

Palamoll® 638

Edition dated July 2019

Valid for product produced in Ludwigshafen only

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® = Registered trademark of BASF SE

High viscosity polymeric plasticizer for PVC. Good resistance to oils and fats. Palamoll® 638 is approved for use in plasticized PVC articles for food contact applications.

Chemical nature

Polymeric plasticizer derived from adipic acid, 1,2 Propanediol and 1-Octanol

CAS number 82904-80-1

EINECS compliant (raw materials listed in EINECS)

Delivery specification

Property	Value	Unit	Test method DIN/ASTM
Dynamic viscosity at 20 °C	7000 – 9500	mPa · s	DIN 53019/ ASTM D 7042
Density at 20 °C	1.110 – 1.130	g/cm ³	DIN 51757/ ASTM D 4052
Platinum-cobalt color	150 max.		DIN EN ISO 6271/ ASTM D 1209
Refractive index n_D^{20}	1.466 – 1.468		DIN 51423-2/ ASTM D 1045
Acid value	2 max.	mg KOH/g	DIN EN ISO 2114/ ASTM D 1045
Water content	0.05 max.	% by weight	DIN 51777, Part 1/ ASTM E 203

Properties

Palamoll® 638 is a slightly yellowish, practically anhydrous liquid and has a mild ester odor. It is soluble in the usual organic esters, ketones, ethers, aromatic and chlorinated hydrocarbons. The product is practically insoluble in water, aliphatic hydrocarbons, vegetable and animal oils.

Palamoll® 638 is listed for use in food-contact applications. Information on its regulatory status according to food-contact legislation is available in a separate document that we would be pleased to send to you upon request.

Physical data

The following physical data were measured in the BASF SE laboratories. They do not represent any legally-binding guarantee of properties for our sales product.

Pour point (DIN ISO 3016)	-9 °C
Solution temperature at the clear point (5 % S-PVC, K-value 71; BASF-method DIN 53408)	164 °C
Surface tension 50 °C (Drop volume method BASF)	37.5 mN/m

Density and viscosity dependent on temperature

Temperature [°C]	Density* ρ [g/cm ³]	Dyn. Viscosity η [mPa · s]
10	1.1300	23500
20	1.1220	8600
30	1.1139	3700
40	1.1059	1800
50	1.0978	1000

*Calculated using the following equation: $\rho = (-0.00081 \cdot t + 1.1381)$ from data measured by BASF SE. (ρ = Density in g/cm³, t = Temperature in °C)

Specific heat C_P (DSC) according to DIN 51007

Temperature [°C]	Specific heat C_p [J/(g · K)]
30	1.90
50	2.00
100	2.29

Storage & Handling

Palamoll® 638 can be stored in tanks and drums constructed from normal carbon steel, e. g. A 283 grade. If severe demands are imposed on the product quality, we recommend to store it in tanks constructed from stainless steel, e. g. AISI TP 316 Ti (German steel No. 1.4541) or aluminum (AlMg3).

It is recommended to take steps to ensure the exclusion of atmospheric moisture, e. g. by storing under a blanket of dry nitrogen, as otherwise the product quality may deteriorate, e. g. the water fraction may rise, or the Palamoll® 638 may be discolored by rust in normal steel tanks.

Drums containing the product should be kept tightly closed in a well-ventilated place.

Palamoll® 638 can be stored for one year at temperatures below 40 °C, if moisture is excluded. Exceeding the recommended storage temperature can cause degradation of the product with negative impact on the quality. Only dedicated equipment should be used to discharge this product.

Pumps:

Cast-steel centrifugal pumps with a simple slip-ring seal are suitable.

Flange seals:

An example of a suitable material for seals is chemical-resistant Polytetrafluoroethylene (PTFE). Other plastics should be checked for suitability before they are taken into use.

Safety

When using this product, the information and advice given in our **Safety Data Sheet** should be observed. Due attention should also be given to the **precautions** necessary for handling chemicals.

Note

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein may change without prior information and do not constitute the agreed contractual quality of the product. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

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