Dynaflex™ G6725-0001

Thermoplastic Elastomer

Key Characteristics

Product Description

Dynaflex™ G6725-0001 is an easy processing compound designed for use in injection molding applications where extremely soft feel properties are desired.

- Excellent Colorability
- Good Ozone and UV Stability
- Overmold Adhesion to Polypropylene
- Tactile Feel
- Ultra Soft Touch

General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Colorability	• Ozone Resistant	• UV Resistant
Uses	• Consumer Applications • Flexible Grips	• Overmolding • Personal Care	• Soft Touch Applications • Toys
Agency Ratings	• FDA 21 CFR 177.1210 [1]		
RoHS Compliance	• RoHS Compliant		
Appearance	• Translucent		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

Technical Properties [2]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.890	0.890	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	35 g/10 min	35 g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.028 to 0.032 in/in	2.8 to 3.2 %	ASTM D955
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [3, 4] (100% Strain, 73°F (23°C))	70.0 psi	0.483 MPa	ASTM D412
Tensile Stress [3, 4] (300% Strain, 73°F (23°C))	150 psi	1.03 MPa	ASTM D412
Tensile Strength [3, 4] (Break, 73°F (23°C))	570 psi	3.93 MPa	ASTM D412
Tensile Elongation [3, 4] (Break, 73°F (23°C))	820 %	820 %	ASTM D412
Tear Strength	65.0 lbf/in	11.4 kN/m	ASTM D624
Compression Set (73°F (23°C), 22 hr)	9.0 %	9.0 %	ASTM D395B
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	24	24	ASTM D2240

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Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	330 to 400 °F	166 to 204 °C
Middle Temperature	350 to 420 °F	177 to 216 °C
Front Temperature	370 to 440 °F	188 to 227 °C
Nozzle Temperature	370 to 440 °F	188 to 227 °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	115 to 165 rpm	115 to 165 rpm

Injection Notes

Color concentrates with polypropylene (PP), ethylene vinyl acetate (EVA), or low density polyethylene (PE) carriers are most suitable for coloring Dynaflex™ G6725-0001. Improved color dispersion can be achieved by using higher melt flow concentrates (with a melt flow of 25 - 40 g/10 min). Typical loadings for color concentrates are 1% to 5% by weight. Liquid color can be used, but mineral oil based carriers may have a significant effect on the final hardness value. Concentrates based on PVC should not be used. A high color match consistency can be obtained by using precolored compounds available from GLS. The final determination of color concentrate suitability should be determined by customer trials.

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™ G6725-0001 with minimal property loss, provided that the regrind is free of contamination. To minimize losses during molding, the melt tempetature should remain as low as possible. The final determination of regrind effectiveness should be determined by the customer.

The Dynaflex™ G6725-0001 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: 150 to 550 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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