



Dynaflex® G2701-1000-02

GLS Corp., Thermoplastic Elastomers Div. - Thermoplastic Elastomer

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General Information

Product Description

Dynaflex® G2701-1000-02 is an easy processing TPE designed for injection molding and extrusion applications that require FDA compliance.

*Made with Kraton® Polymer

General

Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • North America	• South America
Features	• Good Adhesion • Good Colorability • Good Processability	• Good UV Resistance • High Flow • Ozone Resistant	• Soft
Uses	• Thin-walled Parts		
Agency Ratings	• FDA Unspecified Rating		
Appearance	• Translucent		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM and ISO Properties ¹

Physical	Typical Value Unit	Test Method
Specific Gravity	0.900	ASTM D792
Melt Mass-Flow Rate (MFR)		ASTM D1238
190°C/2.16 kg	13 g/10 min	
200°C/5.0 kg	61 g/10 min	
Molding Shrinkage (Flow)	0.0050 to 0.011 in/in	ASTM D955
Elastomers	Typical Value Unit	Test Method
Tensile Stress ² (100% Strain, 73.4 °F)	490 psi	ASTM D412
Tensile Stress ² (300% Strain, 73.4 °F)	670 psi	ASTM D412
Tensile Strength ² (Break, 73 °F)	1050 psi	ASTM D412
Tensile Elongation ² (Break, 73.4 °F)	590 %	ASTM D412
Tear Strength	240 lbf/in	ASTM D624
Compression Set ³ (22.0 hr)	24 %	ASTM D395
Hardness	Typical Value Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	66	ASTM D2240
Fill Analysis	Typical Value Unit	Test Method
Apparent Viscosity (392 °F, 11200 sec ⁻¹)	11.0 Pa·s	ASTM D3835

Processing Information

Injection	Typical Value Unit
Suggested Max Regrind	20 %
Rear Temperature	270 to 340 °F
Middle Temperature	310 to 380 °F
Front Temperature	335 to 405 °F
Nozzle Temperature	335 to 405 °F
Mold Temperature	60.0 to 80.0 °F
Injection Pressure	250 to 650 psi
Back Pressure	50.0 to 150 psi

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Injection

Typical Value Unit

Screw Speed	25 to 75 rpm
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Injection Notes

Holding Pressure: 70% of Boost
 Injection Velocity: 1 to 5 in/sec
 Hold Time (Thick Part): 4 to 10 sec
 Hold Time (Thin Part): 1 to 3 sec

Notes

¹ Typical properties: these are not to be construed as specifications.

² Die C

³ Method B