



## OnFlex™ G7705 B

### Thermoplastic Elastomer

#### Key Characteristics

##### Product Description

OnFlex™ G7705 B is an easy processing, general purpose material designed for a wide variety of applications.

##### General

Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

#### Technical Properties <sup>1</sup>

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.20	1.20	ASTM D792
Hardness	Typical Value (English)	Typical Value (SI)	Test Method
Durometer Hardness <sup>2</sup>			ASTM D2240
Shore A, 10 sec, 73°F (23°C)	42	42	
Fill Analysis	Typical Value (English)	Typical Value (SI)	Test Method
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec <sup>-1</sup>	9.20 Pa·s	9.20 Pa·s	

#### Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Rear Temperature	340 to 390 °F	171 to 199 °C
Middle Temperature	360 to 420 °F	182 to 216 °C
Front Temperature	360 to 420 °F	182 to 216 °C
Nozzle Temperature	380 to 440 °F	193 to 227 °C
Mold Temperature	80 to 120 °F	27 to 49 °C
Injection Rate	Moderate-Fast	Moderate-Fast
Back Pressure	100 to 200 psi	0.689 to 1.38 MPa
Screw Speed	25 to 100 rpm	25 to 100 rpm

**Injection Notes**

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 OnFlex™ G7705 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.

OnFlex™ G7705 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: 350 to 900 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**

<sup>1</sup> Typical values are not to be construed as specifications.

<sup>2</sup> 2 hr

The logo for PolyOne, featuring the word "PolyOne" in a stylized, italicized serif font with a horizontal line underneath.

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