

DOSAGE RECOMMENDATIONS OF POLYCOM-P IN VARIOUS PVC APPLICATIONS

APPLICATIONS	PVC INJECTION MOULDING	PVC PIPE	PVC PROFILES	PVC PANELS	PVC SHEETS / FILM	WPC	PVC FOAM BOARDS	PVC FOAM PIPES
POLYCOM P DOSAGES IN PHR	0.75 - 2.0	0.75 - 1.5	1.0 - 2.0	1.0 - 2.0	1.0 - 2.5	2.0 - 5.0	1.0 - 3.0	1.0 - 3.0

POLYCOM-P CUSTOMER TRIAL REPORT FOR PVC PROFILES

Product: PVC Profile



Without POLYCOM-P



With POLYCOM-P

Product	PVC Profile									
Formulation		PVC	Stabiliser	IMPACT MOD	TiO2	PE WAX	COLOR	Calcium	Processing Aid	Polycom P
	Regular 1st Layer	100 kg	4 kg	5 kg	4 kg	0.5 kg	0.5 kg	10 kg	2 kg	0
	Trial 1	100 kg	4 kg	4 kg	4 kg	0.5 kg	0.5 kg	10 kg	0	1.5 kg
	Trial 2	100 kg	4 kg	3.5 kg	4 kg	0.5 kg	0.5 kg	10 kg	0	1.5 kg
	Trial 3	100 kg	4 kg	3 kg	4 kg	0.5 kg	0.5 kg	12 kg		2 kg
Trial Results	1. Trial done with Polycom-P with 2 Kg and the result was very good with reduction of Impact Modifier. 2. Also with Polycom-P we replaced the processing aid 2kg and little increased dosage of calcium. 3. Strength, Shining, Gloss and Finished surfaces also increased. 4. Customer could also reduce the cost by reducing impact modifier & by replacing processing aid. 5. With addition of higher dosages of calcium, the profile properties do no effect. More strength of the final product. 6. In Trial 1 & Trial 2, there was no droppage of properties in the profile.									

POLYCOM-P CUSTOMER TRIAL REPORT FOR PVC PIPES

Product: PVC Non Pressure Pipe



Without POLYCOM-P



With POLYCOM-P

Formulation	PVC	CaCO3	Stabiliser	Steric Acid	CPE	WAX	Processing Aid	Polycom P	
Regular	100	33	2.5	0.85	3	1	1.8	NIL	
Trial 1	100	33	2.5	0.85	2	1	-	2	
Trial 2	100	40	2.5	0.85	-	1	-	2.5	
	BARREL				DIE				
Temperature parameters	Regular	195	195	195	155	155	160	189	202
	Trial 1	195	195	195	155	155	160	189	202
	Trial 2	195	195	195	185	170	175	180	202
Trial Results	1. Replaced PROCESSING AID by POLYCOM-P 2. Better Gloss, shining and high colour intensity observed . 3. Removed CPE, and passed the impact test. As impact is better so, increased CaCO3 4. Color intensity increased so reduced color master batch 5. Gelation time reduced though with more calcium carbonate 6. Standard impact strength 4.5 Kg . in 1st trial it pass no single crack found 7. 2nd trial impact test did with 6 Kg, no single crack found 8. Lower gelation time, so increased line speed, so higher output of the plant.								

POLYCOM-P CUSTOMER TRIAL REPORT FOR PVC FITTINGS

Product: PVC Fitting



Without POLYCOM-P



With POLYCOM-P

Formulation	PVC	Stabiliser	Impact Modifier	TiO2	PE WAX	Processing Aid	Polycom P	
Regular	100 Kg	4 Kg	1.5 Kg	4 Kg	0.6 Kg	1.5 Kg	0	
Trial 1	100 Kg	4 Kg	1 Kg	4 Kg	0.6 Kg	0	1.5 Kg	
Trial 2	100 Kg	4 Kg	0.5 Kg	4 Kg	0.6 Kg	0	1.5 Kg	
	BARREL				DIE			
Temperature parameters	Regular	Z1	Z2	Z3	Z4			
	Trial 1	190	183	180	168			

Trial Results	1. Replace Processing Aid with POLYCOM-P, no changes in the processing 2. If they make the Processing Aid 1.4 Kg product it cannot process or it cannot produce 3. Reduce dosage of Modifier, getting same impact properties 4. When they reduce the dosage of Modifier 0.1 Gram it fails in pressure test 5. Doing 3 quality test as below (1) Heat detention at 150 degree celcius, (2) Pressure test 67 barr , (3) Vicat softening test 6. With POLYCOM-P all 3 quality test passed (1) Heat detention at 150 degree celcius, (2) Pressure test 67 barr , (3) Vicat softening test
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