# Dynaflex™ G7950-9001-02

## Thermoplastic Elastomer

### Key Characteristics

| Product Description |
|---|

Dynaflex™ G7950-9001-02 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

| General | | | |
|---|---|---|---|
| Material Status | • Commercial: Active | | |
| Regional Availability | • Africa & Middle East<br>• Asia Pacific | • Europe<br>• Latin America | • North America |
| Features | • General Purpose<br>• Good Flow | • Good Processability<br>• Good Processing Stability | • Recyclable Material |
| Uses | • Consumer Applications<br>• Flexible Grips<br>• Gaskets | • General Purpose<br>• Household Goods<br>• Overmolding | • Seals<br>• Soft Touch Applications<br>• Sporting Goods |
| Agency Ratings | • FDA 21 CFR 177.2600 [1] | • UL 94 | |
| RoHS Compliance | • RoHS Compliant | | |
| Automotive Specifications | • FMVSS 302 | | |
| Appearance | • Black | | |
| 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) | 1.0 g/10 min | 1.0 g/10 min | ASTM D1238 |
| Molding Shrinkage - Flow | 0.013 to 0.019 in/in | 1.3 to 1.9 % | ASTM D955 |
| **Elastomers** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Tensile Stress [3, 4] (100% Strain, 73°F (23°C)) | 250 psi | 1.72 MPa | ASTM D412 |
| Tensile Stress [3, 4] (300% Strain, 73°F (23°C)) | 360 psi | 2.48 MPa | ASTM D412 |
| Tensile Strength [3, 4] (Break, 73°F (23°C)) | 660 psi | 4.55 MPa | ASTM D412 |
| Tensile Elongation [3, 4] (Break, 73°F (23°C)) | 620 % | 620 % | ASTM D412 |
| Tear Strength | 120 lbf/in | 21.0 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) | 50 | 50 | ASTM D2240 |
| **Flammability** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Flame Rating (0.06 in (1.5 mm)) | HB | HB | UL 94 |
| **Fill Analysis** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Apparent Viscosity | | | ASTM D3835 |
| 392°F (200°C), 11200 sec^-1 | 10.0 Pa·s | 10.0 Pa·s | |

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| Additional Information |
|---|
| Dynaflex™ G7950-9001-02 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 420 °F | 188 to 216 °C |
| Nozzle Temperature | 370 to 440 °F | 188 to 227 °C |
| Mold Temperature | 60 to 80 °F | 16 to 27 °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 |
|---|
| 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™ G7950-9001-02 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™ G7950-9001-02 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<br>1st Stage - Boost Pressure: 350 to 750 psi<br>2nd Stage - Hold Pressure: 50% of Boost<br>Hold Time (Thick Part): 4 to 10 sec<br>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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