

Dynaflex™ G7410-1000-00

Thermoplastic Elastomer

PolyOne Corporation

Message:

Dynaflex™ G7410-1000-00 is a high-performance composite material that is easy to process and is designed for various applications that require materials to be tough and durable.

Excellent coloring

Excellent thermal stability

It can be bonded to polypropylene by overlapping molding

Suitable for outdoor use

General Information			
Features	Recyclable materials		
	Good coloring		
	Thermal stability, good		
Uses	overmolding		
	Outdoor application		
RoHS Compliance	RoHS compliance		
Appearance	Natural color		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.898	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	2.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.8 - 2.2	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	68		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
100% strain, 23°C ²	2.69	MPa	ASTM D412
300% strain, 23°C ³	3.55	MPa	ASTM D412
Tensile Strength (Break, 23°C)	5.17	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	500	%	ASTM D412
Tear Strength	28.0	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	19	%	ASTM D395B
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 11200 sec ⁻¹)	14.8	Pa · s	ASTM D3835
Additional Information			

Dynaflex™ G7410-1000-00 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 - 204	°C
Middle Temperature	177 - 216	°C
Front Temperature	182 - 221	°C
Nozzle Temperature	182 - 221	°C
Mold Temperature	15.6 - 26.7	°C
Back Pressure	0.345 - 1.03	MPa
Screw Speed	25 - 75	rpm

Injection instructions

以聚丙烯 (PP), 乙烯醋酸乙烯共聚物 (EVA) 或低密度聚乙烯 (PE) 为基础的色母料最适合 Dynaflex™ G7410-1000-00 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. 典型的色母料用量为 1% 至 5%(重量). 可以使用液体颜料, 但以矿物油为基础的载体对最终硬度值会有显著的影响. 不应采用以 PVC 为基础的色母料. 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. 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) 的聚乙烯 (PE) 或聚丙烯 (PP) 彻底进行置换. Dynaflex™ G7410-1000-00 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. 回收料的有效性应由用户最终确定. Dynaflex™ G7410-1000-00 具有极好的熔体稳定性. 如果机器闲置三十 (30) 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: 250 - 650 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

NOTE

1. 2 hours
2. Mouth die c
3. C mould

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