

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

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

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.