

# DuraGrip® DGR 6040NCEHT

Thermoplastic Elastomer

Advanced Polymer Alloys

## Message:

DuraGrip® DGR 6040NCEHT is a general purpose Thermoplastic Elastomer (TPE) designed to process easily in injection molding and extrusion. It features excellent soft touch feel with improved surface tack that produces superior grip qualities. DGR 6040NCEHT will bond to olefinics, and is easily colored. DuraGrip® is not hygroscopic and under normal conditions does not require drying.

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

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.938	g/cm <sup>3</sup>	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)	1.38	MPa	ASTM D412, ISO 37
Tensile Strength (Yield)	2.69	MPa	ASTM D412, ISO 37
Tensile Elongation (Break)	500	%	ASTM D412, ISO 37
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (190°C, 200 sec <sup>-1</sup> )	102	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	188 - 199	°C
Middle Temperature	199 - 210	°C
Front Temperature	216 - 227	°C
Nozzle Temperature	204 - 221	°C
Processing (Melt) Temp	199 - 221	°C
Mold Temperature	43.3 - 54.4	°C
Injection Pressure	1.03 - 4.14	MPa
Screw Speed	25 - 100	rpm

#### Injection instructions

Injection Speed: 1 to 3 in<sup>3</sup>/sec Injection Time (1st Stage/Boost): 0.5 to 4 sec Second Stage Pressure: 150 to 300 psi Second Stage Time: 3 to 10 sec Cooling Time: 10 to 20 sec Back Pressure: 20 to 75 %

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