

# Dynaflex™ G7960-9001-02

Thermoplastic Elastomer

PolyOne Corporation

Message:

Dynaflex™ G7960-9001-02 is an easy-to-process universal TPE designed for a wide range of applications, including applications that must comply with FDA standards.  
It can be bonded to polypropylene by overlapping molding  
Similar to rubber  
Soft to the touch

| General Information                      |                                  |          |             |
|------------------------------------------|----------------------------------|----------|-------------|
| UL YellowCard                            | E76261-101061780                 |          |             |
| Features                                 | Recyclable materials             |          |             |
|                                          | Workability, good                |          |             |
|                                          | Good processing stability        |          |             |
|                                          | Good liquidity                   |          |             |
|                                          | General                          |          |             |
| Uses                                     | overmolding                      |          |             |
|                                          | Washer                           |          |             |
|                                          | Household goods                  |          |             |
|                                          | Seals                            |          |             |
|                                          | Soft touch application           |          |             |
|                                          | Soft handle                      |          |             |
|                                          | Sporting goods                   |          |             |
|                                          | General                          |          |             |
|                                          | Consumer goods application field |          |             |
| Agency Ratings                           | FDA 21 CFR 177.2600 3            |          |             |
|                                          | UL 94 .QMFZ2.E76261              |          |             |
| RoHS Compliance                          | RoHS compliance                  |          |             |
| Appearance                               | Black                            |          |             |
| Forms                                    | Particle                         |          |             |
| Processing Method                        | 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) | 10                               | g/10 min | ASTM D1238  |
| Molding Shrinkage - Flow                 | 1.0 - 1.6                        | %        | ASTM D955   |
| Hardness                                 | Nominal Value                    | Unit     | Test Method |
| Durometer Hardness (Shore A, 10 sec)     | 60                               |          | ASTM D2240  |

| Elastomers                       | Nominal Value | Unit | Test Method |
|----------------------------------|---------------|------|-------------|
| Tensile Stress <sup>1</sup>      |               |      | ASTM D412   |
| 100% strain, 23°C <sup>2</sup>   | 2.14          | MPa  | ASTM D412   |
| 300% strain, 23°C <sup>3</sup>   | 2.62          | MPa  | ASTM D412   |
| Tensile Strength (Break, 23°C)   | 6.34          | MPa  | ASTM D412   |
| Tensile Elongation (Break, 23°C) | 760           | %    | ASTM D412   |
| Tear Strength                    | 24.5          | kN/m | ASTM D624   |
| Compression Set (23°C, 22 hr)    | 17            | %    | ASTM D395B  |

| Flammability           | Nominal Value | Test Method |
|------------------------|---------------|-------------|
| Flame Rating (1.50 mm) | HB            | UL 94       |

| Fill Analysis                                        | Nominal Value | Unit | Test Method |
|------------------------------------------------------|---------------|------|-------------|
| Apparent Viscosity (200°C, 11200 sec <sup>-1</sup> ) | 9.70          | Pa·s | ASTM D3835  |

#### Additional Information

Dynaflex™ G7960-9001-02 can be recycled as a filler or impact modifier for polyolefins, or can be recycled by grinding and reintroduction to the molding process. Similar to PP or PE recycling process, if separated appropriately, it can be recycled many times. Municipality waste stream recycle code is "7" which is designated for "Other". Please contact GLS Thermoplastic Elastomers for a copy of our Recyclability Compliance letter.

| Injection             | Nominal Value | Unit |
|-----------------------|---------------|------|
| Suggested Max Regrind | 20            | %    |
| Rear Temperature      | 166 - 177     | °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

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. Dynaflex™ G7960-9001-02 可利用高达 20% 的回收料同时其性能所受影响却极小,但该回收料必须是未受到污染的. 为了最大限度地减小模塑期间其性能所受的影响,熔体温度应维持得尽可能低. 回收料的有效性应由用户最终确定. 不需要干燥注射速度: 1 - 3 英寸/秒 第一阶段 - 提升压力: 350 - 900 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

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