Dynalloy™ DT 7910 White

Thermoplastic Elastomer

Key Characteristics

Product Description		
Dynalloy™ DT 7910 W is an easy processing, general purpose material designed for a wide variety of applications		
General		
Material Status	• Commercial: Active	
Regional Availability	• Latin America	• North America
Agency Ratings	• FDA 21 CFR 177.2600 [1]	
RoHS Compliance	• RoHS Compliant	
Appearance	• White	
Forms	• Pellets	
Processing Method	• Extrusion	• Injection Molding

Technical Properties [2]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.930	0.930	ASTM D792
Molding Shrinkage			ISO 294-4
Across Flow	2.1 to 2.5 %	2.1 to 2.5 %	
Flow	2.2 to 2.8 %	2.2 to 2.8 %	
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tear Strength	130 lbf/in	22.8 kN/m	ASTM D624
Compression Set			ASTM D395
73°F (23°C), 22 hr	15 %	15 %	
158°F (70°C), 22 hr	90 %	90 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness [3]			ASTM D2240
Shore A, 10 sec, 73°F (23°C)	45	45	
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	21.5 Pa·s	21.5 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Rear Temperature	310 to 380 °F	154 to 193 °C
Middle Temperature	320 to 390 °F	160 to 199 °C
Front Temperature	330 to 390 °F	166 to 199 °C
Nozzle Temperature	330 to 390 °F	166 to 199 °C
Mold Temperature	70 to 100 °F	21 to 38 °C
Injection Pressure	500 to 700 psi	3.45 to 4.83 MPa
Injection Rate	Moderate-Fast	Moderate-Fast
Back Pressure	50.0 to 150 psi	0.345 to 1.03 MPa
Screw Speed	25 to 75 rpm	25 to 75 rpm

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Injection Notes

Purge thoroughly before and after use of this product with a low flow (0.5 - 2.5 MFR) polyethylene (PE) or polypropylene (PP).

Dynalloy™ DT 7910 W has excellent melt stability. Maximum residence times may vary, depending on the size of the barrel. Generally, the barrel should be emptied if it is idle for periods of 8 - 10 minutes or longer. It's recommended not to exceed a maximum melt temperature of 420F.

Drying is not Required

Extrusion	Typical Value (English)	Typical Value (SI)
Cylinder Zone 1 Temp.	280 to 360 °F	138 to 182 °C
Cylinder Zone 2 Temp.	340 to 380 °F	171 to 193 °C
Cylinder Zone 3 Temp.	360 to 400 °F	182 to 204 °C
Melt Temperature	360 to 410 °F	182 to 210 °C
Die Temperature	360 to 400 °F	182 to 204 °C
Screw L/D Ratio	24.0:1.0 to 30.0:1.0	24.0:1.0 to 30.0:1.0

Notes

[1] Please contact Avient Corporation for a copy of the FDA compliance letter

[2] Typical values are not to be construed as specifications.

[3] 2 hr

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