Dynaflex™ G2711-1000-00

Thermoplastic Elastomer

Key Characteristics

Product Description

Dynaflex™ G2711-1000-00 is an easy process compound designed for injection molding and extrusion applications that require FDA compliance.

- Excellent Colorability
- Good Ozone and UV Stability
- Overmold Adhesion to Polypropylene
- Rubbery Feel
- Soft Touch

General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • North America	• South America
Features	• Good Colorability	• Good UV Resistance	• Ozone Resistant
Uses	• Consumer Applications • Medical/Healthcare Applications	• Overmolding • Personal Care	• Soft Touch Applications
Agency Ratings	• EU 2002/72/EC [1] • FDA 21 CFR 177.1210 [2]	• ISO 10993 Part 4 • ISO 10993 Part 5	• USP Class VI
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
Specific Gravity	0.890	0.888 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	4.0 g/10 min	4.0 g/10 min	
200°C/5.0 kg	24 g/10 min	24 g/10 min	
Molding Shrinkage - Flow	0.014 to 0.021 in/in	1.4 to 2.1 %	ASTM D955
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [4, 5] (100% Strain, 73°F (23°C))	180 psi	1.24 MPa	ASTM D412
Tensile Stress [4, 5] (300% Strain, 73°F (23°C))	360 psi	2.48 MPa	ASTM D412
Tensile Strength [4, 5] (Break, 73°F (23°C))	830 psi	5.72 MPa	ASTM D412
Tensile Elongation [4, 5] (Break, 73°F (23°C))	650 %	650 %	ASTM D412
Tear Strength	130 lbf/in	22.8 kN/m	ASTM D624
Compression Set (73°F (23°C), 22.0 hr)	14 %	14 %	ASTM D395B
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	43	43	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	12.4 Pa·s	12.4 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	300 to 370 °F	149 to 188 °C
Middle Temperature	360 to 380 °F	182 to 193 °C
Front Temperature	370 to 440 °F	188 to 227 °C
Nozzle Temperature	370 to 440 °F	188 to 227 °C
Mold Temperature	60.0 to 100 °F	15.6 to 37.8 °C
Back Pressure	0.00 to 120 psi	0.00 to 0.827 MPa
Screw Speed	25 to 75 rpm	25 to 75 rpm

Injection Notes

Color concentrates with polypropylene (PP), ethylene vinyl acetate (EVA), or polyethylene (PE) carrier are most suitable for coloring Dynaflex™ G2711-1000-00. 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 Dynaflex™ G2711-1000-00 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.

Dynaflex™ G2711-1000-00 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: 400 to 1000 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] Please contact GLS Thermoplastic Elastomers for a copy of the EU compliance letter.

[2] Please contact GLS Thermoplastic Elastomers for a copy of the FDA compliance letter.

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

[4] Die C

[5] 2 hr

PolyOne Americas
33587 Walker Road
Avon Lake, Ohio 44012
United States
+1 440 930 1000
+1 866 POLYONE

PolyOne Asia
No. 88 Guoshoujing Road
Z.J Hi-tech Park, Pudong
Shanghai, 201203, China
+86 (0) 21 5080 1188

PolyOne Europe
6 Giällewee
Please Call Assesse
Belgium Phone Number +32
(0) 83 660 211