**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/cm³ | 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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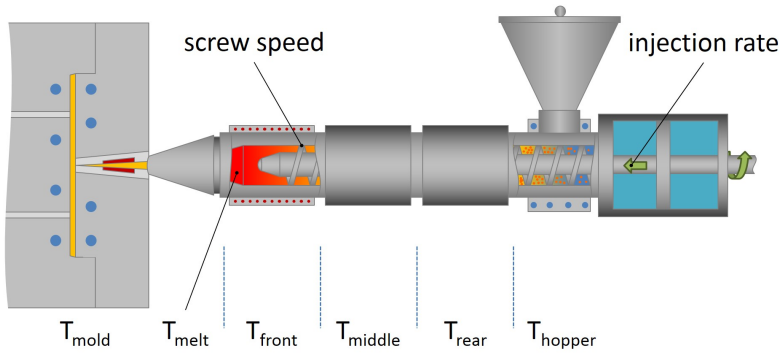


| Injection | Nominal Value (English) | Nominal Value (SI) |
|---|---|---|
| Rear Temperature | 335 °F | 168 °C |
| Middle Temperature | 345 °F | 174 °C |
| Front Temperature | 355 °F | 179 °C |
| Nozzle Temperature | 350 °F | 177 °C |
| Processing (Melt) Temp | 350 °F | 177 °C |
| Mold Temperature | 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.