# OnFlex™ 7610-60

## Thermoplastic Elastomer

## Key Characteristics

**Product Description**

OnFlex™ 7610-60 is an easy processing TPE designed for a variety of automotive applications.

- Excellent surface finish
- Good adhesion to polypropylene
- Excellent performance in static mechanical parts such as seals & grips, plugs, clips and cable clamps.
- Good UV stability
- Low Odor per VDA 270
- OnFlex™ 7610-60B = black
- OnFlex™ 7610-60N = natural

| General | | |
|---|---|---|
| Material Status | • Commercial: Active | |
| Regional Availability | • North America | |
| Features | • Good Processability | |
| Uses | • Automotive Applications<br>• Gaskets | • Overmolding<br>• Plugs |
| RoHS Compliance | • RoHS Compliant | |
| Appearance | • Black | • Natural Color |
| Forms | • Pellets | |
| Processing Method | • Extrusion | • Injection Molding |

## Technical Properties [1]

| Physical | Typical Value (English) | Typical Value (SI) | Test Method |
|---|---|---|---|
| Density | 1.00 g/cm³ | 1.00 g/cm³ | ASTM D792 |
| **Elastomers** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Tensile Strength (Break) | 1170 psi | 8.04 MPa | ASTM D412 |
| Tensile Elongation (Break) | 690 % | 690 % | ASTM D412 |
| Tear Strength | 167 lbf/in | 29.2 kN/m | ASTM D624 |
| Compression Set | | | ASTM D395 |
| 73°F (23°C), 72 hr | 22 % | 22 % | |
| 158°F (70°C), 22 hr | 51 % | 51 % | |
| **Hardness** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Shore Hardness (Shore A, 10 sec) | 66 | 66 | ISO 48-4 |
| **Additional Information** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Weather Resistance - (1500h) [2] | passed (black version) | passed (black version) | SAE J2527 |

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## Processing Information

| Injection | Typical Value (English) | Typical Value (SI) |
|---|---|---|
| Suggested Max Regrind | 20 % | 20 % |
| Rear Temperature | 320 to 370 °F | 160 to 188 °C |
| Middle Temperature | 350 to 380 °F | 177 to 193 °C |
| Front Temperature | 370 to 410 °F | 188 to 210 °C |
| Nozzle Temperature | 370 to 420 °F | 188 to 216 °C |
| Mold Temperature | 86 to 140 °F | 30 to 60 °C |
| Injection Rate | Fast | Fast |
| Back Pressure | 0.00 to 120 psi | 0.00 to 0.827 MPa |
| Screw Speed | 40 to 100 rpm | 40 to 100 rpm |
| **Extrusion** | **Typical Value (English)** | **Typical Value (SI)** |
| Melt Temperature | 356 to 428 °F | 180 to 220 °C |

### Notes

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

[2] OnFlex 7610-60B (60Sh A; black) has been tested according weathering test SAE J2527.

### CONTACT INFORMATION

**North America**
Avon Lake, United States
33587 Walker Road
Avon Lake, OH, United States , 44012
+1 440 930 1000
+1 844 4AVIENT

**South America**
Sao Paulo, Brazil
Av. Francisco Nakasato, 1700
13295-000 Itupeva
Sao Paulo, Brazil
+55 11 4593 9200

**Asia**
Shanghai, China
2F, Block C
200 Jinsu Road
Pudong, 201206
Shanghai, China
+86 (0) 21 6028 4888

**Europe**
Pommerloch, Luxembourg
19 Route de Bastogne
Pommerloch, Luxembourg , L-9638
+352 269 050 35

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