

Duragrip DGR 6160BK

Thermoplastic Elastomer

LyondellBasell Industries

Engineering Plastics

Product Description

DuraGrip® 6160BK is designed to be a special purpose Melt Processible Elastomer (MPE) that is easy to use in injection molding and extrusion processes. DGR 6160BK 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			
--	1.07	1.07 g/cm ³	ASTM D792
--	1.07 g/cm ³	1.07 g/cm ³	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	189 mg	189 mg	
Elastomers	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Set (100% Strain)	4 %	4 %	ASTM D412
Tensile Stress			
100% Strain	320 psi	2.21 MPa	ASTM D412
100% Strain, 73°F (23°C)	320 psi	2.21 MPa	ISO 37
Tensile Strength (Yield, 73°F (23°C))	960 psi	6.62 MPa	ASTM D412 ISO 37
Tensile Elongation			
Break	350 %	350 %	ASTM D412
Break, 73°F (23°C)	350 %	350 %	ISO 37
Tear Strength ¹ (75°F (24°C))	168 lbf/in	29.4 kN/m	ASTM D624
Compression Set			ASTM D395B ISO 815
75°F (24°C), 22 Hr	21 %	21 %	
158°F (70°C), 22 Hr	82 %	82 %	
212°F (100°C), 22 Hr	91 %	91 %	
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Durometer Hardness (Shore A, 5 Sec)	58	58	ASTM D2240 ISO 868
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Brittleness Temperature	-85.0 °F	-65.0 °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	11 %	11 %	ASTM D573 ISO 188
100% Strain, 158°F (70°C), 168 Hr	2.0 %	2.0 %	ASTM D573
212°F (100°C), 168 Hr	40 %	40 %	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	2.0 %	2.0 %	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	4.0 %	4.0 %	
212°F (100°C), 168 Hr	18 %	18 %	
Change in Tensile Strain at Break			ISO 1817
158°F (70°C), 168 Hr	4.0 %	4.0 %	
212°F (100°C), 168 Hr	18 %	18 %	
Change in Volume			ASTM D471 ISO 1817
75°F (24°C), 168 Hr, In Reference Fuel B	52 %	52 %	
158°F (70°C), 168 Hr, In Astm #1 Oil	12 %	12 %	
158°F (70°C), 168 Hr, In Irm 903 Oil	74 %	74 %	
158°F (70°C), 168 Hr, In Water	2.0 %	2.0 %	
Fill Analysis	Nominal Value (English)	Nominal Value (SI)	Test Method
Melt Viscosity (374°F (190°C), 300 Sec ⁻¹)	354 Pa·s	354 Pa·s	ASTM D3835

Additional Information

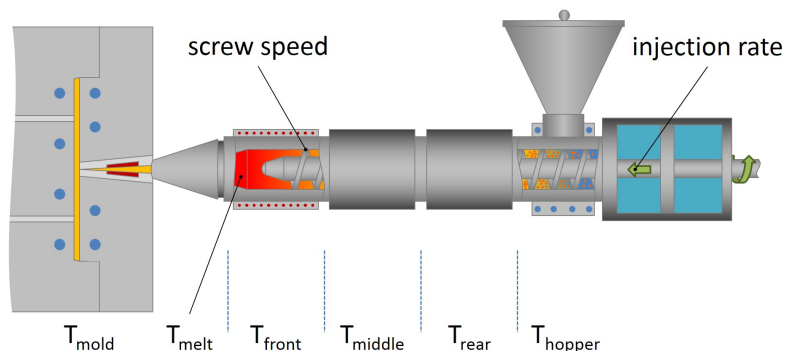
The value listed as Density -Specific Gravity, ASTM D792, was tested in accordance with ASTM D471.

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 %

