



INDOFIL K-120CL

Acrylic Processing Aid for PVC products
(Clear & Opaque Applications)

1 INTRODUCTION

INDOFIL K-120CL is a fine, white, free flowing powder with uniform particle size. It improves the processing of rigid and semi rigid polyvinyl chloride (PVC). PVC containing INDOFIL K-120CL processing aid, fuses rapidly, flows smoothly, has excellent hot strength and is readily formed. Additionally the excellent dispersibility of INDOFIL K-120CL processing aid eliminates the gels & fish eyes that mar the surface of PVC products.

It is recommended to use for PVC products such as calendared film, shrink film, pipes & fittings, PVC profiles etc.

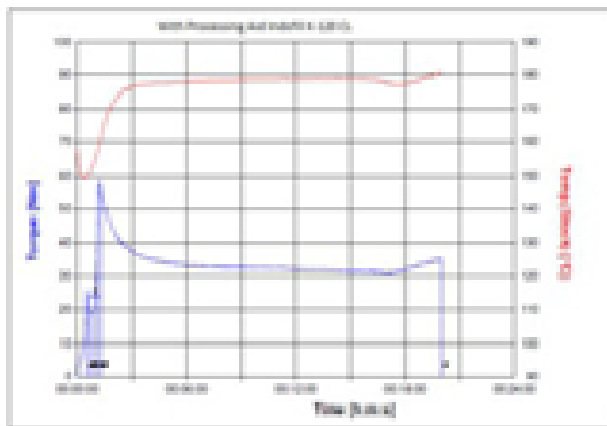
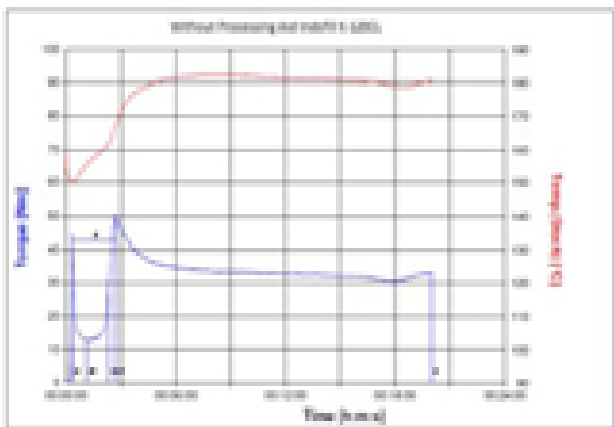
2 PHYSICAL CHARACTERISTICS

Typical Physical Properties (These do not constitute specifications)	
Appearance	White, fine free-flowing Powder with uniform Particle size
Bulk Density ,g/cc	0.30 - 0.45
Volatiles (%)	Max 1
Sieve Test Retention	
60 mesh	Max 5
100 mesh	Max 8
200 mesh	Max 60
Clarity in 10% toluene Solution	Clear

3 PERFORMANCE CHARACTERISTICS

3.1 Processing and Rheological Properties

The performance characteristics of Indofil K-120CL are determined on Brabender Plasticorder for fusion behavior study. Below Graph represents Rheological properties with & without Indofil K-120CL



Indofil K-120CL processing aid is especially suitable for clear applications such as calendared films, extruded films & sheets. However it is also well suitable for opaque PVC application, especially designed for thin gauge films & sheets, etc. Fusion study of Indofil K-120CL (with & without PA) were carried out on Brabender with 160°C temperature, 60rpm & stock weight 52g. (Both formulations were Tin-stabilized).

The results are as below

	Blank (Without PA)	Indofil K-120CL 2 phr
Fusion time (sec)	142.85	42.85
Fusion TQ (Nm)	51.05	59.47
Fusion Temperature (°C)	167	163
Equilibrium TQ (Nm)	32.63	32.10

Table: PVC K-67, Temperature- 160°C, RPM-60, Weight- 52 gms,

Formulation	Parts
PVC(K-67)	100.0
Methyl Tin Stabilizer	1.5
Glycerol Monostearate	0.7
OP Wax	0.3
Processing Aid	2.0

4 APPLICATIONS

INDOFIL K-120CL processing Aid can be used for a wide range of PVC products including:

- Calendaring products
- Injection molded parts
- Pipes & conduits
- Extruded profiles

Recommended Dosage 1 to 3 phr

