Dynaflex™ G6730

Thermoplastic Elastomer

Key Characteristics

Product Description

Dynaflex™ G6730 is an easy processing TPE designed for use in injection molding applications where an extremely soft feel is desired.

- Excellent Colorability
- Good Elastic Memory
- Overmold Adhesion to Polypropylene
- Rubbery Feel
- Ultra Soft Touch

General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Colorability	• Good Flow	• Good Processing Stability
Uses	• Consumer Applications • Flexible Grips	• Overmolding • Soft Touch Applications	• Toys • Transparent or Translucent Parts
Agency Ratings	• FDA [1]		
RoHS Compliance	• RoHS Compliant		
Appearance	• Translucent		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [2]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.910	0.910	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	6.0 g/10 min	6.0 g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.040 to 0.044 in/in	4.0 to 4.4 %	ASTM D955
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [3, 4] (100% Strain, 73°F (23°C))	110 psi	0.758 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))	740 psi	5.10 MPa	ASTM D412
Tensile Elongation [3, 4] (Break, 73°F (23°C))	530 %	530 %	ASTM D412
Tear Strength	80.0 lbf/in	14.0 kN/m	ASTM D624
Compression Set (73°F (23°C), 22 hr)	12 %	12 %	ASTM D395B
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	30	30	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	10.2 Pa·s	10.2 Pa·s	

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Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	275 to 360 °F	135 to 182 °C
Middle Temperature	330 to 380 °F	166 to 193 °C
Front Temperature	340 to 390 °F	171 to 199 °C
Nozzle Temperature	340 to 400 °F	171 to 204 °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	25 to 75 rpm	25 to 75 rpm

Injection Notes

Color concentrates with polypropylene (PP), ethylene vinyl acetate (EVA), or polyethylene (PE) carriers are most suitable for coloring Dynaflex™ G6730. 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™ G6730 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™ G6730 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: 300 to 800 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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