Dynaflex™ G7960-1 NSFG

Thermoplastic Elastomer

Key Characteristics

Product Description			
Dynaflex™ G7960-1 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	• Latin America • North America	
Features	• Good Colorability • 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	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [2]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.18	1.18	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	11 g/10 min	11 g/10 min	ASTM D1238
Molding Shrinkage - Flow	9.0E-3 to 0.015 in/in	0.90 to 1.5 %	ASTM D955
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [3, 4] (100% Strain, 73°F (23°C))	310 psi	2.14 MPa	ASTM D412
Tensile Stress [3, 4] (300% Strain, 73°F (23°C))	380 psi	2.62 MPa	ASTM D412
Tensile Strength [3, 4] (Break, 73°F (23°C))	920 psi	6.34 MPa	ASTM D412
Tensile Elongation [3, 4] (Break, 73°F (23°C))	760 %	760 %	ASTM D412
Tear Strength	140 lbf/in	24.5 kN/m	ASTM D624
Compression Set (73°F (23°C), 22 hr)	17 %	17 %	ASTM D395B
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	60	60	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	9.30 Pa·s	9.30 Pa·s	

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Additional Information
Dynaflex™ G7960-1 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 380 °F	177 to 193 °C
Front Temperature	370 to 430 °F	188 to 221 °C
Nozzle Temperature	380 to 440 °F	193 to 227 °C
Mold Temperature	60 to 100 °F	16 to 38 °C
Back Pressure	0.00 to 150 psi	0.00 to 1.03 MPa
Screw Speed	40 to 100 rpm	40 to 100 rpm

Injection Notes
Color concentrates with polypropylene (PP), ethylene vinyl acetate (EVA), or low density polyethylene (PE) carriers are most suitable for coloring Dynaflex™ G7960-1 NSFG. Improved color dispersion can be achieved by using higher melt flow concentrates (with a melt flow from 25 - 40 g/10 min). Typical loadings for color concentrates are 1% to 5% by weight. Concentrates based on PVC should not be used. 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™ G7960-1 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™ G7960-1 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 3 in/sec 1st Stage - Boost Pressure: 350 to 900 psi 2nd Stage - Hold Pressure: 30% of Boost Hold Time (Thick Part): 3 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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