

Dynalloy™ OBC 8100-N75

Thermoplastic Elastomer

PolyOne Corporation

Message:

DYNALLOY™OBC8100-N75 is a kind of using Dow INFUSE™TPE material with unique characteristics of olefin block polymer. 8100 series of materials are specially developed for TPE applications that require direct contact with food.

New Products. Commercial norms have not yet been established.

can be bonded to polypropylene

direct contact with food

strong liquidity

Excellent coloring

General Information			
Features	Good liquidity		
	Good coloring		
	Compliance of Food Exposure		
Uses	overmolding		
	Kitchen utensils		
	Non-specific food applications		
	Household goods		
	Soft touch application		
Agency Ratings	BfR food contact, not rated 2		
	FDA 21 CFR 177.2600 3		
	European 2002/72/EC 4		
RoHS Compliance	RoHS compliance		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.02	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow	0.60 - 1.3	%	ASTM D955
Transverse flow	0.60 - 1.3	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	71		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
100% strain, 23°C ²	3.56	MPa	ASTM D412
300% strain, 23°C ³	4.27	MPa	ASTM D412

Tensile Strength (Break, 23°C)	5.63	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	690	%	ASTM D412
Tear Strength	36.4	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	30	%	ASTM D395B
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity			ASTM D3835
200°C, 1340 sec ⁻¹	120	Pa·s	ASTM D3835
200°C, 11200 sec ⁻¹	28.1	Pa·s	ASTM D3835
Injection	Nominal Value	Unit	
Rear Temperature	160 - 188	°C	
Middle Temperature	177 - 193	°C	
Front Temperature	182 - 210	°C	
Nozzle Temperature	193 - 216	°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™ OBC 8100-N75 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. 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

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