

# DuraGrip® DGR 7800

Thermoplastic Elastomer

Advanced Polymer Alloys

## Message:

DuraGrip® DGR 7800 is a specialty grade Thermoplastic Elastomers (TPE) that is formulated with FDA compliant raw materials and is easy to use in the injection molding and extrusion process. DGR 7800 has an excellent soft touch feel and will bond to olefinics.

General Information			
Features	Good adhesion		
	Soft		
Agency Ratings	EU 2002/96/EC (WEEE)		
	FDA not rated		
RoHS Compliance	RoHS compliance		
Appearance	Translucent		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	0.980	g/cm <sup>3</sup>	ASTM D471
--	0.892	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage			
Flow: 3.18mm	1.9	%	
Transverse flow: 3.18mm	2.1	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 5 sec)	59		ASTM D2240, ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	2.36	MPa	ASTM D412, ISO 37
Tensile Strength (Yield)	7.18	MPa	ASTM D412, ISO 37
Tensile Elongation (Break)	690	%	ASTM D412, ISO 37
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (190°C, 300 sec <sup>-1</sup> )	120	Pa · s	ASTM D3835
Injection	Nominal Value	Unit	
Drying Temperature	65.6	°C	
Drying Time	3.0	hr	
Suggested Max Regrind	25	%	
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 - 3.45	MPa
Screw Speed	25 - 100	rpm

#### Injection instructions

Injection Speed: 1 to 3 cu. in. /sec. Injection Time (boost: 0.5 to 2 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 50%

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