



INDUSTRIES, INC.

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April 4, 1986

To: Mr. Don Sullivan, Vice President
From: A. Otomi

Re: PVC RECIPES of 865 850

Enclosed are pvc compound recipes
The details of the pvc recipes are as follows

(1) No. of recipes : two

70 PVN072 : 865 850 Walt Body Side
76921/2 63Aoo 76921/2 01G10

90 PVN163 : 850 w/s upper
73965 01G10

Please make the recipes with U.S materials and develop the properties
by the middle of June.
We are going to use the pvc compound begining in August.

Best regards

CHARDO 02232

The recipe are used 865 850 Welt Body S IDE
 Parts number 76921/2 63A10 . 76921/2 01G10

code	PVNO72	
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Ingredient	PHR	Quantity (kg)	Remark
CS1100	100	75000	pvc resin
DEP	23.60	17700	plasticizer
DOP	35.00	26300	"
E-410	13.00	9750	SAE D
MARK AC141X	2.00	2147 1500	Complex stabilizer
OW-442	2.00	NO 1500	"
HOC-RR	20.00	15000	White filler
KP-200	20.00	15000	White filler
662	3		
Total	215.35	161750	

Sp.gr	1.358
Hardness	71
TB (kg/cm ²)	122
Eb (%)	349
M100	49
Tear	33

1730

760

CHARDO 02234

THE DETAIL OF INGREDIENT

4

CS-1100

Straight resin
Average degree of polymerization : 1040
Pour density : 0,51
Volatile matter : 0,2%
Degree of particle 60 mesh pass : 99%
200 mesh pass : 2,0%

E-410

Chlorinated paraffin (40% chlorinated)
Sp, gr : 1,151
Viscosity : 130cp(2%)

OW-442

Complex stabilizers (HEAT RESISTANCE) powders
Ingredient BA-ZN-CA complex
Outlook white powder
Water less than 1%
Pour density 0,38±0,05
Degree of particle (74μ) more than 99%
Metal content BA : 7,0±0,7%
ZN : 2,6±0,3%
CA : 9,8±1,0%

MARK AC-141

Complex stabilizers (heat resistance)
Ingredient BA-zn complex
SP, gr 0,995~1,007
Viscosity(cp) 40~100
Refractive index 1,489~1,493

HOC-R

Ultrafine activated calcium carbonate
treated fatty acid

KP-200

Heavy or ground calcium carbonate