

Dynaflex™ G7680-1 (Natural)

TPE

Avient Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	33	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-
Mold Shrinkage, MD	0.01	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Modulus at 100% Elongation	3.9	MPa	ASTM D 412
Modulus at 300% Elongation	1.52	MPa	ASTM D 412
Shore A Hardness	81	-	ASTM D 2240
Tear Strength	34.1	kN/m	ASTM D 624
Compression Set , 22 hr @ 73 °F	23	%	ASTM D 395
Tensile Strength at Break	7.93	MPa	ASTM D 412
Elongation at Break	660	%	ASTM D 412

Other properties	Value	Unit	Test Standard
Density	1180	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Mold temperature	15.6 - 37.8	°C	-
Zone 1	166 - 188	°C	-
Zone 2	177 - 188	°C	-
Zone 3	188 - 216	°C	-
Nozzle temperature	188 - 227	°C	-
Screw speed	40 - 100	rpm	-
Injection speed	25.4 - 76.2	mm/s	-
Back pressure	0 - 0.827	MPa	-
Holding pressure	0.724 - 1.86	MPa	-

Characteristics**Processing**

Injection Molding, Other Extrusion

Delivery form

Pellets, Natural Color

Features

Good Adhesion, Soft Feel

Certifications

Food contact, Food approval FDA 21 CFR

Applications

General Purpose, Sports Equipment

Regional Availability

Asia Pacific