

Vinika® CA 68012-
High Quality Flexible PVC Extrusion
Automotive Exterior Class A Surface
 Ford: WSK-M4D689A-2



PRODUCT BULLETIN

Vinika® CA 68012-

Flexible PVC extrusion formulation used for Class A surface material on profiles requiring ease of processing, excellent weathering and "Class A" surface appearance. Gloss: 20-30 gloss level.

Property	Test Method	Value - English		Value - Metric (SI)	
Hardness, Shore A	ASTM D2240 15 sec. Delay	83		83	
Specific Gravity	ASTM D792	1.31		1.31	
Tensile Strength	ASTM D638 20 in/min (500 mm/min), Type IV	2800	psi	19.3	MPa
Elongation	ASTM D638 20 in/min (500 mm/min), Type IV	335	%	335	%
100% Modulus	ASTM D638 20 in/min (500 mm/min), Type IV	2000	psi	13.79	MPa
Tear Strength	ASTM D1004 2 in/min (50 mm/min) Die C	380	ppi	66.6	kN/m

Process Parameters



Mitsubishi Chemical Performance Polymers, Inc.



Barrel Temperatures

Zone - Rear	300 ℉
Zone - Center	310 ℉
Zone - Center	315 ℉
Zone - Front	325 ℉
Adaptor	325 ℉
Dies	325 ℉

Melt Temperature 325 ℉

Screen Pack 20/40/20



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