

TECHNICAL DATA SHEET

uPVC Expansion Joint 5EJ

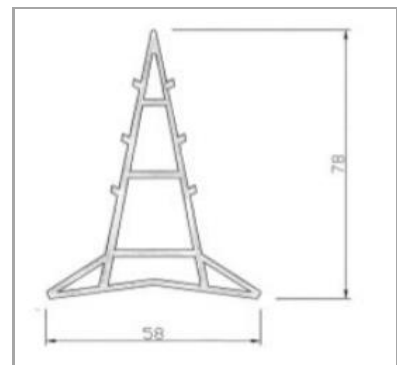
MATERIAL	
Description	Calcium / Zinc Stabilised Rigid PVC Extrusion Compound Regrind Window Grade
Colour	Grey - Concrete Grey
Application	High impact profiles suitable for outdoor use Characteristics
Form	Granules

PROPERTIES (These values do not form part of a specification)	UNITS	TYPICAL TEST
Thermal Stability (@ 180°C) (BS EN ISO 182-1 : 1990)	mins	120
Vicat Softening Point	°C	79
Tensile Impact Strength (@ 23°C) (EN ISO 8256)	kJ/m ²	705
Flexural Modulus (@23°C) (EN ISO 178)	MPa	2440
Charpy Impact Strength (@ 23°C) (EN ISO 179-2)	kJ/m ²	>20
Impact Strength After Aging	%	>40
Relative Density (BS EN ISO 1183-1 : 2004)	kg/m ³	1490
Water Absorption (BS EN ISO 62 : 1999)	%	<1.0
Apparent Bulk Density (BS EN ISO 60 : 2000)	g/ml	0.682

Issue Date: 24th June 2012

PROCESSING CONDITIONS	
haul-off pressure	1.3bar-1.5bar
CMT 58 Extruder	Greiner Downstream
Calibrator Vacuum	-0.7
Material	HO 1.49
EXT RPM	15
FEED RPM	10.75
MELT BAR	200
TORQUE	33
HEAT ZONES	DEG CELCIUS
E1	200
E2	195
E3	185
E4	175
S2	140
A	180
DZ1	195

Profile Height	78 mm
Profile Width	58 mm
Wall Thickness	1.6/2.0 mm



INSTALLATION

- Tools required: Measuring tape, marker, Saw, Concrete, Float
- Step 1: Measure and Cut the profile to length of the location of installation
 - Step 2: Every meter, clean the area and place concrete to receive the profile
 - Step 3: Plumb the profile in concrete and leave to set overnight or until fully set
 - Step 4: Check your sightlines to ensure the correct levels have been achieved
 - Step 5: Fill in between the profiles with suitable concrete for the project
 - Step 6: Float the concrete level with the tip of the profile with a straight edge

Installation Conditions

Customers are recommended to determine optimum conditions for themselves, As these will vary with each particular project.