Versaflex™ GP 3630-75N

Thermoplastic Elastomer

Key Characteristics

Product Description			
Versaflex GP 3630-75N 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	• Natural Color		
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))	700 %	700 %	ASTM D412
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	80	80	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	24.0 Pa·s	24.0 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

Color concentrates with EVA carriers are most suitable for coloring GP 3630-75N. Typical letdown ratios are 50:1 to 25:1 - loading levels should be as low as possible to minimize the effect on adhesion. A high color match consistency can be obtained by the use of precolored compounds available from GLS. Concentrates based on PVC should not be used. The final determination of color concentrate suitability should be determined by customer trials.

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 GP 3630-75N 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.

GP 3630-75N should not be left in the barrel for extended idle periods (greater than 5 minutes).

Suggested Dewpoint: -40°F

Injection Speed: 0.5 to 4 in/sec
1st Stage - Boost Pressure: 500 to 1,000 psi
2nd Stage - Hold Pressure: 20-60% of Boost
Hold Time (Thick Part): 2 to 4 sec
Hold Time (Thin Part): 1 to 2 sec

Notes

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

[2] Die C

[3] 2 hr

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