Dynaflex™ G6713-9 Black

Thermoplastic Elastomer

Key Characteristics

Product Description

Dynaflex™ G6713-9 Black is an easy processing TPE designed for use in injection molding and extrusion applications where an extremely soft feel is desired.

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

General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Latin America • North America	
Features	• 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	• Black		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.880	0.880	ASTM D792
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2, 3] (300% Strain, 73°F (23°C))	110 psi	0.758 MPa	ASTM D412
Tensile Strength [2, 3] (Break, 73°F (23°C))	332 psi	2.29 MPa	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F (23°C))	770 %	770 %	ASTM D412
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	15	15	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	5.30 Pa·s	5.30 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

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Notes

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

[2] Die C

[3] 2 hr

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