Versaflex™ GP 3630-75B

Thermoplastic Elastomer

Key Characteristics

Product Description			
Versaflex GP 3630-75B is an easy processing, general purpose TPE designed for a wide variety of applications. • Overmold adhesion to PC, ABS, PBT • Soft touch, Rubbery feel			
General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific		
Features	• Good Colorability	• Good Processability	• Low Friction
Uses	• Consumer Applications	• Electrical/Electronic Applications	• Overmolding
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.09	1.09	ASTM D792
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2, 3] (300% Strain, 73°F (23°C))	650 psi	4.48 MPa	ASTM D412
Tensile Strength [2, 3] (Break, 73°F (23°C))	1060 psi	7.31 MPa	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F (23°C))	600 %	600 %	ASTM D412
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	75	75	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	27.0 Pa·s	27.0 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	125 to 140 °F	52 to 60 °C
Drying Time	1.0 to 3.0 hr	1.0 to 3.0 hr
Suggested Max Moisture	0.020 to 0.030 %	0.020 to 0.030 %
Suggested Max Regrind	20 %	20 %
Rear Temperature	340 to 360 °F	171 to 182 °C
Middle Temperature	360 to 430 °F	182 to 221 °C
Front Temperature	370 to 440 °F	188 to 227 °C
Nozzle Temperature	380 to 460 °F	193 to 238 °C
Processing (Melt) Temp	380 to 450 °F	193 to 232 °C
Mold Temperature	55 to 110 °F	13 to 43 °C
Back Pressure	0.00 to 50.0 psi	0.00 to 0.345 MPa
Screw Speed	50 to 100 rpm	50 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).

Notes

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

[2] Die C

[3] 2 hr

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