

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
- 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 | • Good Colorability • Ozone Resistant | • Recyclable Material • UV Resistant | |
| Uses | • Consumer Applications • Medical/Healthcare Applications | • Overmolding • Personal Care | • Soft Touch Applications |
| Agency Ratings | • EU 10/2011 ¹ • FDA 21 CFR 177.1210 ² | • ISO 10993 Part 4 • ISO 10993 Part 5 | • USP Class VI ³ |
| RoHS Compliance | • RoHS Compliant | | |
| Appearance | • Translucent | | |
| Forms | • Pellets | | |
| Processing Method | • Extrusion | • Injection Molding | |

Technical Properties⁴

| Physical | Typical Value (English) | Typical Value (SI) | Test Method |
|---|-------------------------|--------------------|-------------|
| Density / Specific Gravity | 0.890 | 0.890 | 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 ^{5,6} (100% Strain, 73°F (23°C)) | 180 psi | 1.24 MPa | ASTM D412 |
| Tensile Stress ^{5,6} (300% Strain, 73°F (23°C)) | 370 psi | 2.55 MPa | ASTM D412 |
| Tensile Strength ^{5,6} (Break, 73°F (23°C)) | 778 psi | 5.36 MPa | ASTM D412 |
| Tensile Elongation ^{5,6} (Break, 73°F (23°C)) | 640 % | 640 % | ASTM D412 |
| Tear Strength | 130 lbf/in | 22.8 kN/m | ASTM D624 |
| Compression Set (73°F (23°C), 22 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 | |

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Additional Information

Dynaflex™ G2711-1000-00 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 | 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 to 100 °F | 16 to 38 °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 Please contact PolyOne GLS Thermoplastic Elastomers for a complete copy of the GLS Healthcare Policy.
 1. The Customer must notify GLS of any FDA Class I and/or European Union Class I medical devices for each specific product and application.
 2. The Customer shall not knowingly manufacture, use, sell or otherwise supply, directly or indirectly products or compounds made from GLS products in any of the following without prior written approval by GLS for each specific product or application:
 - a. Cosmetics
 - b. Drugs and other Pharmaceuticals
 - c. Temporary or permanent implantation in the human body, regardless of the intended duration of implantation
 - d. Class II and Class III Medical Devices as defined in 21 CFR 860.3 ("Medical Devices")
 - e. Class IIa, IIb and III as defined in Directive 93/42/EEC
- ⁴ Typical values are not to be construed as specifications.
- ⁵ Die C
- ⁶ 2 hr

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CONTACT INFORMATION

North America

Avon Lake, United States
33587 Walker Road
Avon Lake, OH, United States ,
44012
+1 440 930 1000
+1 844 4AVIENT

South America

Sao Paulo, Brazil
Av. Francisco Nakasato, 1700
13295-000 Itupeva
Sao Paulo, Brazil
+55 11 4593 9200

Asia

Shanghai, China
2F, Block C
200 Jinsu Road
Pudong, 201206
Shanghai, China
+86 (0) 21 6028 4888

Europe

Pommerloch, Luxembourg
19 Route de Bastogne
Pommerloch, Luxembourg , L-9638
+352 269 050 35



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