

## Technical Data Sheet

### *DuraGrip* DGR-6160NCNAT



Thermoplastic Elastomer

#### Product Description

*DuraGrip* DGR 6160 is offered in an NC (colorable) version, and is designed to chemically bond to a wide variety of thermoplastic substrates including ABS, PC, Nylon 6, Nylon 6/6, glass filled Nylon, ASA, PC/ABS alloys, PBT, and PC/PBT alloys. It is easy to use in injection molding and extrusion processes. DGR 6160NC has excellent elastomeric properties and soft touch feel. *DuraGrip* bonding grades are hygroscopic, and for best results drying is recommended prior to use.

**Processing Method** Extrusion; Injection Molding

**Attribute** Good Adhesion

**Forms** Pellets

| Typical Properties                               | Nominal Value | Units             | Test Method |
|--------------------------------------------------|---------------|-------------------|-------------|
| <b>Physical</b>                                  |               |                   |             |
| Density                                          | 1.09          | g/cm <sup>3</sup> | ISO 1183    |
| Density - Specific Gravity                       | 1.09          | g/cm <sup>3</sup> | ASTM D792   |
| Melt Viscosity, (190 °C, 200 sec <sup>-1</sup> ) | 354           | Pa·s              | ASTM D3835  |
| <b>Mechanical</b>                                |               |                   |             |
| Tensile Stress at 100%                           | 2.3           | MPa               | ISO 37      |
| Tensile Strength at Yield                        | 14.2          | MPa               | ASTM D412   |
| Tensile Stress at Yield                          | 14.2          | MPa               | ISO 37      |
| Tensile Strain at Break                          | 550           | %                 | ISO 37      |
| Tensile Elongation at Break                      | 550           | %                 | ASTM D412   |
| <b>Hardness</b>                                  |               |                   |             |
| Shore Hardness, (Shore A, 5 sec)                 | 65            |                   | ISO 868     |
| Durometer Hardness, (Shore A, 5 sec)             | 65            |                   | ASTM D2240  |

| Injection Parameters   | Nominal Value | Units |
|------------------------|---------------|-------|
| Nozzle Temperature     | 227 to 249    | °C    |
| Screw Speed            | 50 to 150     | rpm   |
| Processing (Melt) Temp | 227 to 254    | °C    |
| Front Temperature      | 227 to 238    | °C    |
| Middle Temperature     | 216 to 227    | °C    |
| Rear Temperature       | 204 to 221    | °C    |
| Mold Temperature       | 43 to 54      | °C    |
| Injection Pressure     | 2.76 to 5.52  | MPa   |