

Dry Blending of Flexible Formulas with OxyVinyls Resin

For successful High Intensity Mixer dry blending, it is recommended that the porosity of the resin of choice be matched to the formula. Those formulas containing high levels of plasticizer or which use significant quantities of relatively non-solvating plasticizers should be based on high porosity resins. Correspondingly, those with low quantities of plasticizer should be based on resins with lower porosity.

For low intensity mixing, as in a Ribbon Blender, a resin of medium porosity is recommended.

Dry Blend Summary – Flexible Resins

Resin dry blend time should be matched to the mixer and formulation.

Add stabilizer to the resin before heating to protect the resin.

For non-solvating plasticizers:

Preheat the resin as high as 230°F.

Preheat plasticizer before addition.

Add lubricant after plasticizer absorption to prevent interference with absorption.

Cool final blend under 120°F before storage to avoid stability problems and caking.

Dry Blend Cycles

High Intensity Mixing

Add:	Blend To:		
	<40 phr Plasticizer	40 - 75 phr Plasticizer	75 - 90 phr Plasticizer
Resin and Stabilizer	140°F (60°C)	150°F (66°C)	190°F (88°C)
Plasticizer	170°F (77°C)	180°F (82°C)	210°F (99°C)
Filler	180°F (82°C)	190°F (88°C)	215°F (102°C)
Lubricant	190°F (88°C)	200°F (93°C)	225°F (107°C)
Cool Final Blend to <120°F (49°C)			

Low Intensity Mixing

All Plasticizer Levels

Add:	Blend To:
Resin and Stabilizer	150°F (66°C)
Plasticizer	180°F (82°C)
Filler	185°F (85°C)
Lubricant	200°F (93°C)
Cool Final Blend to <120°F (49°C)	

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