Dynaflex™ G2711-1000-00

Thermoplastic Elastomer

Key Characteristics

Product Description

Dynaflex™ G2711-1000-00 is an easy process compound designed for injection molding and extrusion applications that require FDA compliance.

- Excellent Colorability
- Overmold Adhesion to Polypropylene
- Rubbery Feel
- Soft Touch

General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Latin America • North America	
Features	• Good Colorability • Ozone Resistant	• Recyclable Material • UV Resistant	
Uses	• Consumer Applications • Medical/Healthcare Applications	• Overmolding • Personal Care	• Soft Touch Applications
Agency Ratings	• EU 10/2011 [1] • FDA 21 CFR 177.1210 [2]	• ISO 10993-4 • ISO 10993-5	• USP Class VI [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	0.890	0.890	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	4.0 g/10 min	4.0 g/10 min	
200°C/5.0 kg	24 g/10 min	24 g/10 min	
Molding Shrinkage - Flow	0.014 to 0.021 in/in	1.4 to 2.1 %	ASTM D955
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [5, 6] (100% Strain, 73°F (23°C))	180 psi	1.24 MPa	ASTM D412
Tensile Stress [5, 6] (300% Strain, 73°F (23°C))	370 psi	2.55 MPa	ASTM D412
Tensile Strength [5, 6] (Break, 73°F (23°C))	778 psi	5.36 MPa	ASTM D412
Tensile Elongation [5, 6] (Break, 73°F (23°C))	640 %	640 %	ASTM D412
Tear Strength	130 lbf/in	22.8 kN/m	ASTM D624
Compression Set (73°F (23°C), 22 hr)	14 %	14 %	ASTM D395B
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	43	43	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	12.4 Pa·s	12.4 Pa·s	

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Additional Information

Dynaflex™ G2711-1000-00 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.

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	300 to 370 °F	149 to 188 °C
Middle Temperature	360 to 380 °F	182 to 193 °C
Front Temperature	370 to 440 °F	188 to 227 °C
Nozzle Temperature	370 to 440 °F	188 to 227 °C
Mold Temperature	60 to 100 °F	16 to 38 °C
Back Pressure	0.00 to 120 psi	0.00 to 0.827 MPa
Screw Speed	25 to 75 rpm	25 to 75 rpm

Injection Notes

Color concentrates with polypropylene (PP), ethylene vinyl acetate (EVA), or polyethylene (PE) carrier are most suitable for coloring Dynaflex™ G2711-1000-00. Improved color dispersion can be achieved by using higher melt flow concentrates (with a melt flow from 25 - 40 g/10 min). Typical loadings for color concentrates are 1% to 5% by weight. Liquid color can be used, but mineral oil based carriers may have a significant effect on the final hardness value. Concentrates based on PVC should not be used. A high color match consistency can be obtained by using precolored compounds available from GLS. 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 Dynaflex™ G2711-1000-00 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.

Dynaflex™ G2711-1000-00 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 5 in/sec
1st Stage - Boost Pressure: 400 to 1000 psi
2nd Stage - Hold Pressure: 30% of Boost
Hold Time (Thick Part): 3 to 10 sec
Hold Time (Thin Part): 1 to 3 sec

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Notes

[1] Please contact GLS Thermoplastic Elastomers for a copy of the EU compliance letter.

[2] Please contact GLS Thermoplastic Elastomers for a copy of the FDA compliance letter.

[3] Please contact PolyOne GLS Thermoplastic Elastomers for a complete copy of the GLS Healthcare Policy.
1. The Customer must notify GLS of any FDA Class I and/or European Union Class I medical devices for each specific product and application.
2. The Customer shall not knowingly manufacture, use, sell or otherwise supply, directly or indirectly products or compounds made from GLS products in any of the following without prior written approval by GLS for each specific product or application:
a. Cosmetics
b. Drugs and other Pharmaceuticals
c. Temporary or permanent implantation in the human body, regardless of the intended duration of implantation
d. Class II and Class III Medical Devices as defined in 21 CFR 860.3 ("Medical Devices")
e. Class IIa, IIb and III as defined in Directive 93/42/EEC

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

[5] Die C

[6] 2 hr

CONTACT INFORMATION

North America
Avon Lake, United States
33587 Walker Road
Avon Lake, OH, United States , 44012
+1 440 930 1000
+1 844 4AVIENT

South America
Sao Paulo, Brazil
Av. Francisco Nakasato, 1700
13295-000 Itupeva
Sao Paulo, Brazil
+55 11 4593 9200

Asia
Shanghai, China
2F, Block C
200 Jinsu Road
Pudong, 201206
Shanghai, China
+86 (0) 21 6028 4888

Europe
Pommerloch, Luxembourg
19 Route de Bastogne
Pommerloch, Luxembourg , L-9638
+352 269 050 35

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