Versaflex™ G2708 N

Thermoplastic Elastomer

Key Characteristics

Product Description			
Versaflex™ G2708 N is an easy processing TPE designed for capliners.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Agency Ratings	• EU 10/2011 [1]	• FDA 21 CFR 177.1210 [2]	• FDA 21 CFR 177.2600 [3]
RoHS Compliance	• RoHS Compliant		
Appearance	• Translucent		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

Technical Properties [4]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.880	0.880	ASTM D792
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness [5]			ASTM D2240
Shore A, 10 sec, 73°F (23°C)	57	57	
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	13.1 Pa·s	13.1 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	70 to 120 °F	21 to 49 °C
Back Pressure	25.0 to 150 psi	0.172 to 1.03 MPa
Screw Speed	25 to 100 rpm	25 to 100 rpm

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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 Versaflex™ G2708 N 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.
Versaflex™ G2708 N 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

Extrusion	Typical Value (English)	Typical Value (SI)
Melt Temperature	375 to 460 °F	191 to 238 °C
Die Temperature	375 to 460 °F	191 to 238 °C

Extrusion Notes
Purge thoroughly before and after use of this product with a low flow (0.5 - 2.5 MFR) polyethylene (PE or polypropylene (PP)
Drying is not required. Screw Speed = 100-700 RPM

Notes

[1] Contact PolyOne for the EU 10/2011 statement.

[2] Contact PolyOne for FDA statement

[3] Contact PolyOne for FDA statement.

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

[5] 2 hr

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