

### EXTRUSION

### FTM 801R T100

#### GENERALITIES AND USES:

NAKAN<sup>®</sup> products for extrusion are plasticized PVC compounds designed for extrusion of technical profiles.

They present excellent extrudability behaviors and perfectly controlled rheological profiles.

Specifically conceived to reach matt, satin or glossy finishing, NAKAN<sup>®</sup> products for extrusion show outstanding durability.

NAKAN<sup>®</sup> products for extrusion are designed for the extrusion of following parts:

- **AUTOMOTIVE INDUSTRY:** roof trims, windscreen seals, body frames, windows profiles, fuel line covering
- **BUILDING INDUSTRY:** windows seals, various profiles
- **INDUSTRY:** hoses, cables

#### PROPERTIES:

	<b>Standards</b>	<b>Units</b>	<b>Values</b>
Density	ISO 1183	N/A	1,24
Shore hardness	ISO 868	Shore A	80
Tensile strength (100% elongation)	ISO 527	MPa	> 7
Tensile strength (break)	ISO 527	MPa	> 15
Elongation at break	ISO 527	%	> 330
Cold bend	NFT 51105	°C	< -40

#### INFORMATION:

Plasticizer	DEHP
Application	Medical grade
Color	Transparent

## **TRANSFORMATION PARAMETERS:**

It is recommended to process NAKAN<sup>®</sup> products with appropriate PVC transformation tooling.

We advise to process NAKAN<sup>®</sup> products preferentially with shearing instead of with heat input.

We consequently advise following parameters to be used:

- Start processing with a temperature profile about 10°C lower than recommended.
- Depending on the desired appearance (matt, satin or glossy) and on the dimension of the final part, increase the temperature 5°C by 5°C starting from the extrusion die to the feed section.
- Do not exceed 140°C at the feed section to avoid an excessive fast-softening that would prevent good mechanical shearing.

<b>Properties of the extrusion screw</b>	
Length / diameter ratio (L/D)	22 to 24
Length of the feed section	3 to 5 times the diameter
Length of the compression section	11 to 15 times the diameter
Compression ratio	3 à 4
Length of the metering section	4 à 6% of the diameter

<b>Extrusion temperatures</b>	
Zone 1 (°C)	140
Zone 2 (°C)	150
Zone 3 (°C)	150
Zone 4 (°C)	155
Head (°C)	160
Extrusion die (°C)	165
Filter (mesh)	2 x 80

## **STORAGE CONDITIONS:**

Storage at temperatures between 5 and 40°C.

Storage in covered store.

## **CERTIFICATES AND APPROVALS:**



**Heavy metals:** NAKAN<sup>®</sup> products are compliant with the 2000/53/EC EU directive. They do not contain any heavy metals (Lead-Pb, Cadmium-Cd, Mercury-Hg or Chromium<sup>IV</sup>-Cr<sup>IV</sup>).



**RoHS:** NAKAN<sup>®</sup> products are compliant with the 2002/95/EC EU directive (RoHS) on the restriction of the use of certain hazardous substances in electrical and electronic equipment.

**RESINOPLAST**  
A KEM ONE COMPANY

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