



# Dynalloy™ GP 7510-80N

## Thermoplastic Elastomer

### Key Characteristics

#### Product Description

Dynalloy™ GP 7510-80N is an easy processing, general purpose TPE designed for a wide variety of applications, including those where FDA compliance is required.

- Overmold Adhesion to Polypropylene

#### General

Material Status	• Commercial: Active
Regional Availability	• North America
Features	<ul style="list-style-type: none"> <li>• General Purpose</li> <li>• Good Colorability</li> <li>• Good Flow</li> <li>• Good Processability</li> <li>• Good Processing Stability</li> <li>• Recyclable Material</li> </ul>
Uses	<ul style="list-style-type: none"> <li>• Consumer Applications</li> <li>• Flexible Grips</li> <li>• General Purpose</li> <li>• Household Goods</li> <li>• Industrial Applications</li> <li>• Overmolding</li> <li>• Soft Touch Applications</li> <li>• Sporting Goods</li> </ul>
Agency Ratings	• FDA 21 CFR 177.2600 <sup>1</sup>
RoHS Compliance	• RoHS Compliant
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

### Technical Properties<sup>2</sup>

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.15	1.15	ASTM D792
Molding Shrinkage - Flow	0.020 to 0.026 in/in	2.0 to 2.6 %	ASTM D955
Elastomers	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength <sup>3, 4</sup> (Break, 73°F (23°C))	797 psi	5.50 MPa	ASTM D412
Tensile Elongation <sup>3, 4</sup> (Break, 73°F (23°C))	540 %	540 %	ASTM D412
Hardness	Typical Value (English)	Typical Value (SI)	Test Method
Durometer Hardness (Shore A, 10 sec)	79	79	ASTM D2240
Fill Analysis	Typical Value (English)	Typical Value (SI)	Test Method
Apparent Viscosity 392°F (200°C), 11200 sec <sup>-1</sup>	7.10 Pa·s	7.10 Pa·s	ASTM D3835

#### Additional Information

Dynalloy™ GP 7510-80N 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 370 °F	166 to 188 °C
Middle Temperature	350 to 370 °F	177 to 188 °C
Front Temperature	370 to 420 °F	188 to 216 °C

Injection	Typical Value (English)	Typical Value (SI)
Nozzle Temperature	370 to 440 °F	188 to 227 °C
Mold Temperature	60 to 100 °F	16 to 38 °C
Back Pressure	0.00 to 120 psi	0.00 to 0.827 MPa
Screw Speed	40 to 100 rpm	40 to 100 rpm

**Injection Notes**

Color concentrates with polypropylene (PP), ethylene vinyl acetate (EVA), or low density polyethylene (PE) carriers are most suitable for coloring Dynalloy™ GP 7510-80N. Improved color dispersion can be achieved by using higher melt flow concentrates (with a melt flow from 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 Dynalloy™ GP 7510-80N 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.

Dynalloy™ GP 7510-80N 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 3 in/sec  
 1st Stage - Boost Pressure: 200 to 900 psi  
 2nd Stage - Hold Pressure: 50% of Boost  
 Hold Time (Thick Part): 3 to 10 sec  
 Hold Time (Thin Part): 1 to 3 sec

**Notes**

<sup>1</sup> Please contact GLS Thermoplastic Elastomers for a copy of the FDA compliance letter.

<sup>2</sup> Typical values are not to be construed as specifications.

<sup>3</sup> Die C

<sup>4</sup> 2 hr



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