

# Gallonprene® GP520-4004

Thermoplastic Elastomer

Shenzhen Sungallon Rubber & Plastic Corporation Limited

Message:

Gallonprene® GP520-4004 is a thermoplastic elastomer (TPE) product. It can be processed by injection molding and is available in Africa and the Middle East, Latin America or Asia Pacific. Gallonprene® GP520-4004 application areas include engineering/industrial accessories, home applications, consumer goods and handles.

- Features include:
- Comply with REACH standard
  - ROHS certification
  - Halogen-free

| General Information                       |                         |                   |             |
|---|-------------------------|-------------------|-------------|
| Features                                  | High elasticity         |                   |             |
|   | Halogen-free            |                   |             |
| Uses                                      | overmolding             |                   |             |
|   | Household goods         |                   |             |
|   | Soft handle             |                   |             |
|   | Toys                    |                   |             |
| Agency Ratings                            | EC 1907/2006 (REACH)    |                   |             |
| RoHS Compliance                           | RoHS compliance         |                   |             |
| Appearance                                | White                   |                   |             |
|   | Rough surface polishing |                   |             |
| Processing Method                         | Injection molding       |                   |             |
| Physical                                  | Nominal Value           | Unit              | Test Method |
| Specific Gravity                          | 1.09                    | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (200°C/2.16 kg) | 2.8                     | g/10 min          | ASTM D1238  |
| Hardness                                  | Nominal Value           | Unit              | Test Method |
| Durometer Hardness (Shore A, 23°C)        | 40                      |                   | ASTM D2240  |
| Elastomers                                | Nominal Value           | Unit              | Test Method |
| Tensile Strength <sup>1</sup> (Break)     | 2.80                    | MPa               | ASTM D412   |
| Tensile Elongation <sup>2</sup> (Break)   | 650                     | %                 | ASTM D412   |
| Injection                                 | Nominal Value           | Unit              |             |
| Rear Temperature                          | 140 - 160               | °C                |             |
| Middle Temperature                        | 150 - 170               | °C                |             |
| Front Temperature                         | 160 - 180               | °C                |             |
| Processing (Melt) Temp                    | 110 - 130               | °C                |             |
| Mold Temperature                          | 30.0 - 60.0             | °C                |             |

|   |            |
|---|------------|
| Injection Rate  | Moderate   |
| Injection instructions  |            |
| Processing Temperature Limit: 260°CInjection Pressure: ModerateBack Pressure: 20 to 50%Overmolding Parameters:Rear Temperature: 160 to 180°CCenter Temperature: 170 to 190°CFront Temperature: 180 to 200°C Melt Temperature: 110 to 130°C Mold Temperature: 30 to 60°CProcessing Temperature Limit: 220°CInjection Pressure: ModerateInjection Speed: ModerateBack Pressure: 20 to 50% |            |
| NOTE  |            |
| 1.  | 500 mm/min |
| 2.  | 500 mm/min |

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### Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

