

## PVC - QUALITY REQUIREMENT

### K-Value DIN 53726

|                   |               |
|-------------------|---------------|
| Injection molding | K – 60 ... 68 |
| Profile extrusion | K – 60 ... 68 |
| Window profile    | K – 68 ± 1    |
| Pipe extrusion    | K – 68 ... 70 |

### K-Wert

|                 |
|-----------------|
| Spritzguss      |
| Profilextrusion |
| Fensterprofil   |
| Rohrextrusion   |

|                        |                               |
|------------------------|-------------------------------|
| Density 23°C DIN 53479 | 1,40 ± 0,03                   |
| Bulk density DIN 53466 | 0,56 - 0,60 g/cm <sup>3</sup> |

|              |
|--------------|
| Dichte       |
| Schüttdichte |

|                              |         |
|------------------------------|---------|
| Volatile Ingrediens ISO 1269 | ≤ 0,3 % |
| Humidity ISO 1269            | ≤ 0,3 % |

|                   |
|-------------------|
| Flüchtige Anteile |
| Restfeuchtigkeit  |

|                         |                 |
|-------------------------|-----------------|
| Sieve tailings ISO 1624 | 0,063 mm ≥ 95 % |
|                         | 0,250 mm ≤ 5 %  |

|                |
|----------------|
| Siebrückstände |
|----------------|

|                     |                      |
|---------------------|----------------------|
| Viscosity DIN 53492 | funnel 10mm ≤ 20 sec |
|---------------------|----------------------|

|                 |
|-----------------|
| Rieselfähigkeit |
|-----------------|

### RAL German Window Standard:

Die Werkstoff-Formmasse muß gemäß DIN 7748, Teil 1 in den kennzeichnenden Eigenschaften den Mindestwerten einer Formmasse DIN 7748-PVC-U,E,D (G) PL, 076-25-23 entsprechen.

The material-mass must be according to DIN 7748, part 1 characteristics. Form-mass DIN 7748-PVC-U,E,D (G) PL, 076-25-23.

The used Material must correspond to DIN 7746 and the bulk density and free flowing property of PVC compound must be in tolerances at +/- 3%.

