

PolyOne Dynaflex™ G7650-9 (Black) Thermoplastic Elastomer (TPE)

Category : Polymer , Thermoplastic , Elastomer, TPE

Material Notes:

Dynaflex™ G7650-9 (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

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™ G7650-9 (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™ G7650-9 (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 Required

Injection Speed: 1 to 5 in/sec 1st Stage - Boost Pressure: 350 to 750 psi 2nd Stage - Hold Pressure: 50% of Boost Hold Time (Thick Part): 4 to 10 sec Hold Time (Thin Part): 1 to 3 sec

Information provided by PolyOne

Order this product through the following link:

http://www.lookpolymers.com/polymer_PolyOne-Dynaflex-G7650-9-Black-Thermoplastic-Elastomer-TPE.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.17 g/cc	1.17 g/cc	ASTM D792
Viscosity	9100 cP	9100 cP	ASTM D3835
	@Shear Rate 11200 1/s, Temperature 200 °C	@Shear Rate 11200 1/s, Temperature 392 °F	
	46800 cP	46800 cP	ASTM D3835
	@Shear Rate 1340 1/s, Temperature 200 °C	@Shear Rate 1340 1/s, Temperature 392 °F	
Linear Mold Shrinkage, Flow	0.011 - 0.019 cm/cm	0.011 - 0.019 in/in	ASTM D955
Melt Flow	9.0 g/10 min	9.0 g/10 min	ASTM D1238
	@Load 5.00 kg, Temperature 200 °C	@Load 11.0 lb, Temperature 392 °F	

Mechanical Properties	Metric	English	Comments
Hardness, Shore A	48	48	10 sec; ASTM D2240
Tensile Strength at Break	4.83 MPa	701 psi	Die C2 hr; ASTM D412
	@Temperature 23.0 °C	@Temperature 73.4 °F	
Tensile Stress	1.52 MPa	220 psi	Die C2 hr; ASTM D412
	@Strain 100 %, Temperature 23.0 °C	@Strain 100 %, Temperature 73.4 °F	
	2.76 MPa	400 psi	

Mechanical Properties	Metric	English	Comments
	@Strain 300 %, Temperature 23.0 °C	@Strain 300 %, Temperature 73.4 °F	Die C2 hr; ASTM D412
Elongation at Break	700 % @Temperature 23.0 °C	700 % @Temperature 73.4 °F	Die C2 hr; ASTM D412
Tear Strength	20.5 kN/m	117 pli	ASTM D624
Compression Set	12 % @Temperature 23.0 °C, Time 79200 sec	12 % @Temperature 73.4 °F, Time 22.0 hour	ASTM D395B

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	160 - 177 °C	320 - 351 °F	
Middle Barrel Temperature	177 - 188 °C	351 - 370 °F	
Front Barrel Temperature	188 - 216 °C	370 - 421 °F	
Nozzle Temperature	188 - 227 °C	370 - 441 °F	
Mold Temperature	15.6 - 26.7 °C	60.1 - 80.1 °F	
Back Pressure	0.000 - 1.03 MPa	0.000 - 149 psi	
Screw Speed	40 - 100 rpm	40 - 100 rpm	

Descriptive Properties	Value	Comments
Agency Ratings	FDA 21 CFR 177.1210	Please contact GLS Thermoplastic Elastomers for a copy of the FDA compliance letter.
Appearance	Black	
Features	General Purpose	
	Good Flow	
	Good Processability	
	Good Processing Stability	
Forms	Pellets	
Generic Material	TPE	
Generic Name	Thermoplastic Elastomer (TPE)	
Manufacturer / Supplier	GLS Thermoplastic Elastomers	

Descriptive Properties	Method	Value	Comments
		Injection Molding	
Regional Availability		Asia Pacific	
RoHS Compliance		RoHS Compliant	
Suggested Max Regrind		20%	
Uses		Consumer Applications	
		Flexible Grips	
		Gaskets	
		General Purpose	
		Overmolding	
		Seals	
		Soft Touch Applications	
		Sporting Goods	

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