

Gallonprene® GP520-6509

Thermoplastic Elastomer

Shenzhen Sungallon Rubber & Plastic Corporation Limited

Message:

Gallonprene® GP520-6509 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® GP520-6509 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	1.14	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/2.16 kg)	32	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 23°C)	65		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break)	3.50	MPa	ASTM D412
Tensile Elongation ² (Break)	550	%	ASTM D412
Injection	Nominal Value	Unit	
Rear Temperature	130 - 150	°C	
Middle Temperature	140 - 160	°C	
Front Temperature	150 - 170	°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: 260°CInjection Pressure: ModerateInjection Speed: ModerateBack Pressure: 20 to 50%	
NOTE	
1.	500 mm/min
2.	500 mm/min

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