

DuraGrip® DGR 6165TR

Thermoplastic Elastomer

Advanced Polymer Alloys

Message:

DuraGrip® DGR6165TR is a translucent thermoplastic elastomer (TPE) formulated for excellent elastic properties and enhanced adhesion to engineered thermoplastics using insert molding, co-injection molding and co-extrusion processes. DGR6165TR bonds tenaciously to polycarbonate, polycarbonate alloys, ABS, ASA, acrylics, and cellulosic materials. It will also bond to various nylons and PET. DGR6165TR is hygroscopic and drying is recommended at 150F for 3 to 4 hours to ensure optimum aesthetics, properties and adhesion.

General Information			
Features	Bondability		
	Good Adhesion		
	High Elongation		
Uses	Bonding		
Appearance	Translucent		
Processing Method	Coextrusion		
	Injection Molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D471, ISO 2781
Melt Mass-Flow Rate (MFR) (190°C/8.7 kg)	11	g/10 min	ASTM D1238

Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	65		ASTM D2240, ISO 48

Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412, ISO 37
Across Flow : 100% Strain	3.97	MPa	
Flow : 100% Strain	3.43	MPa	
Across Flow : 300% Strain	9.23	MPa	
Flow : 300% Strain	7.73	MPa	
Tensile Strength			ASTM D412, ISO 37
Across Flow : Break	25.9	MPa	
Flow : Break	18.1	MPa	
Tensile Elongation			ASTM D412, ISO 37
Across Flow : Break	810	%	
Flow : Break	580	%	
Tear Strength ¹			ASTM D624
Across Flow	59.5	kN/m	
Flow	52.2	kN/m	

Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (190°C, 294 sec ⁻¹)	427	Pa · s	ASTM D3835

Injection	Nominal Value	Unit
Drying Temperature	65.6	°C
Drying Time	3.0 to 4.0	hr
Processing (Melt) Temp	180 to 230	°C
NOTE		
1.	Die C	

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