

NORAC[®] **XL-77**

DESCRIPTION

NORAC[®] XL-77 is a paraffin-free ester-based blend designed for rigid PVC foam and profile extrusion.

USAGE LEVEL RECOMMENDATION

0.5 – 1.5 phr

TYPICAL PROPERTIES

Specific gravity	1.17
Softening point	Approximately 55° C
Bulk density	43.7 lb/ft ³

ADVANTAGES

- Superb metal release
- Well-balanced for desired melt flow properties
- Promotes consistent cell structure
- Paraffin-free system for reduced plate out and less down time

STARTING POINT FORMULA

<u>PHR</u>	<u>INGREDIENT</u>
100	PVC K58
3.0 to 8.0	Process aid
0.8 to 2.0	Tin stabilizer
0.5 to 1.5	COAD® 10LD Calcium Stearate
0.5 to 1.5	Norac® XL 77
0.0 to 0.5	Norac® EL-10
0.1 to 0.3	Oxidized polyethylene wax
0.6 to 2.0	Blowing agent depending on process
5.0 to 10.0	CaCO ₃
1.0 to 8.0	TiO ₂

WINDOW STARTING POINT FORMULA

<u>PHR</u>	<u>INGREDIENT</u>
100	PVC K65
1.0 to 2.0	Process aid
3.0 to 5.0	Impact modifier
1.2 to 2.5	Tin stabilizer
0.5 to 1.5	COAD® 10LD Calcium Stearate
0.5 to 1.5	Norac® XL 77
0.0 to 1.0	Norac® EL-10
0.1 to 0.3	Oxidized polyethylene wax
0.0 to 10.0	CaCO ₃
1.0 to 10.0	TiO ₂

ADDITIONAL INFORMATION

- Other – See SDS for NORAC® XL-77 for additional health, safety, and environmental information.
- Packaging – NORAC® EL and XL lubricants are packaged in various sized multiwall bags and supersacks, unitized on non-returnable wooden pallets. Please contact your Norac sales representative to discuss your special packaging requirements.