

Nano Composite

VNCT-39 Application Instruction

VNCT-39 dosage instruction sheet (unit: KG)						
Item	Ratio	PVC (kg)	Calcium	Total weight (kg)	Pure Nano	Heavy Calcium (kg)
1	1:1	50	50	100	7.38	4.92
2	<3:2	50	40	90	6.41	4.74
3	<3:2	50	34	84	5.81	4.57
4	3:2	75	50	125	8.63	6.84
5	>3:2	75	45	120	8.12	6.58
6	2:1	50	25	75	4.92	4.21
7	2:1	75	37.5	112.5	7.38	6.32
8	>2:1	75	30	105	6.65	5.8
9	3:1	75	25	100	6.16	5.28
TIPS	The dosage can be adjusted by 5% up or down according to the actual situation.					

5 thrilling steps to manufacture fine PVC edge banding:

50kg PVC resin: 50kg Heavy Calcium. 65 granulator

- ① Take 50kg of PVC resin (SG-5) + VNCT-39 Nano Composite (4.92kg) + some pigment were poured into the mixing tank one by one, then add 50kg of heavy calcium powder, and start the high-speed continuous mixing.
- ② Stir to 82 °C and add 1.6kg of DOP (This dosage is suitable for the thickness of 0.5~1.2mm).
- ③ Stir at high speed to 135°C to discharge.
- ④ Enter the granulation process, set all 6 sections of 65 granulator temperature control to 170~175 °C (horizontal plate temperature control method), if the electricity current is ok, granulate normally.
- ⑤ Extrusion molding process, operate the single screw as usual. If there is surface flatness issue, to increase the temperature can get improvement. (e.g. Front sideways 180~190 °C , mould 235°C)

100kg PVC resin: 100kg Heavy Calcium. 80 granulator

- ① Take 100kg of PVC resin (SG-5) + VNCT-39 Nano Composite (9.84kg) + some pigment were poured into the mixing tank one by one, then add 100kg of heavy

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- ② calcium powder, and start the high-speed continuous mixing.
- ② Stir to 82°C and add 3-4kg of DOP (This dosage is suitable for the thickness of 0.5~1.2mm, if thickness >1.2mm, add corresponding portion DOP).
- ③ Stir at high speed to 135°C to discharge.
- ④ Enter the granulation process, set all 7 sections of 80 granulator temperature control to 170~175 °C (horizontal plate temperature control method), if the electricity current is ok, granulate normally.
- ⑤ Extrusion molding process, operate the single screw as usual. If there is surface flatness issue, to increase the temperature can get improvement.

75kg PVC resin: 50kg Heavy Calcium. 65 granulator

- ① Take 75kg of PVC resin (SG-5) + VNCT-39 Nano Composite (6.84kg) + some pigment were poured into the mixing tank one by one, then add 50kg of heavy calcium powder, and start the high-speed continuous mixing.
- ② Stir to 82°C and add 2-3kg of DOP (This dosage is suitable for the thickness of 0.5~1.2mm, if thickness >1.2mm, add corresponding portion DOP).
- ③ Stir at high speed to 135°C to discharge.
- ④ Enter the granulation process, set all 6 sections of 65 granulator temperature control to 170~175 °C (horizontal plate temperature control method), if the electricity current is ok, granulate normally.
- ⑤ Extrusion molding process, operate the single screw as usual. If there is surface flatness issue, to increase the temperature can get improvement. (e.g. Front sideways 180~190 °C , mould 235°C)

50kg PVC resin: 25kg Heavy Calcium. 65 granulator

- ① Take 50kg of PVC resin (SG-5) + VNCT-39 Nano Composite (4.21kg) + some pigment were poured into the mixing tank one by one, then add 25kg of heavy calcium powder, and start the high-speed continuous mixing.
- ② Stir to 72°C and add 1.6kg of DOP (This dosage is suitable for the thickness of 0.5~1.2mm, if thickness >1.2mm, add corresponding portion DOP).
- ③ Stir at high speed to 135°C to discharge.
- ④ Enter the granulation process, set all 6 sections of 65 granulator temperature control to 170~175 °C (horizontal plate temperature control method), if the electricity current is ok, granulate normally.

⑥ Extrusion molding process, operate the single screw as usual. If there is surface flatness issue, to increase the temperature can get improvement. (e.g. Front sideways 180~190°C, mould 235°C)

75kg PVC resin: 25kg Heavy Calcium. 65 granulator

① Take 75kg of PVC resin (SG-5) + VNCT-39 Nano Composite (5.28kg) + some pigment were poured into the mixing tank one by one, then add 25kg of heavy calcium powder, and start the high-speed continuous mixing.

② Stir to 72°C and add 2.4kg of DOP(This dosage is suitable for the thickness of 0.5~1.2mm, if thickness >1.2mm, add corresponding portion DOP).

③ Stir at high speed to 135°C to discharge.

④ Enter the granulation process, set all 6 sections of 65 granulator temperature control to 170~175 °C (horizontal plate temperature control method), if the electricity current is ok, granulate normally.

⑤ Extrusion molding process, operate the single screw as usual. If there is surface flatness issue, to increase the temperature can get improvement. (e.g. Front sideways 180~190 °C , mould 235°C)