Technical Data Sheet

Duragrip DGR 6150BK

Thermoplastic Elastomer
LyondellBasell Industries
Engineering Plastics

Product Description

DuraGrip® 6150BK is designed to be a special purpose Melt Processible Elastomer (MPE) that is easy to use in injection molding and extrusion processes. DGR 6150BK has an excellent soft touch feel and will Bond to Nylon, ABS, PC, PC/ABS. DuraGrip® 6100 series is hygroscopic and requires drying prior to use.

General

Features	• Good Adhesion	
Agency Ratings	• EU 2002/96/EC (WEEE)	
RoHS Compliance	• RoHS Compliant	
Forms	• Pellets	
Processing Method	• Extrusion	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity			
--	1.06	1.06 g/cm³	ASTM D792
--	1.06 g/cm³	1.06 g/cm³	ISO 1183
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Taber Abrasion Resistance			ASTM D1044
1000 Cycles, 1.0e+6 G, Cs-17 Wheel	144 mg	144 mg	
Elastomers	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Set (100% Strain)	3 %	3 %	ASTM D412
Tensile Stress			
100% Strain	260 psi	1.79 MPa	ASTM D412
100% Strain, 73°f (23°c)	260 psi	1.79 MPa	ISO 37
Tensile Strength (Yield, 73°f (23°c))	850 psi	5.86 MPa	ASTM D412 ISO 37
Tensile Elongation			
Break	360 %	360 %	ASTM D412
Break, 73°f (23°c)	360 %	360 %	ISO 37
Tear Strength [1] (75°f (24°c))	146 lbf/in	25.6 kN/m	ASTM D624
Compression Set			ASTM D395B ISO 815
75°f (24°c), 22 Hr	19 %	19 %	
158°f (70°c), 22 Hr	76 %	76 %	
212°f (100°c), 22 Hr	87 %	87 %	
Hardness	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 5 Sec)	52	52	ASTM D2240 ISO 868
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Brittleness Temperature	-90.0 °F	-67.8 °C	ASTM D746 ISO 812

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Aging	Nominal Value (English)	Nominal Value (SI)	Test Method
Change in Tensile Strength in Air			
158°f (70°c), 168 Hr	17 %	17 %	ASTM D573 ISO 188
100% Strain, 158°f (70°c), 168 Hr	1.0 %	1.0 %	ASTM D573
212°f (100°c), 168 Hr	47 %	47 %	ASTM D573 ISO 188
100% Strain, 212°f (100°c), 168 Hr	-5.0 %	-5.0 %	ASTM D573
100% Strain 158°f (70°c), 168 Hr	1.0 %	1.0 %	ISO 188
100% Strain 212°f (100°c), 168 Hr	-5.0 %	-5.0 %	ISO 188
Change in Ultimate Elongation in Air			ASTM D573
158°f (70°c), 168 Hr	6.0 %	6.0 %	
212°f (100°c), 168 Hr	16 %	16 %	
Change in Tensile Strain at Break			ISO 1817
158°f (70°c), 168 Hr	6.0 %	6.0 %	
212°f (100°c), 168 Hr	16 %	16 %	
Change in Volume			ASTM D471 ISO 1817
75°f (24°c), 168 Hr, In Reference Fuel B	47 %	47 %	
158°f (70°c), 168 Hr, In Astm #1 Oil	16 %	16 %	
158°f (70°c), 168 Hr, In Irm 903 Oil	95 %	95 %	
158°f (70°c), 168 Hr, In Water	1.0 %	1.0 %	
Fill Analysis	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Melt Viscosity (374°f (190°c), 300 Sec^-1)	327 Pa·s	327 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.

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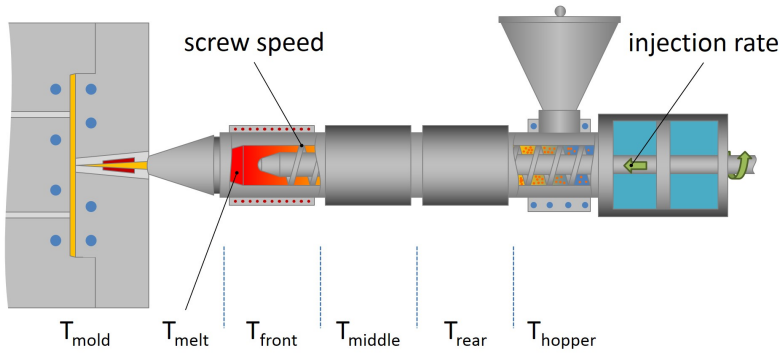

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	150 °F	66 °C
Drying Time	3.0 hr	3.0 hr
Rear Temperature	400 to 430 °F	204 to 221 °C
Middle Temperature	420 to 440 °F	216 to 227 °C
Front Temperature	440 to 460 °F	227 to 238 °C
Nozzle Temperature	440 to 480 °F	227 to 249 °C
Processing (Melt) Temp	440 to 490 °F	227 to 254 °C
Mold Temperature	110 to 130 °F	43 to 54 °C
Injection Pressure	400 to 800 psi	2.76 to 5.52 MPa
Screw Speed	50 to 150 rpm	50 to 150 rpm

Injection Notes

DuraGrip® is not hygroscopic, under normal conditions does not require drying. Dry in a desiccant dryer if porosity is observed.
Injection Speed: 1 to 3 in³/sec
Injection Time (1st Stage/Boost): 0.5 to 4 sec
Second Stage Pressure: 300 to 500 psi
Second Stage Time: 3 to 10 sec
Cooling Time: 10 to 25 sec
Back Pressure: 25 to 75 %