

Dynaflex™ D3204-1000-03

Thermoplastic Elastomer

PolyOne Corporation

Message:

Dynaflex™D3204-1000-03 is an easy-to-process TPE designed for general-purpose applications. It is suitable for injection molding, extrusion molding, blow molding and thermoforming processes.

Dry texture

easy to process

High melt strength

Soft to the touch

General Information	
Features	Workability, good
	Good melt strength
Uses	General
	Toys
	Consumer goods application field
Agency Ratings	FDA not rated
RoHS Compliance	RoHS compliance
Appearance	Natural color
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.01	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	6.0	g/10 min	ASTM D1238
200°C/5.0 kg	23	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.10 - 0.40	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	78		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain, 23°C)	6.83	MPa	ASTM D412
Tensile Strength (Break, 23°C)	7.60	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	420	%	ASTM D412
Tear Strength	45.5	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	22	%	ASTM D395B
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 11200 sec ⁻¹)	23.5	Pa · s	ASTM D3835

Injection	Nominal Value	Unit
Rear Temperature	116 - 160	°C
Middle Temperature	166 - 188	°C
Front Temperature	182 - 204	°C
Nozzle Temperature	182 - 204	°C
Mold Temperature	21.1 - 32.2	°C
Back Pressure	0.00 - 1.03	MPa
Screw Speed	40 - 100	rpm
Injection instructions		

以乙烯醋酸乙烯共聚物 (EVA) 为基础的色母料最适合 Dynaflex™ D3204-1000-03 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(一致性).典型的色母料用量为 1% 至 5%(重量).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 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.Dynaflex™ D3204-1000-03 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 5 - 8 分钟或以上,则应将机筒排空.不需要干燥注射速度:1 - 5 英寸/秒第一阶段 - 提升压力:300 - 700 psi第二阶段 - 保持压力:70% 的升压保持时间(厚部件):4 - 10 秒保持时间(薄部件):1 - 3 秒

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