



# Struktol Company of America

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# TECHNICAL DATA

## STRUKTOL® VLB-618

### PROCESSING ADDITIVE

#### COMPOSITION

Blend of fatty acid esters. STRUKTOL® VLB-618 is manufactured from high quality vegetable fatty acids.

#### TYPICAL PROPERTIES

Appearance	Off white to tan pastille or powder
Dropping Point (°C)	79 - 88
Specific Gravity	1.025
Physiological Behavior	Refer to safety data sheet
Storage Stability	At least 2 years under normal storage conditions
Packaging	55 lb. bag or 2000 lb. supersack

#### RECOMMENDATIONS FOR APPLICATION

**Typical Applications:** STRUKTOL® VLB-618 is the vegetable version of VLB-602 and is a very compatible complex ester lubricant. It has noted performance in clear calendered PVC sheet. It also has application in clear extrusion, blow molding and injection molding formulations. It is especially useful in products that require printing, laminating, or bonding.

**Features:** STRUKTOL® VLB-618 is very effective mostly as an external lubricant, with some internal properties, which have no negative impact on clarity in extrusion, calendering, or injection molding. STRUKTOL® VLB-618 is noted to have ideal characteristics for calendered sheet where clarity and low water blush is critical and where lower cost in performance is needed to replace montanic esters.

#### DOSAGE

<b>Injection Molding</b> (Opaque)	V-HRW	0.7 – 1.5 phr	<b>Extrusion</b> (Opaque)	V-SSE	0.7 – 1.0 phr
	VLB-618 or V-PEAS	0.3 – 0.75 phr		VLB-618	0.4 – 0.8 phr
	Oxidized HDPE	0.07 – 0.15 phr		Calcium Stearate	0.7 – 1.0 phr
	Calcium Stearate*	0.3 – 1.0 phr			
*Note: Reduce Calcium Stearate as much as possible for improved flow.					
<b>Injection Molding</b> (Clear)	V-HRW	0.7 – 1.0 phr	<b>Extrusion</b> (Clear)	V-DSP	0.7 – 1.0 phr
	VLB-618 or V-PEAS	0.3 – 0.6 phr		VLB-618	0.3 – 0.6 phr
				Oxidized HDPE	0.1 – 0.3 phr
<b>Calendering</b> (Opaque)	V-HRW	0.7 – 1.5 phr	<b>Wire and Cable</b> (High Speed)	V-PEAS	1.0 – 1.5 phr
	VLB-618	0.5 – 0.75 phr		VLB-618	0.5 – 0.7 phr
	Calcium Stearate	0.3 – 0.75 phr			
	Oxidized HDPE	0.07 – 0.15 phr			

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