



Data sheet

Granule Type: S8648

PVC Compound

Description

General Purpose PVC Fixed Sheathing Compound

Specification

IEC 60502: PVC/ST1 & ST2\ IEC 60227: PVC/ST4

Color

Natural and Colors

Physical Properties

Properties	Standard and Test Method	Unit	Typical Value
Hardness	ASTM D2240(15sec)	Shore A	86
Density	ASTM D792 / IEC 60811-1-3	gr/cm ³	1.48±0.01
Heat Stability at 200°C	VDE 0472/9.71	minute	min 80
Properties before ageing Tensile strength Elongation at break	IEC 60811-1-1	N/mm ² %	min 13.5 min 200
Properties after ageing "7 days at 100°C" Variation of Tensile Variation of Elongation	IEC 60811-1-2	% %	max 25 max 25

Processing Guidelines

1- The actual extrusion conditions will depend on the type of equipment used. The following conditions may be used as a guide when starting up the extruder.

	Zone 1	Zone 2	Zone 3	Zone 4	Head	Die	Screw*
max (°C)	150	160	160	165	170	180	70
min (°C)	130	140	150	150	160	170	80

* The thermostatic control of the screw improves processing results.

Extruder L/D= 20-26

2- Head and tools should be designated allowing streamlined flow avoiding stagnation of the material.

3- A breaker plate and filter net (80 -100 mesh/cm²) are recommended to be used.

**Storage**

- Packaging should be keep closed during storage
- Ambient temperature should not exceed more than 40°C
- Avoid direct exposure to sunlight and humid weathering
- Shelf life of the compound is 12 months from the date of manufacture.

Packaging

It is available in the form of pellets and supplied in PP bags with a net content of 25 kg.

Safety

S8648 is classified as no-dangerous material.