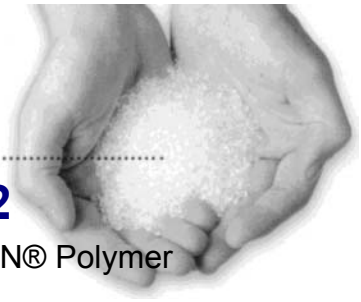
Technical Data Sheet



DYNAFLEX® G7950-9001-02

Thermoplastic Elastomer Compound made with KRATON® Polymer

The DYNAFLEX® G7950-9001-02 is an easy processing, general purpose material designed for a wide variety of applications, including those where FDA compliance is required.

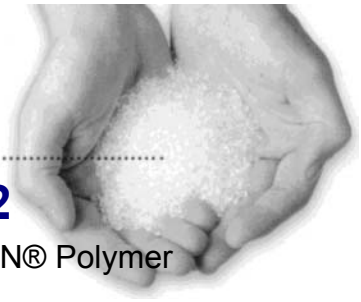
Product Feature	*Example Applications:*
SOFT TOUCH, RUBBERY FEEL	HARDWARE AND POWER TOOL GRIPS
OVERMOLD ADHESION TO POLYPROPYLENE	DISPOSABLE GRIPS AND HANDLES
UL 94 HB FLAME RATING (1.5 MM)	SPORT GRIPS AND KNOBS
NSF-61 (WATER), NSF-51 (FOOD EQUIPMENT)	HAND HELD ELECTRONICS
AUTOMOTIVE FMVSS 302	HOUSEWARE UTENSILS AND APPLIANCES

Color	Black

Physical Data		English	Metric
Hardness			
Shore A- 10 sec dwell	ASTM D2240	50 Shore A	
Specific Gravity			
	ASTM D792	1.18	
Melt Flow Rate			
190°C / 2160g	ASTM D1238	N/A g/10 min	N/A
200°C / 5000g		1 g/10 min	
Viscosity @ 200°C			
at 11170/sec	ASTM D1238E	10000 cPs	10 Pa-sec
Shrinkage			
Flow Direction	ASTM D955	0.018 - 0.022 in/in	0.018 - 0.022 mm/mm
Compression Set @ 23°C			
	ASTM D395B	10 %	

Tensile Data		English	Metric
Cross Direction			
@ 100 %	ASTM D412 - Die C	200 PSI	1378 kPa
@ 300 %		360 PSI	2481 kPa
Elongation		690 %	690 %
Tear	ASTM D624 - Die C	130 PLI	22 kN/m
Tensile	ASTM D412 - Die C	820 PSI	5653 kPa
Flow Direction			
@ 100 %	ASTM D412 - Die C	250 PSI	1723 kPa
@ 300 %		480 PSI	3309 kPa
Elongation		500 %	500 %
Tear	ASTM D624 - Die C	130 PLI	22 kN/m
Tensile	ASTM D412 - Die C	640 PSI	4412 kPa

Temperatures	English	Metric
Injection Molding	Suggested Initial Setup Conditions	
1st Zone - Rear	320 - 350 °F	160 - 176°C
2nd Zone - Center	350 - 370 °F	176 - 187°C
3rd Zone - Front	370 - 420 °F	187 - 215°C
4th Zone - Nozzle	370 - 440 °F	187 - 226°C
Mold Temperature	60 - 80 °F	15 - 26°C



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Pressure, Velocity, Recovery, Timers	English	Metric
Pressure		Suggested Initial Setup Conditions
1st Stage - Boost	350 - 750 PSI	2412 - 5170 kPa
2nd Stage - Hold	50-70% of Boost	50-70% of Boost
Back Pressure	0 - 150 PSI	0 - 1034 kPa
Velocity		
Injection Velocity	1 - 5 in/sec	25 - 126 mm/sec
Recovery		
Screw Speed	40 - 100 RPM	40 - 100 RPM
Timers		
Hold Time (Thick Part)	4 - 10 sec	4 - 10 sec
Hold Time (Thin Part)	1 - 3 sec	1 - 3 sec

Drying

The DYNAFLEX® G7950-9001-02 is dry when packaged and does not readily absorb moisture. Under normal conditions drying is not necessary.

Purging

The DYNAFLEX® G7950-9001-02 has excellent melt stability. Empty the barrel for idle periods of thirty (30) minutes or longer. Purge thoroughly before and after use of this product with a low flow (0.5-2.5 MFR) polyethylene (PE) or polypropylene (PP).

Regrind

The DYNAFLEX® G7950-9001-02 can use regrind up to 20% with minimal property losses, provided that the regrind is free of contamination. To minimize losses during molding, the melt temperature should remain as low as possible. The final determination of regrind effectiveness should be determined by the customer.

Note: All ASTM methods referenced above are GLS versions of the ASTM test method shown.

Note: No warranties, expressed or implied, including patent warranties, or warranties of merchantability or fitness for use, are made with respect to the product information described above. The properties given in this technical datasheet are typical properties, and as such are dependent on processing conditions. An "X" denotes a Preliminary product which is subject to minor changes.

The data summarized in this datasheet is current as of 5/9/2003, however, other revisions may exist. Please contact your sales representative for updated information.

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