# Dynaflex™ G7630-9 (Black)

## Thermoplastic Elastomer

### Key Characteristics

**Product Description**

Dynaflex™ G7630-9 (Black) is an easy processing, general purpose TPE designed for a wide variety of applications, including those where FDA compliance is required. *Made with Kraton® Polymer

- Non-Slip Grip
- Overmold Adhesion To Polypropylene
- Soft Touch, Rubbery Feel

| General | | | |
|---|---|---|---|
| Material Status | • Commercial: Active | | |
| Regional Availability | • Asia Pacific | | |
| Features | • General Purpose<br>• Good Flow | • Good Processability<br>• Good Processing Stability | |
| Uses | • Consumer Applications<br>• Flexible Grips<br>• Gaskets | • General Purpose<br>• Overmolding<br>• Seals | • Soft Touch Applications<br>• Sporting Goods |
| Agency Ratings | • FDA 21 CFR 177.1210 [1] | | |
| RoHS Compliance | • RoHS Compliant | | |
| Appearance | • Black | | |
| Forms | • Pellets | | |
| Processing Method | • Extrusion | • 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) | 100 g/10 min | 100 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)) | 100 psi | 0.689 MPa | ASTM D412 |
| Tensile Stress [3, 4] (300% Strain, 73°F (23°C)) | 240 psi | 1.65 MPa | ASTM D412 |
| Tensile Strength [3, 4] (Break, 73°F (23°C)) | 475 psi | 3.28 MPa | ASTM D412 |
| Tensile Elongation [3, 4] (Break, 73°F (23°C)) | 650 % | 650 % | ASTM D412 |
| Tear Strength | 85.0 lbf/in | 14.9 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) | 29 | 29 | 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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## 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 | 60 to 100 °F | 16 to 38 °C |
| Back Pressure | 0.00 to 120 psi | 0.00 to 0.827 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 polypopylene (PP).

Regrind levels up to 20% can be used with Dynaflex™ G7630-9 (Black) 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™ G7630-9 (Black) 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: 200 to 900 psi
2nd Stage - Hold Pressure: 50% 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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