



BEHIND THE SCENES OF YOUR PRODUCTS

Rheological properties
of CERALENE[®] and
VISCOCER[®] waxes
in rigid PVC applications

Get a plus

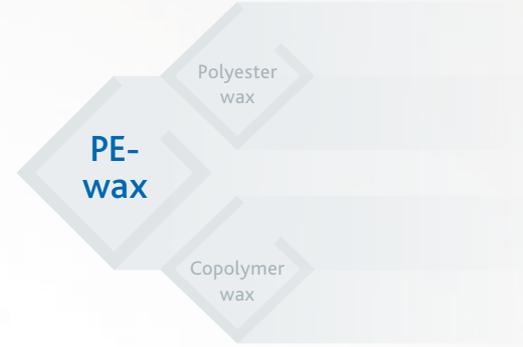
The additive evolution.



CERALENE[®] non-oxidised polyethylene waxes

Function:

- external lubrication
- reduced shear
- gloss improvement

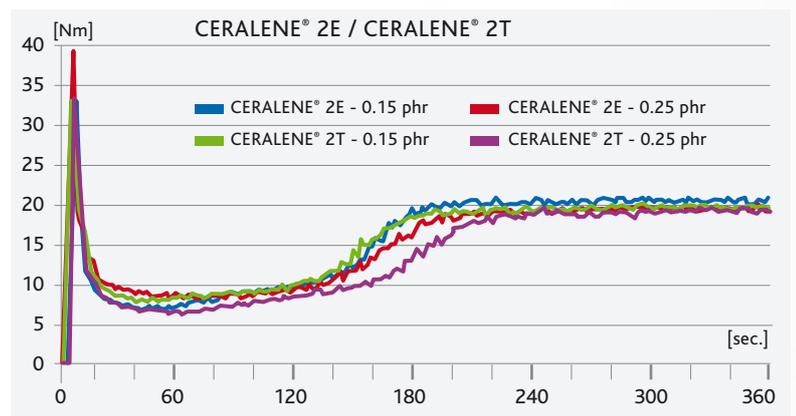


Non polar polyethylene wax

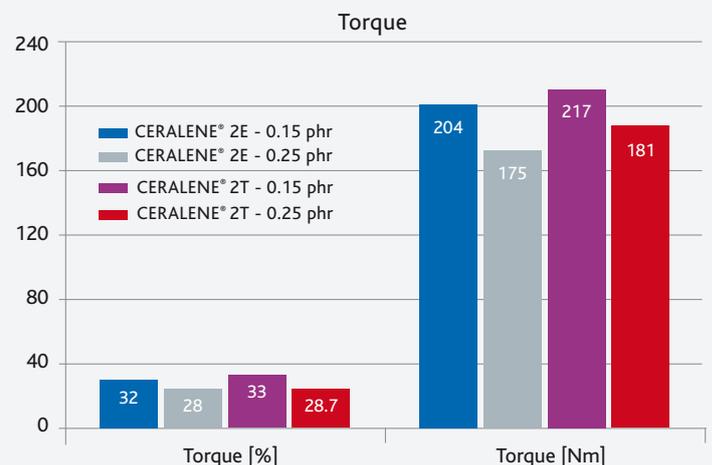
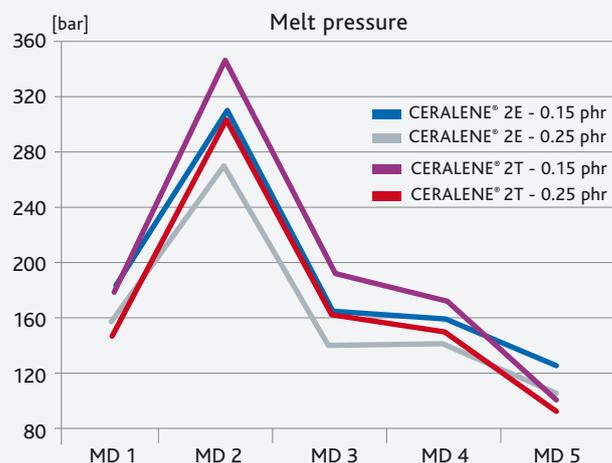
CERALENE [®] grade	chem. description	acid value mg KOH/g	drop point °C	viscosity (120°C) mPa · s	density (at 23°C) g/cm ³	penetration (at 25°C) mm · 10 ⁻¹
CERALENE [®] 2E	LDPE wax	0	106	550	0.92-0.94	3
CERALENE [®] 2T	LDPE wax	0	108	1.100	0.92-0.94	2

CERALENE[®] PE-wax, rigid PVC – window profile-CaZn

formulation	phr			
S-PVC KW 68	100			
Filler	6			
Impact modifier	3			
TiO ₂	10			
Stabilizer	3.20			
CERALENE [®] 2E	0.15	0.25		
CERALENE [®] 2T			0.15	0.25



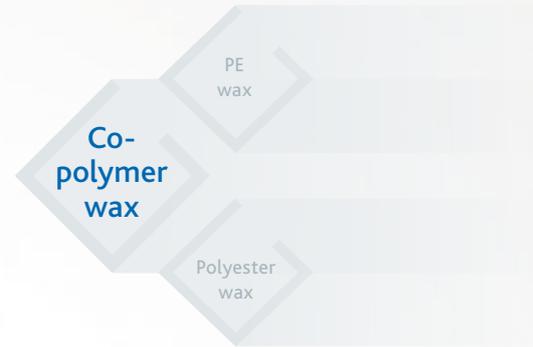
Collin-single screw extruder (30 mm/25d)



CERALENE® polar copolymer-waxes

Function:

- mainly internal
- nearly neutral regarding fusion
- low volatility and plate out
- suitable as carrier for pigments

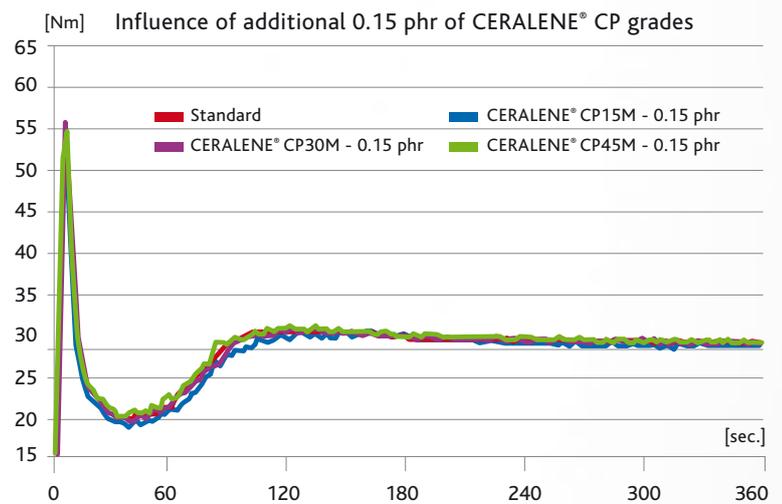


CERALENE® CP15M / CERALENE® CP30M / CERALENE® CP45M

CERALENE® grade	chem. description	acid value mg KOH/g	drop point °C	viscosity (120°C) mPa · s	density (at 23°C) g/cm³	penetration (at 25°C) mm · 10 ⁻¹
CERALENE® CP15M	Copolymer wax	17	103	500	0.93	4
CERALENE® CP30M	Copolymer wax	28	100	600	0.94	5
CERALENE® CP45M	Copolymer wax	38	97	600	0.94	7

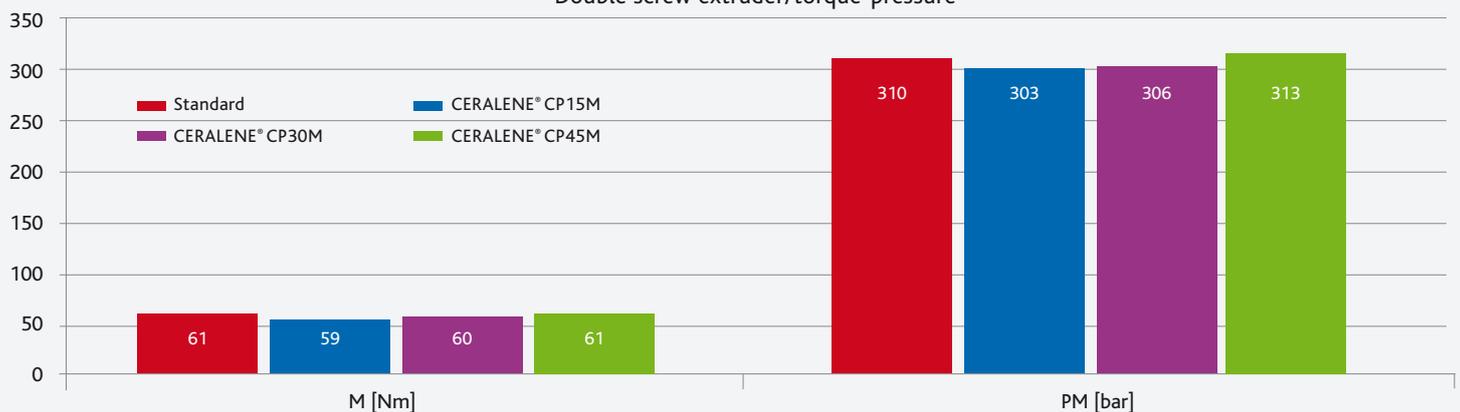
CERALENE® copolymer wax, rigid PVC – window profile-CaZn

TR 203 U--	1	9	10	11
formulation	phr	phr	phr	phr
PVC 67		100		
Impact modifier		6		
TiO ₂		3		
Filler		10		
CaZn stabilizer		3.20		
Lubricant		0.075		
Fatty acid diester		0.30		
CERALENE® CP15M		0.15		
CERALENE® CP30M			0.15	
CERALENE® CP45M				0.15



TR 203 U--	1	9	10	11
tpl [min]	1.60	1.60	1.70	1.50
Mdmax [Nm]	28.9	27.7	29.5	28.3
Mda [Nm]	28.2	28.3	28.1	28.5

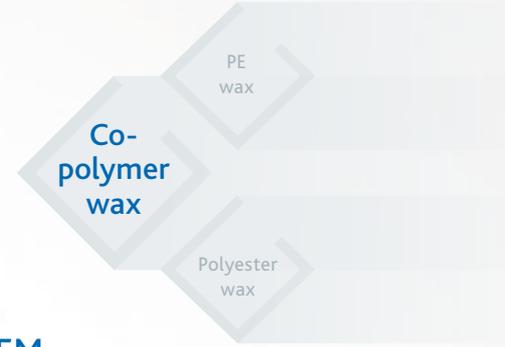
Double screw extruder/torque-pressure



CERALENE® polar copolymer-waxes

Function in PVC injection moulding:

- positive effect on vicat softening point in comparison to standard internal lubricants



CERALENE® CP15M / CERALENE® CP30M / CERALENE® CP45M

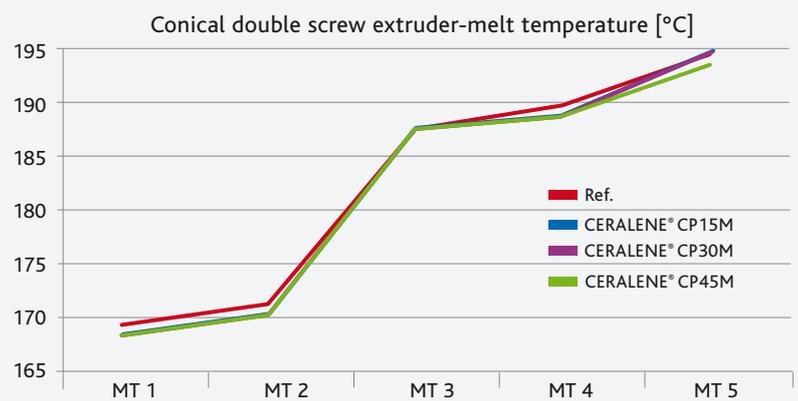
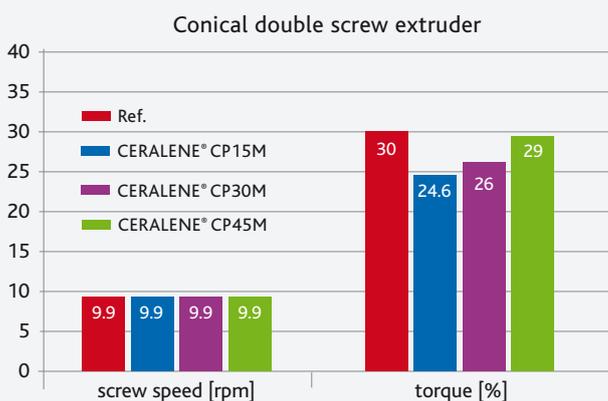
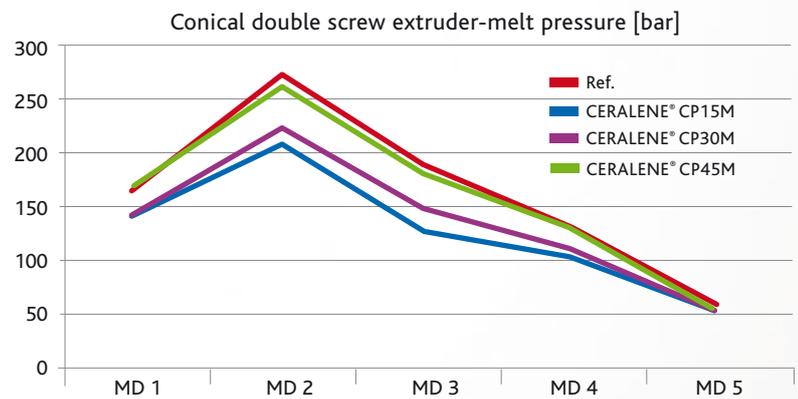
CERALENE® grade	chem. description	acid value mg KOH/g	drop point °C	viscosity (120°C) mPa · s	density (at 23°C) g/cm ³	penetration (at 25°C) mm · 10 ⁻¹
CERALENE® CP15M	Copolymer wax	17	103	500	0.93	4
CERALENE® CP30M	Copolymer wax	28	100	600	0.94	5
CERALENE® CP45M	Copolymer wax	38	97	600	0.94	7

CERALENE® copolymer wax, rigid PVC – injection moulding-CaZn

TR R-05/15	A	B	C	D
formulation	phr	phr	phr	phr
PVC 58		100		
Filler		1		
CaZn stabilizer		4.00		
PE wax		0.10		
Dicarboxylic acid ester	0.25			
CERALENE® CP15M		0.25		
CERALENE® CP30M			0.25	
CERALENE® CP45M				0.25

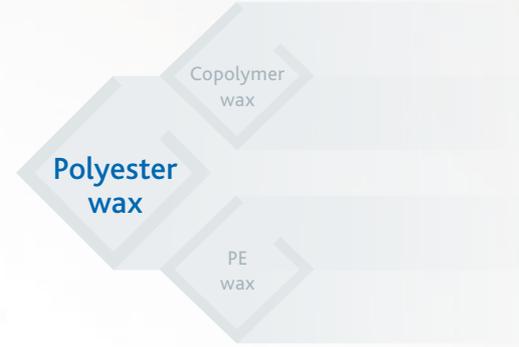
TR. may 2015	A	B	C	D	
Screw speed [rpm]	9.9	9.9	9.9	9.9	
Torque [Nm]	185	140	153	180	
Torque [%]	30	24.6	26	29	
Melt pressure	MD 1 [bar]	170	144	146	172
	MD 2 [bar]	272	209	226	261
	MD 3 [bar]	191	130	149	182
	MD 4 [bar]	134	104	115	132

TR R-05/15	A	B	C	D
Plastification time [min]	7:18	9:14	7:56	6:20
Torque – Max [Nm]	56.8	54.9	55.85	57.4
Torque 15 min after P-time [Nm]	41.3	47.7	46.7	43.0
Melt temperature 15 min after P-time t [°C]	172	169	170	172



Function:

- mainly internal
- nearly neutral regarding fusion
- low volatility and plate out
- similar properties like montan waxes

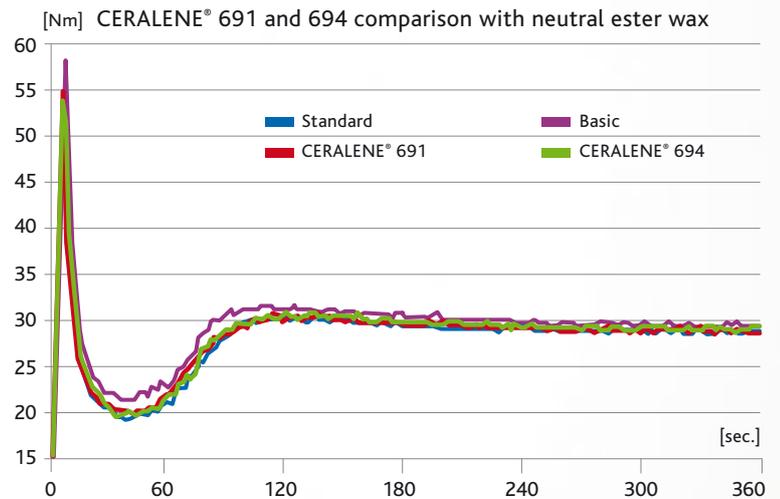


CERALENE[®] 691 / CERALENE[®] 694

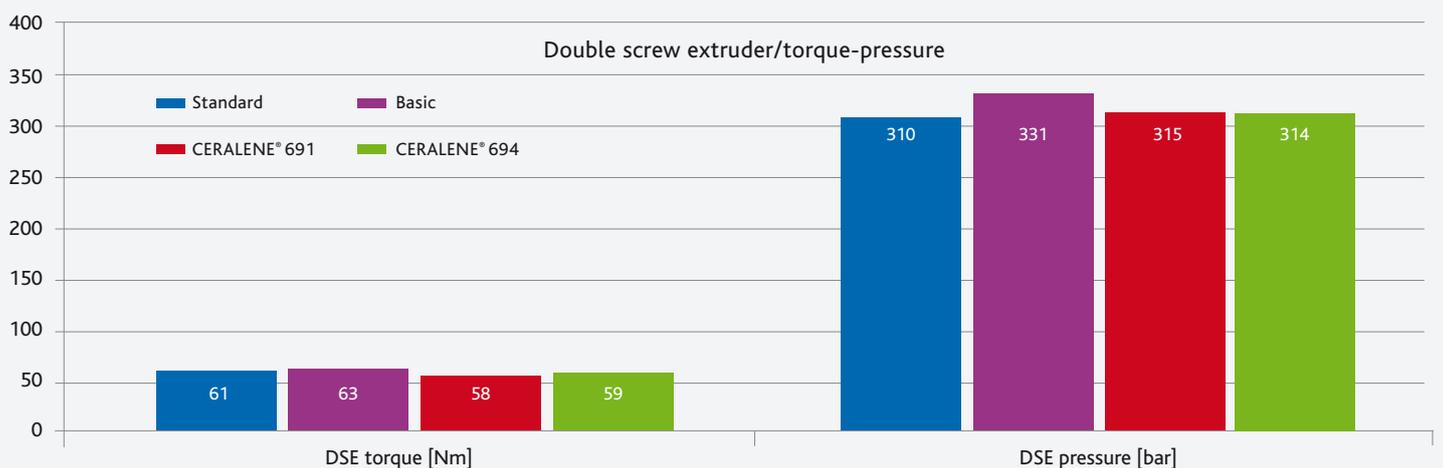
CERALENE [®] grade	chem. description	acid value mg KOH/g	drop point °C	viscosity (at 120°C) mPa · s	density (at 23°C) g/cm ³	penetration (at 25°C) mm · 10 ⁻¹
CERALENE [®] 691	Polyester wax	10	73	130	0.96-0.98	1-2
CERALENE [®] 694	Polyester wax	19	70	170	0.96-0.98	1-2

CERALENE[®] polyester wax, rigid PVC – window profile-CaZn

TR 203 U--	1	5	6	8
formulation	phr	phr	phr	phr
PVC 67		100		
Impact modifier		6		
TiO ₂		3		
Filler		10		
CaZn stabilizer		3.20		
Lubricant		0.075		
Neutral ester wax	0.30			
CERALENE [®] 691			0.15	
CERALENE [®] 694				0.15



■ Standard - 0.30 phr neutral ester wax
 ■ Basic - no neutral ester wax
 ■ CERALENE[®] 691 - 0.15 phr
 ■ CERALENE[®] 694 - 0.15 phr



Comparison of CERALENE[®] polyester wax with a neutral esterwax with only half the dosage (0.30 phr/0.15 phr)

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VISCOCER[®] oxidised LDPE waxes

VISCOCER[®] oxidised HDPE



Function oxidised LDPE waxes:

- acceleration of fusion

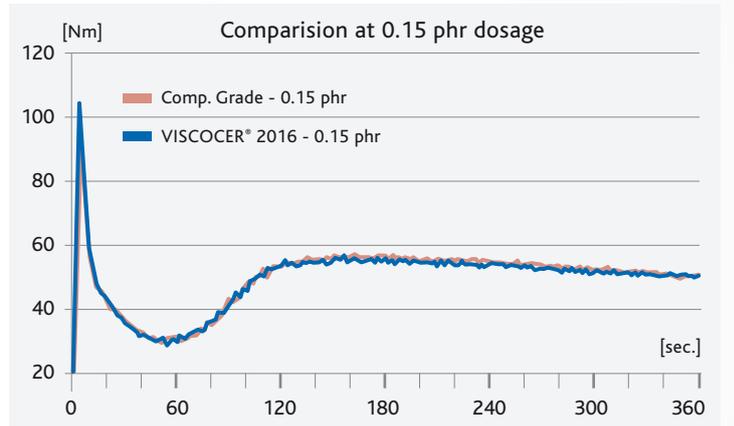
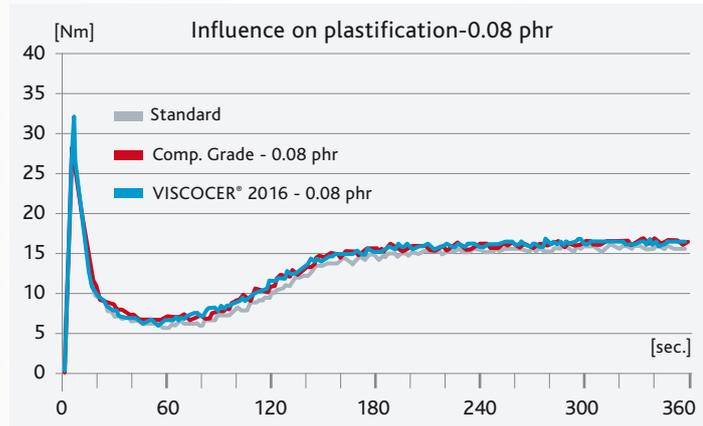
Function oxidised HDPE:

- strong acceleration of fusion
- excellent non sticking behaviour



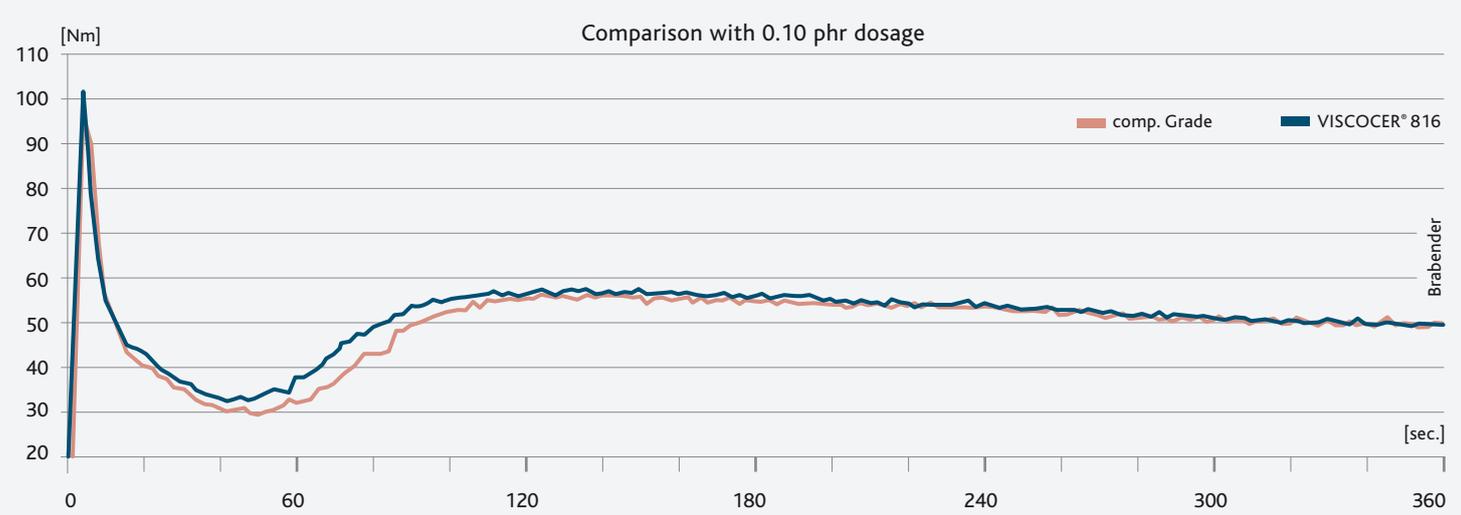
Polar polyolefin wax - oxidised LDPE wax

VISCOCER [®] grade	chem. description/ wax type	acid value mg KOH/g	drop point °C	viscosity (at 140°C) mPa · s	density (at 23 °C) g/cm ³	penetration (at 25°C) mm · 10 ⁻¹
VISCOCER [®] 2016 powder	LDPE	16	103	800	0.94	4
VISCOCER [®] 2016 flakes	LDPE	16	103	800	0.94	4



Polar polyolefins - oxidised HDPE

VISCOCER [®] grade	chem. description/ wax type	acid value mg KOH/g	drop point °C (DSC)	viscosity (160°C) mPa · s	density (at 23 °C) g/cm ³	penetration (at 25°C) mm · 10 ⁻¹
VISCOCER [®] 816 fine powder	HDPE	16	135	8.000	0.98	<1



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