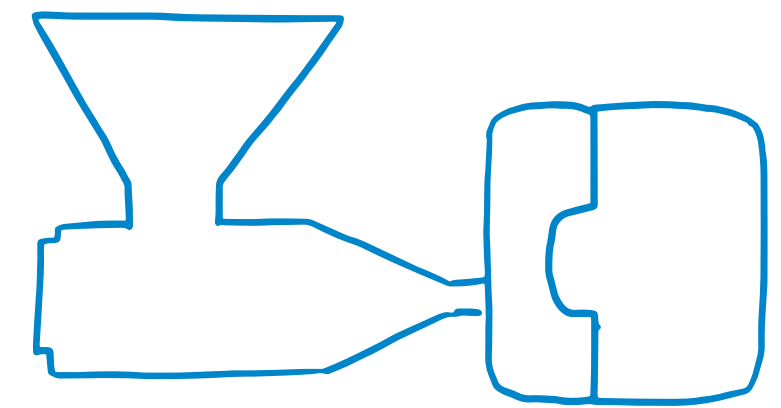


A Material Difference

Lifolit®

Soft PVC Processing Guide

soft
PVC



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Introduction

Lifolit are a family of high-quality, soft polyvinyl chloride (PVC) compounds, custom formulated to your requirements.

PVC is a building block of our daily lives, its versatility and performance benefits make it an ideal choice for a wide variety of applications in the construction, consumer, industrial, toy and automotive markets.

We have engineered flexible PVC compounds with very high flowability, ideal for injection moulding, as well as highly viscous grades for extrusion. Lifolit PVC compounds result in fast cycling times, meaning low energy costs during manufacture of the final application. Recycling of finished products is also possible

In the following pages we provide processing guidelines for the injection moulding and extrusion of Lifolit PVC compounds. The following process temperatures and parameters are suggested as starting conditions. Optimization of these suggestions may be necessary. The actual parameters will depend on the machine and the mould being used.

Injection Moulding Guidelines

Mould: Stainless steel with a minimum chromium content of 13% (preferably 16%) is recommended for mould building. If the application allows, highly polished or chrome plated mould and runner surface is beneficial for steel protection.

Injection Speed: Slow to medium

Back Pressure: Low

The injection and holding pressures are determined by filling properties, mould design and part size.

Compression Ratio: 2:1 to 2.5 : 1

L/D Ratio: $\geq 20 D$

Barrel Capacity: 1.5 to 2 times the shot capacity

Gating: Due to the thermal and shear sensitivity of all PVC compounds, liberal gating is recommended. If possible, use full round runners.

Injection Moulding Guidelines

Drying: Predrying is normally not necessary

Colouring: Only use pigments. Due to the risk of colour bleeding, migration or leaching, dyes should not be used

Purging: PVC compounds are thermal and shear sensitive and care must be taken to avoid excessive heating or delays during the moulding process. Do not allow the PVC to sit idle in the screw for more than 10 – 15 minutes. Turn off heat. During stoppage, the machine should be purged with polyethylene (PE) until all the PVC compound is removed. Then purge the remainder of the PE and turn off the heat.

Typical Shrinkage Values: See table, exact values should be determined by independent testing

Grade Hardness	Filled	Unfilled
50 to 70 Shore A	1.8 - 2.1%	1.5 - 1.8%
70 to 80 Shore A	1.2 - 1.5%	1.0 - 1.2%

Injection Moulding Recommended Temperatures

Melt Temperature: The melt temperature should not exceed 200°C. PVC is heat sensitive, decomposition could occur.

Mould Temperature: 30 - 60 °C

Hardness Shore A	Barrel Temperatures °C	Melt Temperatures °C
50 - 70	130 - 170	170 - 180
70 - 80	140 - 175	175 - 185
80 - 90	145 - 185	180 - 195

Extrusion Guidelines

Screw Design: Standard 3 zone screws with a length of (L/D ratio) 20 – 24 D and compression ratio of 2:1 to 2.5:1 are recommended. Highly polished or plated, streamlined dies are recommended for PVC.

Drying: Predrying is normally not necessary

Colouring: Only use pigments. Due to the risk of colour bleeding, migration or leaching, dyes should not be used

Purging: PVC compounds are thermal and shear sensitive materials. We recommend that you do not leave the material in the screw for more than 15 minutes at an elevated temperature. However, if this is unavoidable, allow the extruder to run at a slow speed so that the material is kept moving. During stoppage, open the head and clean the adapter, tooling and all other parts immediately. Then reduce the temperatures and allow the machine to empty.

Extrusion Recommended Temperatures

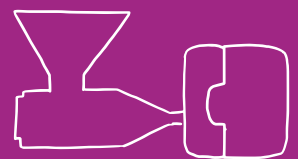
Melt Temperature: The melt temperature should not exceed 200°C. PVC is heat sensitive and decomposition could occur. Normally, the standard temperature profiles used are low to high from feed to die. Running a reverse temperature profile is also possible.

Hardness Shore A	Barrel Temperatures °C	Melt Temperatures °C
50 - 70	125 - 160	155 - 165
70 - 80	135 - 169	165 - 175
80 - 90	140 - 180	175 - 180

More Product Ranges

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Dryflex® SE



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Epseal®




Dryflex® 2K

2K

Lifobatch®



Dryflex® Circular



Lifocork®



Dryflex® Green



Dryflex® DW



Dryflex® HiF



Dryflex® Interior

VOC




Dryflex® Flam



Dryflex® T



Dryflex® C



Dryflex® TPV

TPV

ABOUT US



info@hexpolTPE.com | www.hexpolTPE.com

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T/P.A. CAPACITY

Across our Sweden, UK, German, China & North America operations. [Our companies](#)

50+
YEARS HISTORY

We've a proud history in flexible polymer compounding & were among the 1st to produce TPEs in Europe. [About us](#)

34,795+
FORMULATIONS

A comprehensive portfolio in TPE, TPS, TPO, TPU, TPV, soft PVC & Biobased technologies. Learn more about [Our products](#)

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