

DATA SHEET

hy-vin[®] VQ130

Description	Rigid PVC Injection Moulding Compound
Colour	Clears and Colours
Application	Rigid Medical mouldings
Specification	Meets Heavy metal requirements of BS2463, Freedom from toxicity tests & US Pharmacopoeia Class VI biological tests for plastics
Form	Pellets
SDS No.	27

<u>PROPERTIES</u>	<u>UNITS</u>	<u>TYPICAL RESULTS</u>
(These values do not form part of a specification)		(Based on B.S. 2782)
Density (varies with colour)	kg/m ³	1347
Softening Point		
Vicat, 5kg load	°C	72.3
Vicat, 1 kg load	°C	78.0
Mould Shrinkage	%	0.3 (DTM 225)
Tensile Stress @ 50 mm/min		
At Yield	MPa	44.8
Impact Strength	KJ/m ²	7.8
Charpy 0.25 V edge notch @ 23°C		

PROCESSING CONDITIONS

Customers are recommended to determine optimum conditions for themselves as these will vary depending on the particular moulding tool and injection moulding machine being used. As a general guide, a reciprocating screw machine with compression ratio between 2:1 and 2.5:1 together with stainless steel tooling is preferred. The following conditions have proved satisfactory for a Negri Bossi NB90 injection moulding machine.

Barrel Temperature °C	<u>Zone 1</u>	<u>Zone 2</u>	<u>Zone 3</u>	<u>Nozzle</u>
	150	155	160	170
Mould Temperature	25°C			
Injection Pressure	120 Bar			
Screw Speed	50rpm			
Back Pressure	1-5 Bar			