

Dynaflex™ G2780C

Thermoplastic Elastomer

PolyOne Corporation

Message:

Dynaflex™ G2780C is an easy-to-process thermoplastic elastomer material designed for injection and extrusion molding and meeting FDA requirements.
excellent coloring performance
Good ozone and UV stability
bonded polypropylene
The elastic feeling of rubber
soft touch

General Information	
Features	Good UV resistance Recyclable materials Good coloring Ozone resistance
Uses	overmolding Blow molding applications Personal care Sheet Transparent or Translucent Accessories Consumer goods application field
Agency Ratings	FDA 21 CFR 177.2600 2
RoHS Compliance	RoHS compliance
Appearance	Translucent
Forms	Particle
Processing Method	Extrusion Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.898	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	5.0	g/10 min	ASTM D1238
200°C/5.0 kg	16	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.90 - 1.5	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	84		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
100% strain, 23°C ²	5.79	MPa	ASTM D412

300% strain, 23°C ³	7.86	MPa	ASTM D412
Tensile Strength (Break, 23°C)	8.27	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	370	%	ASTM D412
Tear Strength	43.8	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	18	%	ASTM D395B
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 11200 sec ⁻¹)	22.0	Pa·s	ASTM D3835

Additional Information

Dynaflex™ G2780C 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.

Injection	Nominal Value	Unit
Suggested Max Regrind	20	%
Rear Temperature	132 - 171	°C
Middle Temperature	171 - 188	°C
Front Temperature	188 - 207	°C
Nozzle Temperature	188 - 207	°C
Mold Temperature	15.6 - 26.7	°C
Back Pressure	0.00 - 1.03	MPa
Screw Speed	40 - 100	rpm

Injection instructions

以聚丙烯(PP), 乙烯-醋酸乙烯(EVA), 或低密度的聚乙烯为载体的色母粒最适合用于Dynaflex™ G2780C的着色. 高流动性的色母粒(熔融指数在25-40克/10分钟)有助于提高颜色的分散. 典型的色母粒添加重量比例为1%-5%. 也可以使用色油进行着色, 但以矿物油作为载体的色油对产品的最终硬度有显著的影响. 以PVC做载体的色母粒不建议使用. 如需高质量的颜色控制, GLS公司可以提供预着色产品. 色母粒的适用性应由客户根据实际的试生产情况而最终确定. 在使用前和后, 都要用熔融指数在0.5-2.5的聚乙烯(PE)或聚丙烯(PP)进行彻底的清洗. 在回收料没有污染的前提下, 最高可以用20%比例的Dynaflex™ G2780C回收料和新料混和使用, 同时不至于影响材料的特性. 为尽可能降低对材料特性的影响, 加工温度应尽可能的低. 回收料的最终使用效果应由客户实际试生产情况决定. Dynaflex™ G2780C

有优异的熔体稳定性. 最大的停留时间因料筒尺寸差异而不同. 一般在闲置8-10分钟或更长时间后, 料筒内材料应被清空. 不需要干燥. 注射速度:

1~5英寸/秒一段: 注射压力: 100~500 psi二段: 保压压力: 70%注射压力保压时间(厚部件): 4~10秒保压时间(薄部件): 1~3秒

NOTE

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| 1. | 2 hours |
| 2. | Mouth die c |
| 3. | C mould |

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Recommended distributors for this material

Susheng Import & Export Trading Co., Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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