



# Ddev Plastiks Industries Limited

## TECHNICAL DATA SHEET

### KI – 60 (BK) GUM: PVC Compound

#### Description:

**KI – 60 (BK) GUM** is suitable for injection molding foot wear gumboot application, formulated with a high-quality resin with plasticizers, stabilizers and other additives. Special additives are added to make the compound.

#### Typical Properties:

Property	Unit	Test Method	<b>KI-60 (BK) GUM</b>
Sp. Gravity @27 <sup>o</sup> C		ASTM - D – 792	1.250±0.03
Hardness @27 <sup>o</sup> C	Shore A	ASTM - D 2240	60 ± 2
Thermal Stability@200 <sup>o</sup> C	Minutes	IS : 10810 (60)	≥ 40
Tensile Strength (TS) @27 <sup>o</sup> C	MPa	IS : 10810 (7)	≥ 8.0
Elongation at Break (E.B) @27 <sup>o</sup> C	%	IS : 10810 (7)	≥ 200
Volatile Loss @130 <sup>o</sup> C for 3 hours	%	IS : 6719	≤1.00

\* Test specimen made after milling the granules and then in compression molded at 160 °C for 10 min with 200kg / cm<sup>2</sup> hydraulic pressure

Above Values are Typical value of Compound and customer need to check before accepting the TDS.

**Color:** Black

#### Processing:

**KI – 60 (BK) GUM** can be processed on any good injection molding designed for PVC at temperature in the range of 140<sup>o</sup>C- 180<sup>o</sup>C.This is the guideline temperature range; actual temperature should be optimized by the user depending upon the other processing variables. The screw must have a good homogenizing capacity. Preheating of granules at 70+/-5<sup>o</sup>C for 10 minutes is always advisable for better processing.

#### Packaging:

**KI – 60 (BK) GUM** is available in the form of free-flowing pellets and supplied in bags with sealed double layer PE liner to prevent moisture. The finished bag weight is either 25 kg woven sacks bag or in 1000kg jumbo bags.

#### Storage:

Material should be store in moisture free cool & dry place.

#### Safety:

**KI – 60 (BK) GUM** is not classified as a dangerous product group.

The information and recommendations contained in this bulletin are, to the best of our knowledge, accurate and reliable but no guarantee of their accuracy is made. These are all the typical values only and subject to change without prior intimation. The product is sold upon condition that purchaser should make their own tests to determine the suitability of such product of their particular purpose and purchasers assume all risks and liability for the results of the use of the product.

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