

Technical Data Sheet

**Polyvin PVC 7974GLN**

Polyvinyl Chloride
LyondellBasell Industries
Engineering Plastics

Product Description

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

General

Material Status	• Commercial: Active
Availability	• North America
Processing Method	• Injection Molding

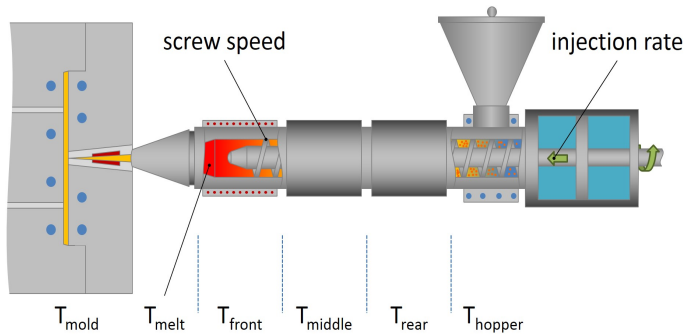
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.34	1.34 g/cm ³	ASTM D792
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength ¹ (Yield)	1650 psi	11.4 MPa	ASTM D638
Tensile Elongation ¹ (Break)	200 %	200 %	ASTM D638
Elastomers	Nominal Value (English)	Nominal Value (SI)	Test Method
Tear Strength ²	99.9 lbf/in	17.5 kN/m	ASTM D624
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Durometer Hardness (Shore A, 15 sec)	76	76	ASTM D2240

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Injection	Nominal Value (English)	Nominal Value (SI)
Rear Temperature	335 °F	168 °C
Middle Temperature	345 °F	174 °C
Front Temperature	355 °F	179 °C
Nozzle Temperature	350 °F	177 °C
Processing (Melt) Temp	350 °F	177 °C
Mold Temperature	70 to 110 °F	21 to 43 °C
Injection Pressure	650 to 800 psi	4.48 to 5.52 MPa
Holding Pressure	200 to 250 psi	1.38 to 1.72 MPa
Back Pressure	25.0 to 50.0 psi	0.172 to 0.345 MPa
Screw Speed	40 to 70 rpm	40 to 70 rpm

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Notes

¹ Type IV, 20 in/min (510 mm/min)

² Die C, 2.0 in/min (51 mm/min)

Notes

These are typical property values not to be construed as specification limits.

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Product Storage and Handling

- Product should be stored in dry conditions at temperatures below 50°C and protected from UV-light
- Improper storage may bring damage to the packaging and can negatively affects on the quality of this product
- Keep material completely dry for good processing

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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