Versaflex™ G2800-17

Thermoplastic Elastomer

Key Characteristics

Product Description			
Versaflex G2800-17 is a TPE gel material for use where ultra-soft properties and dry surface feel are desired.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Latin America • North America	
Features	• Soft		
Uses	• Artificial Skin • Consumer Applications	• Footwear • Personal Care	• Toys
RoHS Compliance	• RoHS Compliant		
Appearance	• Beige	• Natural Color	• Pink
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.850	0.850	ASTM D792
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Strength [2, 3] (Break, 73°F (23°C))	90.0 psi	0.621 MPa	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F (23°C))	1300 %	1300 %	ASTM D412
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness			ASTM D2240
Shore OO, 10 sec, 73°F (23°C)	18	18	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	230 to 260 °F	110 to 127 °C
Middle Temperature	270 to 300 °F	132 to 149 °C
Front Temperature	280 to 320 °F	138 to 160 °C
Nozzle Temperature	290 to 340 °F	143 to 171 °C
Processing (Melt) Temp	290 to 340 °F	143 to 171 °C
Mold Temperature	55 to 90 °F	13 to 32 °C
Back Pressure	0.00 to 50.0 psi	0.00 to 0.345 MPa
Screw Speed	25 to 110 rpm	25 to 110 rpm

Injection Notes

A shutoff nozzle should be used with this product to ensure proper screw recovery.

Regrind levels up to 20% can be used with Versaflex G2800-17 with minimal property loss, 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.

Versaflex G2800-17 has good melt stability. Maximum residence times may vary, depending on the size of the barrel. Generally, the barrel should be emptied if it is idle for periods of 5 - 8 minutes or longer.

Drying is not Required

Injection Speed: 0.5 to 2 in/sec
1st Stage - Boost Pressure: 80 to 300 psi
2nd Stage - Hold Pressure: 30% of Boost
Hold Time (Thick Part): 3 to 10 sec
Hold Time (Thin Part): 1 to 3 sec

Notes

[1] Typical values are not to be construed as specifications.

[2] Die C

[3] 2 hr

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