

DuraGrip® DGR 6160NC

Thermoplastic Elastomer

Advanced Polymer Alloys

Message:

DuraGrip® DGR 6160 is offered in an NC (colorable) version, and is designed to chemically bond to a wide variety of thermoplastic substrates including ABS, PC, Nylon 6, Nylon 6/6, glass filled Nylon, ASA, PC/ABS alloys, PBT, and PC/PBT alloys. It is easy to use in injection molding and extrusion processes. DGR 6160NC has excellent elastomeric properties and soft touch feel. DuraGrip® bonding grades are hygroscopic, and for best results drying is recommended prior to use.

General Information	
Features	Good adhesion
Agency Ratings	EU 2002/96/EC (WEEE)
RoHS Compliance	RoHS compliance
Forms	Particle
Processing Method	Extrusion Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm ³	ASTM D792, ISO 1183
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 5 sec)	65		ASTM D2240, ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	2.30	MPa	ASTM D412, ISO 37
Tensile Strength (Yield)	14.2	MPa	ASTM D412, ISO 37
Tensile Elongation (Break)	550	%	ASTM D412, ISO 37
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (190°C, 200 sec ⁻¹)	354	Pa · s	ASTM D3835

Additional Information

The value listed as Density -Specific Gravity, ASTM D792, was tested in accordance with ASTM D471. The value listed as Density, ISO 1183, was tested in accordance with ISO 2781.

Injection	Nominal Value	Unit
Rear Temperature	204 - 221	°C
Middle Temperature	216 - 227	°C
Front Temperature	227 - 238	°C
Nozzle Temperature	227 - 249	°C
Processing (Melt) Temp	227 - 254	°C
Mold Temperature	43.3 - 54.4	°C
Injection Pressure	2.76 - 5.52	MPa
Screw Speed	50 - 150	rpm

Injection instructions

Injection Speed: 1 to 3 in³/sec
Injection Time (1st Stage/Boost): 0.5 to 4 sec
Second Stage Pressure: 300 to 500 psi
Second Stage Time: 3 to 10 sec
Cooling Time: 10 to 25 sec
Back Pressure: 25 to 75 %

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