

**For Window Profile , PVC Faux Wood & Blinds**

# ***LHR - 300***

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***Series***

Sakai Chemical Industry Co., Ltd.  
Plastic Additives Division

# REQUIRED PERFORMANCE

*Technical Information*

Weatherability : Antichalking

Charpy Impact : Satisfactory Up To

5 kJ/m<sup>2</sup>, -10° C Charpy

Gross : Appearance of Surface

Plate Out : At Die or Calibrator

Discoloration : Anti-Pinking

## Plate-Out Issues

Cause)

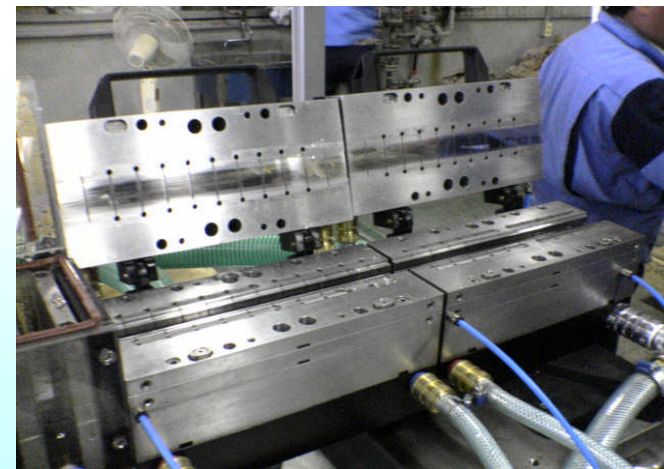
Mixture of  $\text{CaCO}_3$  and  $\text{TiO}_2$  Deposit on Dies

On Dies)

- Anti-Plate-Out Agent Is Effective
- Fast Fusion Is Effective
- Do NOT Use Low-Solubility Materials

On Cooling Calibrator)

- Do NOT Use Sublime Materials
- Anti-Plate-Out Agent Is Effective



# RECOMMENDED FORMULATION

## (Window Profile A)

*Technical Information*

PVC(1000)	100
CaCO <sub>3</sub> (Micronized heavy CaCO <sub>3</sub> )	8
TiO <sub>2</sub> (Sakai R-3L)	3 – 4
IM (KANEACE FM-50)	7
PA (KANEACE PA-10)	0.5 – 1.5
LHR-300 Series (Ca/Zn Stabilizer)	3 – 4
Ester-WAX (Internal Lubricant)	0.2
Fatty Acid (Internal Lubricant)	0.2
Ester WAX or PE WAX (External Lubricant)	0.3

# RECOMMENDED FORMULATION

## (Window Profile B)

*Technical Information*

PVC(1000)	100
CaCO <sub>3</sub> (Micronized heavy CaCO <sub>3</sub> )	8
TiO <sub>2</sub> (Sakai R-3L)	3 – 4
IM (KANEACE FM-50)	3 – 5
Chlorinated PE	3 – 5
PA (KANEACE PA-10)	0.5 – 1.5
LHR-300 Series (Ca/Zn Stabilizer)	3 – 4
Ester-WAX (Internal Lubricant)	0.2
Fatty Acid (Internal Lubricant)	0.2
Ester WAX or PE WAX (External Lubricant)	0.3

# RECOMMENDED FORMULATION

## (Foamed PVC-Window Decoration)

*Technical Information*

PVC(1000)	100
ADCA	1.0
PA (KANEACE PA-60)	3.0 – 8.0
LHR-300 Series (Ca/Zn Stabilizer)	3 – 4
Calcium Stearate (Internal Lubricant)	0.2 – 0.5
Stearyl Alcohol (External Lubricant)	0.5
Paraffin WAX or PE WAX (External Lubricant)	1.0

# RECOMMENDED FORMULATION (PVC FauxWood)

*Technical Information*

PVC(1000)	100
Wood Powder	20
DOP	2
PA - 1 (KANEACE PA-30)	3.0
PA - 2 (KANEACE PA-20)	2.0
LHR-300 Series (Ca/Zn Stabilizer)	3 – 4
LBT-754 (Internal Lubricant)	1.5
Paraffin WAX or PE WAX or Ester WAX (External Lubricant)	0.5