Versaflex™ G2800-17

Thermoplastic Elastomer

Key Characteristics

Product Description			
Versaflex G2800-17 is a TPE gel material for use where ultra-soft properties and dry surface feel are desired.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Latin America • North America	
Features	• Soft		
Uses	• Artificial Skin • Consumer Applications	• Footwear • Personal Care	• Toys
RoHS Compliance	• RoHS Compliant		
Appearance	• Pink	• Translucent	
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.850	0.850	ASTM D792
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress (100% Strain)	5.80 psi	0.0400 MPa	ASTM D412
Tensile Stress (300% Strain)	11.4 psi	0.0786 MPa	ASTM D412
Tensile Strength [2, 3] (Break, 73°F (23°C))	166 psi	1.14 MPa	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F (23°C))	1300 %	1300 %	ASTM D412
Tear Strength	46.0 lbf/in	8.06 kN/m	ASTM D624
Compression Set			ASTM D395
73°F (23°C)	15 %	15 %	
158°F (70°C)	100 %	100 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness			ASTM D2240
Shore OO, 10 sec, 73°F (23°C)	18	18	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	230 to 260 °F	110 to 127 °C
Middle Temperature	240 to 290 °F	116 to 143 °C
Front Temperature	250 to 300 °F	121 to 149 °C
Nozzle Temperature	260 to 310 °F	127 to 154 °C
Processing (Melt) Temp	260 to 310 °F	127 to 154 °C
Mold Temperature	70 to 120 °F	21 to 49 °C
Back Pressure	0.00 to 50.0 psi	0.00 to 0.345 MPa
Screw Speed	25 to 110 rpm	25 to 110 rpm

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Injection Notes

A shutoff nozzle should be used with this product to ensure proper screw recovery.

Regrind levels up to 20% can be used with Versaflex G2800-17 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 G2800-17 has good 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 5 - 8 minutes or longer.

Drying is not Required

Injection Speed: 0.25 to 2 in/sec
Hold Pressure: 30-50% of peak injection pressure
Hold Time (Thick Part): 3 to 10 sec
Hold Time (Thin Part): 1 to 3 sec

Notes

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

[2] Die C

[3] 2 hr

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