

Vinika® CA 68022-35 Black (High Gloss)
 High Quality Flexible PVC Extrusion
 Automotive Exterior Class A Surface
 Chrysler: MC DC 543 CPN 4577
 GM: GMP PVC .010
 Ford: WSKM4D689A-2



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Flexible PVC extrusion formulation used for Class A surface material on profiles requiring ease of processing, excellent weathering and "Class A" high gloss surface appearance. Gloss: 50- 70 gloss.

Property	Test Method	Value - English		Value - Metric (SI)	
Hardness, Shore A	ASTM D2240 15 sec. Delay	85		85	
Specific Gravity	ASTM D792	1.23		1.23	
Tensile Strength	ASTM D638 20 in/min (500 mm/min), Type IV	2830	psi	19.5	MPa
Elongation	ASTM D638 20 in/min (500 mm/min), Type IV	325	%	325	%
Tear Strength	ASTM D1004 2 in/min (50 mm/min) Die C	375	ppi	65.77	kN/m



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Process Parameters

Barrel Temperatures

Zone - Rear	320 ℉
Zone - Center	320 ℉
Zone - Center	325 ℉
Zone - Front	335 ℉
Adaptor	340 ℉
Dies	345 ℉

Melt Temperature 335 ℉

Screen Pack 20/40/20



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