Dynaflex™ G7680-9 (Black)

Thermoplastic Elastomer

PolyOne Corporation

Message:

Dynaflex™ G7680-9 (Black) is an easy processing, general purpose TPE designed for a wide variety of applications, including those where FDA compliance is required.
Overmold Adhesion to Polypropylene
Rubbery Feel
Soft Touch

General Information	
Features	Workability, good
	Good processing stability
	Good liquidity
	General
Uses	overmolding
	Washer
	Seals
	Soft touch application
	Soft handle
	Sporting goods
	General
	Consumer goods application field
Agency Ratings	FDA 21 CFR 177.1210 2
RoHS Compliance	RoHS compliance
Appearance	Black
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	33	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.60 - 1.4	%	ASTM D955
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	81		ASTM D2240
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [1]			ASTM D412
100% strain, 23°C [2]	3.90	MPa	ASTM D412

300% strain, 23°C [3]	4.55	MPa	ASTM D412
Tensile Strength (Yield, 23°C)	7.93	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	660	%	ASTM D412
Tear Strength	34.1	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	23	%	ASTM D395B

Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity			ASTM D3835
200°C, 1340 sec^-1	47.3	Pa·s	ASTM D3835
200°C, 11200 sec^-1	10.9	Pa·s	ASTM D3835

Injection	Nominal Value	Unit
Suggested Max Regrind	20	%
Rear Temperature	149 - 188	°C
Middle Temperature	177 - 188	°C
Front Temperature	188 - 216	°C
Nozzle Temperature	188 - 227	°C
Mold Temperature	15.6 - 37.8	°C
Back Pressure	0.00 - 0.827	MPa
Screw Speed	40 - 100	rpm

Injection instructions

Purge thoroughly before and after use of this product with a low flow (0.5 - 2.5 MFR) polyethylene (PE) or polypropylene (PP).Regrind levels up to 20% can be used with Dynaflex™ G7680-9 (Black) with minimal property loss, provided that the regrind is free of contamination. To minimize losses during molding, the melt temperature should remain as low as possible. The final determination of regrind effectiveness should be determined by the customer.Dynaflex™ G7680-9 (Black) 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.Drying is not RequiredInjection Speed: 1 to 3 in/sec1st Stage - Boost Pressure: 350 to 900 psi2nd Stage - Hold Pressure: 30% of BoostHold Time (Thick Part): 3 to 10 secHold Time (Thin Part): 1 to 3 sec

NOTE	
1.	2 hr
2.	Mouth die c
3.	C mould

Recommended distributors for this material

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