Dynalloy™ OBC 8100-N65

Thermoplastic Elastomer

PolyOne Corporation

Message:

DYNALLOY™OBC8100-N65 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 Food service sector		
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	1.06	g/cm³	ASTM D792
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	63		ASTM D2240
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [1]			ASTM D412
100% strain, 23°C [2]	3.00	MPa	ASTM D412
300% strain, 23°C [3]	3.65	MPa	ASTM D412
Tensile Strength (Break, 23°C)	4.27	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	570	%	ASTM D412

Tear Strength	23.6	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	21	%	ASTM D395B
Fill Analysis	**Nominal Value**	**Unit**	**Test Method**
Apparent Viscosity			ASTM D3835
200°C, 1340 sec^-1	117	Pa·s	ASTM D3835
200°C, 11200 sec^-1	27.0	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-N65 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

Recommended distributors for this material

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