

# Gallonprene® GP420-8502

Thermoplastic Elastomer

Shenzhen Sungallon Rubber & Plastic Corporation Limited

Message:

Gallonprene® GP420-8502 is a thermoplastic elastomer (TPE) product. It can be processed by injection molding and is available in Africa and the Middle East, Latin America or Asia Pacific. Gallonprene® GP420-8502 application areas include engineering/industrial accessories, consumer goods and handles. Features include:  
Comply with REACH standard  
ROHS certification  
high gloss  
Halogen-free

| General Information                       |                      |                   |             |
|---|----------------------|-------------------|-------------|
| Features                                  | Highlight            |                   |             |
|   | Sprayable            |                   |             |
|   | Halogen-free         |                   |             |
| Uses                                      | overmolding          |                   |             |
|   | Soft handle          |                   |             |
|   | Toys                 |                   |             |
| Agency Ratings                            | EC 1907/2006 (REACH) |                   |             |
| RoHS Compliance                           | RoHS compliance      |                   |             |
| Appearance                                | White                |                   |             |
| Processing Method                         | Injection molding    |                   |             |
| Physical                                  | Nominal Value        | Unit              | Test Method |
| Specific Gravity                          | 1.10                 | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (200°C/2.16 kg) | 16                   | g/10 min          | ASTM D1238  |
| Hardness                                  | Nominal Value        | Unit              | Test Method |
| Durometer Hardness (Shore A, 23°C)        | 85                   |                   | ASTM D2240  |
| Elastomers                                | Nominal Value        | Unit              | Test Method |
| Tensile Strength <sup>1</sup> (Break)     | 5.80                 | MPa               | ASTM D412   |
| Tensile Elongation <sup>2</sup> (Break)   | 380                  | %                 | ASTM D412   |
| Injection                                 | Nominal Value        | Unit              |             |
| Rear Temperature                          | 140 - 160            | °C                |             |
| Middle Temperature                        | 150 - 170            | °C                |             |
| Front Temperature                         | 160 - 180            | °C                |             |
| Processing (Melt) Temp                    | 120 - 140            | °C                |             |
| Mold Temperature                          | 30.0 - 60.0          | °C                |             |
| Injection Rate                            | Moderate             |                   |             |
| Injection instructions                    |                      |                   |             |

Processing Temperature Limit: 220°CInjection Pressure: ModerateBack Pressure: 20 to 50%Overmolding Parameters:Rear Temperature: 155 to 175°CCenter Temperature: 165 to 185°CFront Temperature: 175 to 195°CMelt Temperature: 120 to 140°C Mold Temperature: 30 to 60°CProcessing Temperature Limit: 220°CInjection Pressure: ModerateInjection Speed: ModerateBack Pressure: 20 to 50%

| NOTE |            |
|------|------------|
| 1.   | 500 mm/min |
| 2.   | 500 mm/min |

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