

## TUBE GRADE

### SOFT PVC COMPOUND FOR MEDICAL TRANSFUSION APPLICATION

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#### Description

The product tube grade soft PVC compound for transfusion application uses medical-use PVC as main raw material, incorporated with moderate amount of plasticizer, non-toxic stabilizer and other non-toxic additives. The production procedure includes mixing raw materials, plasticizing, extruding, and granulating. The final product is transparent compound with  $\Phi 3\text{mm} \times 4\text{mm}$ .

#### Features

1. Comply with the standard of GB15593—1995 and company technical standard.
2. Suitable for extrusion of transparent tube.
3. Especially for production of medical transfusion applications, such as connection tube, lung tube and etc.

#### Main Physical Properties & Typical Values

Grade	Hardness	Tensile Strength	Elongation Strain	Heat stable time at 180°C
	GB 2411-2008 Standard value $\pm 2$	GB/1040.3-2006 $\geq 13$ MPa	GB/T1040.3-2006 $\geq 250$ %	GB/T2917.1-2002 $\geq 40$ min
5401T-A62/A62B	62(A)	13	420	80
5401T-A67/A67B	67(A)	16	400	90
5401T-A69B	69(A)	17	410	80
5401T-A71/A71B	71(A)	17	390	60
5401T-A74/A74B/A74G	74(A)	18	360	80
5401T-A76W	76(A)	17	380	60
5401T-A78	78(A)	18	390	50
5401T-A83/A83G/A83B	83(A)	20	350	110
5401T-A83B-1	83(A)	20	360	65
5401T-A90/A90B	90(A)	23	310	100

## Main Chemical Properties & Typical Values

Grade	Reducing substance	Acidity/ Alkalinity	Heavy metals	Non-volatile	Ash	Residual VCM
	GB/T14232.1-2004	GB/T14233.1-2008	GB/T14233.1-2008	GB/T14233.1-2008	GB/T9345.1-2008	GB/T4615-2006
	≤ 0.3 ml	≤ 1.0	≤ 0.3μg/ml	≤ 2.0 mg/100ml	≤ 1 mg/g	≤ 1 μg/ml
5401T-A62/ A62B	0.1	< 1	0.3	0.7	0.1	0.4
5401T-A67/ A67B	0.1	< 1	0.3	0.6	0.1	0.4
5401T-A69B	0.1	< 1	0.3	0.69	0.1	0.4
5401T-A71/ A71B	0.1	< 1	0.3	0.6	0.1	0.4
5401T-A74/ A74B/A74G	0.1	< 1	0.3	0.7	0.1	0.4
5401T-A76W	0.1	< 1	0.3	0.7	0.1	0.4
5401T-A78	0.1	< 1	0.3	0.7	0.1	0.4
5401T-A83/ A83G/A83B	0.1	< 1	0.3	0.9	0.1	0.4
5401T-A83B-1	0.1	< 1	0.3	0.7	0.1	0.4
5401T-A90/ A90B	0.1	< 1	0.3	0.9	0.1	0.4

## Recommended Processing Technique

### Equipment:

Ratio of length and diameter: 24 : 1

Screw compression ratio: 2.5:1 ~3.5:1; Generally cooling system is not necessary

Extrusion die head: To avoid scorch problem please use smooth pipeline and well-controlled

die head temperature

### Temperature control:

Hardness (Shore A)	Extruder Zone Temp. (°C)	Melting Temp. (°C)
50~60	140~165	155-160
60~70	145~170	160-165

70~80

150~175

165-175

80~90

155~180

170-180

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***Please contact our customer service for more technical service.***