Dynaflex™ G7940-9001-02

Thermoplastic Elastomer

Key Characteristics

Product Description

Dynaflex™ G7940-9001-02 is an easy processing, general purpose TPE designed for a wide variety of applications, including those where FDA compliance is required.

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

General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• General Purpose • Good Flow	• Good Processability • Good Processing Stability	• Recyclable Material
Uses	• Consumer Applications • Flexible Grips • Gaskets	• General Purpose • Household Goods • Overmolding	• Seals • Soft Touch Applications • 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)	2.0 g/10 min	2.0 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))	180 psi	1.24 MPa	ASTM D412
Tensile Stress [3, 4] (300% Strain, 73°F (23°C))	295 psi	2.03 MPa	ASTM D412
Tensile Strength [3, 4] (Break, 73°F (23°C))	520 psi	3.59 MPa	ASTM D412
Tensile Elongation [3, 4] (Break, 73°F (23°C))	580 %	580 %	ASTM D412
Tear Strength	100 lbf/in	17.5 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)	40	40	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	8.80 Pa·s	8.80 Pa·s	

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Additional Information

Dynaflex™ G7940-9001-02 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	330 to 350 °F	166 to 177 °C
Middle Temperature	350 to 370 °F	177 to 188 °C
Front Temperature	370 to 400 °F	188 to 204 °C
Nozzle Temperature	370 to 400 °F	188 to 204 °C
Mold Temperature	60 to 80 °F	16 to 27 °C
Back Pressure	50.0 to 150 psi	0.345 to 1.03 MPa
Screw Speed	25 to 100 rpm	25 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™ G7940-9001-02 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™ G7940-9001-02 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
1st Stage - Boost Pressure: 150 to 675 psi
2nd Stage - Hold Pressure: 70% of Boost
Hold Time (Thick Part): 4 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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