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March 20, 1964

cc

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Acetone Test Method - PVC Pipe

Your letter March 9, 1964

Our comments on the test method changes for PVC acetone are as follows:

I. Test Temperature 75 to 80° F

Test temperature checks show floor temperatures vary from 55° F. to 80° F. In order for us to hold the acetone to a minimum temperature of 70° F., we investigated (a) placing the acetone at the base of the extruder and using the extruder heat. Safety requirements ruled this out - (b) construction of a central production acetone temperature bath for all machine acetone test samples. Cost approximately \$150. (Items 1 - 2.)

All acetone samples presently are saved and checked by Quality Control. If failure occurs, Q. C. checks production sheets for disposition of production during the failure period. Rechecks are run on the dimensional samples from the production bundles. These re-tests are run under laboratory conditions (Items 3 - 4). When failure shows on floor, we generally confirm in laboratory. The degree of flaking is the only discernible difference.

II. Sectioning of all acetone samples

We do not feel this is required. Our small diameter 160 psi pipe is run on No. 5, 2 1/2 Prodex. We have never had a failure either as extruded or sectioned. In fact, some pipe has been left in acetone for long periods at 730 F. with no failure shown. We feel that the additional labor in filing down samples on less than .125 wall (one each hour) is not warranted in our situation.

The reason for filing down samples is to remove the skin which could have been fused by die heats only. When running

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small (1/2 - 2") 160 PVC on No. 5, the melt comes from the screw work. Our die heats are run low in temperature.

Filing down samples with less than .125" wall to .0625" leaves out 1/2 - 1 1/4 160 psi pipe, since these walls are .060 to .064". If 1 1/2 and 2" are filed down to .0625", we find the sample will split. We do not consider this a failure.

On all sections above .125" wall we agree the wall should be removed.


W. E. Volwiler - Franklin
by R. M. Hutchison

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