Dynalloy™ 8900-80

Thermoplastic Elastomer

PolyOne Corporation

Message:

Dynalloy™8900 series is an innovative thermoplastic elastomer, which enables the injection model forming machine to bond low density polyethylene (LDPE) and polypropylene (PP) materials by overlapping molding in an efficient cycle.
Bonable low density polyethylene and polypropylene
flexible
Colourable

General Information			
Features	Workability, good Good processing stability Good coloring High liquidity		
Uses	overmolding Thin wall parts Non-specific food applications Household goods Soft handle Sporting goods General Consumer goods application field		
Agency Ratings	BfR XXI, section 2.1.3.1.1 2 FDA 21 CFR 177.1210 2		
RoHS Compliance	RoHS compliance		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	0.878	g/cm³	ASTM D792
Molding Shrinkage - Flow	0.70 - 1.2	%	ASTM D955
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	80		ASTM D2240
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [1]			ASTM D412
100% strain, 23°C [2]	4.34	MPa	ASTM D412
300% strain, 23°C [3]	5.00	MPa	ASTM D412

Tensile Strength (Break, 23°C)	5.52	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	550	%	ASTM D412
Tear Strength	46.4	kN/m	ASTM D624
Compression Set [4]			ASTM D395B
23°C, 22 hr	22	%	ASTM D395B
70°C, 22 hr	37	%	ASTM D395B

Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity			ASTM D3835
200°C, 1340 sec^-1	40.0	Pa·s	ASTM D3835
200°C, 11200 sec^-1	10.3	Pa·s	ASTM D3835

Injection	Nominal Value	Unit
Rear Temperature	160 - 182	°C
Middle Temperature	171 - 193	°C
Front Temperature	182 - 204	°C
Nozzle Temperature	182 - 204	°C
Mold Temperature	15.6 - 26.7	°C
Back Pressure	0.00 - 0.689	MPa
Screw Speed	25 - 100	rpm

Injection instructions

以聚丙烯 (PP),乙烯醋酸乙烯共聚物 (EVA) 或低密度聚乙烯 (PE) 为基础的色母料最适合 Dynalloy™ 8900 系列着色.使用熔体流动速率较高(范围为 25 - 40 克/10 分钟)的色母料,则能达到较好的颜色分散效果.典型的色母料用量为 1% 至 5%(重量).不应采用以 PVC 为基础的色母料.色母料是否适用,应由用户通过试验来最终确定.在使用此产品之前或之后,均须用熔体流动速率较低 (0.5 - 2.5 MFR) 的聚乙烯 (PE) 或聚丙烯 (PP) 彻底进行置换.Dynalloy™ 8900 系列具有极好的熔体稳定性.最长停留时间可能会根据机筒尺寸有所变化.通常,如果机器闲置 8 - 10 分钟或以上,则应将机筒排空.不需要干燥注射速度:1 - 3 英寸/秒第一阶段 - 提升压力:175 - 800 psi第二阶段 - 保持压力:30% 的升压保持时间(厚部件):3 - 10 秒保持时间(薄部件):1 - 3 秒

NOTE	
1.	2 hours
2.	Mouth die c
3.	C mould
4.	25% deflection

Recommended distributors for this material

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