

Dynalloy™ OBC8000-T05

Thermoplastic Elastomer

PolyOne Corporation

Message:

DYNALLOY™OBC8000-T05 is a kind of using Dows INFUSE™Ultra-soft TPE with unique characteristics of olefin block polymers. This material is designed for injection molding applications that require extremely high softness and adhesion of polypropylene by overlap molding.

New Products. Commercial norms have not yet been established.

can be bonded to polypropylene

strong liquidity

Excellent coloring

good touch

super soft

General Information			
Features	Good processing stability		
	Good liquidity		
	Good coloring		
	Soft		
	Hardness, low		
Uses	overmolding		
	Personal care		
	Seals		
	Soft handle		
	Transparent or Translucent Accessories		
	Consumer goods application field		
Agency Ratings	FDA 21 CFR 177.1210 2		
RoHS Compliance	RoHS compliance		
Appearance	Translucent		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.868	g/cm ³	ASTM D792
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shaw OO, 10 seconds)	57		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
100% strain, 23°C ²	0.103	MPa	ASTM D412
300% strain, 23°C ³	0.207	MPa	ASTM D412
Tensile Strength (Break, 23°C)	1.25	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	1400	%	ASTM D412

Compression Set			ASTM D395B
23°C, 22 hr	10	%	ASTM D395B
40°C, 22 hr	19	%	ASTM D395B
70°C, 22 hr	35	%	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	7.60	Pa·s	ASTM D3835
Injection	Nominal Value	Unit	
Suggested Max Regrind	20	%	
Rear Temperature	149 - 171	°C	
Middle Temperature	166 - 188	°C	
Front Temperature	177 - 199	°C	
Nozzle Temperature	182 - 216	°C	
Processing (Melt) Temp	182 - 216	°C	
Mold Temperature	15.6 - 32.2	°C	
Back Pressure	0.00 - 0.552	MPa	
Screw Speed	80 - 120	rpm	
Injection instructions			

此产品应使用以 DYNALLOY™ OBC8000-T05 为色载体的色母料着色.若欲采用以 OBC8000-T05 为色载体的色母料,很重要的一点是所选择的着色工厂具有水下造粒的能力.典型的色母料用量为 1% 至 5%(重量).可以使用液体颜料(颜料,而非染料);推荐采用白油载体.若使用 GLS 可供的预着色复合材料,则可达到较好的配色一致性.不应采用以聚丙烯 (PP) 为基础的色母料,因为它们将导致较差的分散性,并能显著地改变材料的硬度.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) 的聚苯乙烯 (PS) 或聚丙烯 (PP) 彻底进行置换.DYNALLOY™ OBC8000-T05 可利用高达 20% 的回收料同时其性能所受影响却极小,但该回收料必须是未受到污染的.为了最大限度地减小模塑期间其性能所受的影响,熔体温度应维持得尽可能低.回收料的有效性应由用户最终确定.DYNALLOY™ OBC8000-T05 具有良好的熔体稳定性.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:0.5 - 3 英寸/秒第一阶段 - 提升压力:200 - 700 psi第二阶段 - 保持压力:20% 的升压保持时间(厚部件):1 - 5 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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