

Technical Data Sheet

Polyvin PVC 7974GLN-01 NATURAL



Polyvinyl Chloride, Unspecified

Product Description

Flexible PVC formulation for general purpose injection molding applications requiring good flow for multiple cavity tools

Processing Method Injection Molding

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density - Specific Gravity	1.34	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield, (510 mm/min, Type IV)	11.4	MPa	ASTM D638
Tensile Elongation at Break, (510 mm/min, Type IV)	200	%	ASTM D638
Tear Strength, (Die C, 51 mm/min)	17.5	kN/m	ASTM D624
Hardness			
Durometer Hardness, (Shore A, 15 sec)	76		ASTM D2240

Injection Parameters	Nominal Value	Units
Nozzle Temperature	177	°C
Screw Speed	40 to 70	rpm
Processing (Melt) Temp	177	°C
Front Temperature	179	°C
Holding Pressure	1.38 to 1.72	MPa
Middle Temperature	174	°C
Rear Temperature	168	°C
Back Pressure	0.172 to 0.345	MPa
Mold Temperature	21 to 43	°C
Injection Pressure	4.48 to 5.52	MPa