUCT DATA SHEET

General

- Availability
- Processing Method
- Description
- Global
- Injection Molding
- General purpose PC

| Physical | Nominal Value | Test Method |
|--------------------------|-----------------------|-------------|
| Density/Specific Gravity | 1.2 g/cm ³ | ASTM D792 |
| Melt Mass-Flow Rate | 18 g/10 min | ASTM D1238 |

| Mechanical | Nominal Value | Test Method |
|--------------------|---------------|-------------|
| Tensile Stress | | ASTM D638 |
| Yield | 9000 psi | |
| Break | 10000 psi | |
| Tensile Elongation | | ASTM D638 |
| Yield | 6% | |
| Break | 120% | |
| Flexural Modulus | 335000 psi | ASTM D790 |
| Flexural Strength | 13900 psi | ASTM D790 |

| Impact | Nominal Value | Test Method |
|---------------------|---------------|-------------|
| Notched Izod Impact | 800 J/m | ASTM D256 |

These suggestions and data are based on information we believe to be reliable. They are offered in good faith, but without guarantee as conditions and methods of use are beyond our control. We recommend that the prospective user determine the suitability of our materials and suggestions before adopting them on a commercial scale.





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PRODUCT DATA SHEET

| Thermal | Nominal Value | Test Method |
|----------------------------------|----------------|---------------|
| HDT, 1.82 MPa, 3.2mm, Unannealed | 132 C | ASTM D648 |
| Flammability | | |
| Flame Rating (1.5mm) | V-2 | UL 94 |
| Injection Processing | | Nominal Value |
| Drying Temperature | 120 C | |
| Drying Time | 3 to 4 hours | |
| Suggested Max Moisture | 0.02% | |
| Rear Temperature | 270 to 295 C | |
| Middle Temperature | 280 - 305 C | |
| Front Temperature | 295 - 315 C | |
| Nozzle Temperature | 290 - 315 C | |
| Processing (melt) Temperature | 295 - 315 C | |
| Mold Temperature | 70 - 95 C | |
| Back Pressure | .3 - .07 MPa | |
| Screw Speed | 40 to 70 rpm | |
| Vent Depth | .025 - .076 mm | |

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