

VS 5-052-97 ML 26



Plasticized polyvinyl chloride film type 656

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Issue: 2

1 General characteristics

Plasticized polyvinyl chloride (PVC-P) film type 656 is produced by calendering technology. There are no phthalate plasticizers contained in our film recipes from - the rolls are denoted by white label with red sign "NEW". This film is not tested for the amount of phthalates and may contain more than 0.1 % of phthalates. On customer's request, the film can be made as a semi-product for products for children of up to 3 years - the rolls are denoted by blue label (in the name is "D" behind the type number). This film is tested for the amount of phthalates (max. to 0,1 %) - is guaranteed by compliance with ES 1907/2006 (REACH), Annex XVII, item 51 and 52. Due to the requirements of the customer on the special properties of the film it may be produced from recipes that include phthalate plasticizers or other special components or other special components - the rolls are denoted by yellow label.

On customer's request, the film can be made in powdered version by using natural cornflour to prevent adhesiveness ("P") and stabilized against solar radiation ("UV"). The film is designed for making tent's windows. It may be handled at temperatures ranging from +5 °C to +40 °C and may be high-frequency welded or glued. If it is mechanically strained at temperatures below 0 °C, the film becomes rigid and fragile, so there is a danger it may develop cracks. In case of connecting more than one type of PVC-P film, it is recommended using the films of approximately the same hardness from the same producer (i.e.FATRA, j.c.). It is necessary to combine the films with the same color label. All films eventually used for production of the final product have to be connected in the same direction of calendaring. Otherwise the producer cannot guarantee the quality of the final product.

Packing, the size of basic packing units as well as marking of the product may be standard i.e. wound on cardboard tubes, wrapped in PE tubing, laid in horizontal layers and fixed on EUR pallet or various packaging can be agreed on at customer's request in writing. Transport of the film has to be made by a dry, clean and covered vehicle. The film may not be transported together with organic solvents, acids or any other chemicals that are not chemically inert towards this film. Storage within temperatures ranging from +5 °C to +35 °C.

2 Dimensions

Thickness [mm]	Width [mm]	Quantity in one roll [m]
0.25 ± 0.02	(800 - 1400) ± 20	100
0.30 ± 0.03		
0.35 ± 0.03		50

3 Technical specifications

Property	Value	Unit	Test Method/ Standard
Hardness at (23 ± 2) °C	81 ± 3 85 ± 3	Sh A	ČSN EN ISO 868 (after time 3 s)
Density (informative value)	1.24	g/cm ³	ČSN EN ISO 1183-1
Tensile strength at break, min.	16	MPa	ČSN EN ISO 527-1 ČSN EN ISO 527-3
Elongation at break, min.	250	%	500 mm/min test specimen type 5
Dimensional stability (125 °C, 6 min), max.	±8	%	ČSN 64 0610
Brittleness temperature	-30	°C	PN 4545/98 (ISO 974)

PN ... Company Standard

END