

Honeywell RL 410

Lubricant Blend

RL 410 acts as an external lubricant in rigid PVC compounds. It is a blend of paraffinic hydrocarbon and oxidized polyethylene waxes. The product should provide good metal release and gloss levels for the extruded part. Typical use applications include the extrusion of rigid PVC profile, fence, sheet, and siding. Typical usage levels for this lubricant are 1.0 – 1.7 PHR.

Typical Properties:

Property	Test Method	Value
Congealing Point	ASTM D938	73.6 °C (164.5 °F)
Viscosity @ 210 °F (98.9 °C)	ASTM D445	12.3 cSt
Acid Number	ASTM D1386	1.5 mg KOH/g

Product Form:

Product State:	Wax like solid
Product Form:	Free flowing prill

Recommendations to avoid compaction and handling issues:

- Avoid double stacking skids of product.
- Store in cool area, preferably < 90 °F (32.2 °C).
- Rotate stock using FIFO inventory control.
 - Preferably using it within 30 days or less from the delivery date.
- Do not place material near a source of heat or in direct sunlight.
- Compaction does not affect the quality of the material, and the material will continue to meet all physical specification even when compacted.
- If compaction occurs the customer should manually or mechanically break up compacted product before use.
- Contact Honeywell for handling and usage guidance as needed.

Safety Precautions

Consult our Material Safety Data Sheet for specific recommendations on safe handling.

For additional information or to contact us, please visit: www.honeywell-additives.com

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