

DEXFLEX® 727

Thermoplastic Polyolefin Elastomer

LyondellBasell Industries

Message:

Dexflex 727 is a thermoplastic olefinic elastomer (TPO) designed for automotive exterior applications that require a combination of stiffness, good low-temperature impact resistance, and excellent processability.

General Information			
Features	Good Processability		
	Good Stiffness		
	Good Weather Resistance		
	Low Temperature Impact Resistance		
	Paintable		
Uses	Automotive Applications		
	Automotive Exterior Parts		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	0.970	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	14	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress ¹ (Yield, 4.00 mm)	19.0	MPa	ISO 527-2/50
Flexural Modulus (4.00 mm)	1320	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Instrumented Dart Impact ² (23°C)	18.0	J	ASTM D3763
Injection	Nominal Value	Unit	
Rear Temperature	193 to 227	°C	
Middle Temperature	193 to 227	°C	
Front Temperature	193 to 227	°C	
Nozzle Temperature	193 to 227	°C	
Processing (Melt) Temp	210 to 232	°C	
Mold Temperature	18.3 to 48.9	°C	
Injection Pressure	3.45 to 10.3	MPa	
Injection Rate	Moderate		
Back Pressure	0.345 to 2.07	MPa	
Screw Speed	50 to 100	rpm	
Clamp Tonnage	2.8 to 4.1	kN/cm ²	
Cushion	6.35 to 12.7	mm	

NOTE

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| 1. | 150x10x4 mm specimen |
| 2. | 2.20 m/sec |

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