

DuraGrip® DGR 6140UT

Thermoplastic Elastomer

Advanced Polymer Alloys

Message:

DuraGrip® DGR 6140UT is an unfilled translucent Thermoplastic Elastomer (TPE). It is designed to process easily in injection molding and extrusion applications. DuraGrip® TPE features excellent soft touch feel, will bond to ABS, PC, clear copolyester and acrylics, and because it is translucent it is easily colored with a minimum of concentrate. DuraGrip® TPE is not hygroscopic and under normal conditions does not require drying.

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

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.958	g/cm ³	ASTM D792, ISO 1183
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 5 sec)	38		ASTM D2240, ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	1.20	MPa	ASTM D412, ISO 37
Tensile Strength (Yield)	8.93	MPa	ASTM D412, ISO 37
Tensile Elongation (Break)	640	%	ASTM D412, ISO 37
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (190°C, 200 sec ⁻¹)	302	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/secInjection Time (1st Stage/Boost): 0.5 to 4 secSecond Stage Pressure: 300 to 500 psiSecond Stage Time: 3 to 10 secCooling Time: 10 to 25 secBack Pressure: 25 to 75 %

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