Dynaflex™ G2755-1000-00

Thermoplastic Elastomer

Key Characteristics

Product Description

Dynaflex™ G2755-1000-00 is an easy processing TPE designed for injection molding and extrusion applications that require FDA compliance.

- Overmold Adhesion to Polypropylene
- Rubbery Feel
- Soft Touch

General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Latin America • North America	
Features	• Ozone Resistant	• Recyclable Material	• UV Resistant
Uses	• Consumer Applications • Flexible Grips • General Purpose	• Overmolding • Personal Care • Soft Touch Applications	• Transparent or Translucent Parts
Agency Ratings	• EU 10/2011 [1]	• FDA 21 CFR 177.1210 [2]	
RoHS Compliance	• RoHS Compliant		
Appearance	• Translucent		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

Technical Properties [3]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.880	0.880	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	3.0 g/10 min	3.0 g/10 min	
200°C/5.0 kg	42 g/10 min	42 g/10 min	
Molding Shrinkage - Flow	9.0E-3 to 0.016 in/in	0.90 to 1.6 %	ASTM D955
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [4, 5] (100% Strain, 73°F (23°C))	220 psi	1.52 MPa	ASTM D412
Tensile Stress [4, 5] (300% Strain, 73°F (23°C))	330 psi	2.28 MPa	ASTM D412
Tensile Strength [4, 5] (Break, 73°F (23°C))	775 psi	5.34 MPa	ASTM D412
Tensile Elongation [4, 5] (Break, 73°F (23°C))	740 %	740 %	ASTM D412
Tear Strength	140 lbf/in	24.5 kN/m	ASTM D624
Compression Set (73°F (23°C), 22 hr)	17 %	17 %	ASTM D395B
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	55	55	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	7.00 Pa·s	7.00 Pa·s	

Additional Information

Dynaflex™ G2755-1000-00 can be recycled as a filler or impact modifier for polyolefins, or can be recycled by grinding and reintroduction to the molding process. Similar to PP or PE recycling process, if separated appropriately, it can be recycled many times.

Municipality waste stream recycle code is "7" which is designated for "Other".

Please contact GLS Thermoplastic Elastomers for a copy of our Recyclability Compliance letter.

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	330 to 350 °F	166 to 177 °C
Middle Temperature	350 to 370 °F	177 to 188 °C
Front Temperature	370 to 440 °F	188 to 227 °C
Nozzle Temperature	370 to 440 °F	188 to 227 °C
Mold Temperature	60 to 100 °F	16 to 38 °C
Back Pressure	50.0 to 150 psi	0.345 to 1.03 MPa
Screw Speed	25 to 75 rpm	25 to 75 rpm

Injection Notes

Color concentrates with polypropylene (PP), ethylene vinyl acetate (EVA), or low density polyethylene (PE) carriers are most suitable for coloring Dynaflex™ G2755-1000-00. Improved color dispersion can be achieved by using higher melt flow concentrates (with a melt flow of 25 - 40 g/10 min). Typical loadings for color concentrates are 1% to 5% by weight. Liquid color can be used, but mineral oil based carriers may have a significant effect on the final hardness value. Concentrates based on PVC should not be used. A high color match consistency can be obtained by using precolored compounds available from GLS. The final determination of color concentrate suitability should be determined by customer trials.

Purge thoroughly before and after use of this product with a low flow (0.5 - 2.5 MFR) polyethylene (PE) or polypropylene (PP).

Regrind levels up to 20% can be used with Dynaflex™ G2755-1000-00 with minimal property loss, provided that the regrind is free of contamination. To minimize losses during molding, the melt tempetature should remain as low as possible. The final determination of regrind effectiveness should be determined by the customer.

Dynaflex™ G2755-1000-00 has excellent 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 8 - 10 minutes or longer.

Drying is not Required

Injection Speed: 1 to 5 in/sec
1st Stage - Boost Pressure: 150 to 550 psi
2nd Stage - Hold Pressure: 50% of Boost
Hold Time (Thick Part): 4 to 10 sec
Hold Time (Thin Part): 1 to 3 sec

Notes

[1] Please contact GLS Thermoplastic Elastomers for the specific EU compliance letter on this product.

[2] Please contact GLS Thermoplastic Elastomers for the specific FDA compliance letter on this product.

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

[4] Die C

[5] 2 hr