Dynaflex™ G6713-0001 EU

Thermoplastic Elastomer

Key Characteristics

Product Description

Dynaflex™ G6713-0001 EU is an easy processing TPE designed for use in injection molding and extrusion applications where an extremely soft feel is desired. This product is formulated for certain food contact and pharmaceutical applications, for further Information please contact our Product stewardship.

- Excellent Colorability
- Overmold Adhesion To Polypropylene
- Tactile Feel
- Ultra Soft Touch

General

Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East	• Asia Pacific	• Europe
Features	• Good Colorability	• Ozone Resistant	• UV Resistant
Uses	• Consumer Applications • Flexible Grips • Gaskets	• Overmolding • Personal Care • Seals	• Soft Touch Applications • Toys • Transparent or Translucent Parts
RoHS Compliance	• RoHS Compliant		
Appearance	• Translucent		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density	0.890 g/cm³	0.890 g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR)			ISO 1133
190°C/2.16 kg	1.0 g/10 min	1.0 g/10 min	
200°C/5.0 kg	40 g/10 min	40 g/10 min	
Molding Shrinkage			ISO 294-4
Across Flow : 73°F (23°C)	1.2 %	1.2 %	
Flow : 73°F (23°C) [2]	4.4 %	4.4 %	

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Elastomers	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Stress - Flow [3]			ISO 37
100% Strain, 73°F (23°C), 0.0787 in (2.00 mm)	50.8 psi	0.350 MPa	
Tensile Stress - Flow [3]			ISO 37
300% Strain, 73°F (23°C), 0.0787 in (2.00 mm)	94.3 psi	0.650 MPa	
Tensile Stress - Flow [3]			ISO 37
Break, 73°F (23°C), 0.0787 in (2.00 mm)	239 psi	1.65 MPa	
Tensile Elongation - Flow [3]			ISO 37
Break, 73°F (23°C), 0.0787 in (2.00 mm)	700 %	700 %	
Tear Strength - Flow [4]			ISO 34-1
73°F (23°C), 0.0787 in (2.00 mm)	37.1 lbf/in	6.50 kN/m	
Compression Set (73°F (23°C), 22 hr)	11 %	11 %	ISO 815
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness [5] (Shore A, 10 sec)	14	14	ISO 48-4
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	5.70 Pa·s	5.70 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	300 to 350 °F	149 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 420 °F	188 to 216 °C
Mold Temperature	60 to 80 °F	16 to 27 °C
Back Pressure	0.00 to 110 psi	0.00 to 0.758 MPa
Screw Speed	50 to 150 rpm	50 to 150 rpm

Injection Notes

Color concentrates with polypropylene (PP), ethylene vinyl acetate (EVA), or low density polyethylene (PE) carriers are most suitable for coloring Dynaflex™ G6713-0001 EU. 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. 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™ G6713-0001 EU 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.

The Dynaflex™ G6713-0001 EU 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: 150 to 700 psi
2nd Stage - Hold Pressure: 30% of Boost
Hold Time (Thick Part): 3 to 10 sec
Hold Time (Thin Part): 1 to 3 sec

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Notes

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

[2] on 100mmx100mmx2mm plaques

[3] 7.9 in/min (200 mm/min)

[4] 20 in/min (500 mm/min)

[5] ±5 Sh A

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