Dynaflex™ G7930-9 NSFG

Thermoplastic Elastomer

Key Characteristics

Product Description

Dynaflex™ G7930-9 NSFG is a NSF 51 (food equipment) approved material suitable for a wide variety of applications.

- NSF 51 approved
- FDA (see Notes)
- Overmold Adhesion to Polypropylene
- Soft Touch, Rubbery Feel

General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• General Purpose • Good Flow	• Good Processability • Good Processing Stability	• Recyclable Material
Uses	• Consumer Applications • Flexible Grips • Food Service Applications • Gaskets	• Household Goods • Kitchenware • Non-specific Food Applications • Overmolding	• Seals • Soft Touch Applications
Agency Ratings	• FDA 21 CFR 177.2600 [1]	• NSF STD-51	
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [2]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.05	1.05	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	37 g/10 min	37 g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.013 to 0.021 in/in	1.3 to 2.1 %	ASTM D955
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [3, 4] (100% Strain, 73°F (23°C))	130 psi	0.896 MPa	ASTM D412
Tensile Stress [3, 4] (300% Strain, 73°F (23°C))	200 psi	1.38 MPa	ASTM D412
Tensile Strength [3, 4] (Break, 73°F (23°C))	480 psi	3.31 MPa	ASTM D412
Tensile Elongation [3, 4] (Break, 73°F (23°C))	650 %	650 %	ASTM D412
Tear Strength [4] (73°F (23°C))	100 lbf/in	17.5 kN/m	ASTM D624
Compression Set (73°F (23°C), 22 hr)	13 %	13 %	ASTM D395B
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	30	30	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	6.40 Pa·s	6.40 Pa·s	

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Additional Information

Dynaflex™ G7930-9 NSFG 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.

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	320 to 350 °F	160 to 177 °C
Middle Temperature	350 to 370 °F	177 to 188 °C
Front Temperature	370 to 400 °F	188 to 204 °C
Nozzle Temperature	370 to 400 °F	188 to 204 °C
Mold Temperature	60 to 80 °F	16 to 27 °C
Back Pressure	50.0 to 150 psi	0.345 to 1.03 MPa
Screw Speed	25 to 75 rpm	25 to 75 rpm

Injection Notes

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™ G7930-9 NSFG 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™ G7930-9 NSFG 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: 200 to 700 psi
2nd Stage - Hold Pressure: 50% of Boost
Hold Time (Thick Part): 4 to 10 sec
Hold Time (Thin Part): 1 to 3 sec

Notes

[1] Please contact GLS Thermoplastic Elastomers for a copy of the FDA compliance letter.

[2] Typical values are not to be construed as specifications.

[3] Die C

[4] 2 hr

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