

# Soffflex 2701 3694 Teal

## LyondellBasell Industries - Thermoplastic Elastomer

### General Information

#### Product Description

Soffflex 2701 3694 Teal is a Thermoplastic Elastomer material.

#### General

Uses • Overmolding

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.994		ASTM D792
Melt Mass-Flow Rate (MFR) <sup>2</sup> (235°C/1.0 kg)	5.0	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Taber Abrasion Resistance 1000 Cycles, 1000 g, H-22 Wheel	58.9	mg	ASTM D3389
Films	Nominal Value	Unit	Test Method
Peel Strength - 90°	20	lbf/in	ASTM D429
Elastomers	Nominal Value	Unit	Test Method
Tensile Set (100% Strain)	4	%	ASTM D412
Tensile Stress (50% Strain)	218	psi	ASTM D412
Tensile Stress (100% Strain)	289	psi	ASTM D412
Tensile Stress (300% Strain)	487	psi	ASTM D412
Tensile Strength <sup>3</sup> (Yield)	1640	psi	ASTM D412
Tensile Elongation (Break)	870	%	ASTM D412
Tear Strength	298	lbf/in	ASTM D624
Compression Set			ASTM D395B
73°F, 22 hr	22	%	
158°F, 22 hr	73	%	
212°F, 22 hr	89	%	
Impact	Nominal Value	Unit	Test Method
Gardner Impact (-22°F)	239	in·lb	ASTM D5420
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A	48		
Shore A, 10 sec	45 to 55		

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	129 to 151	°F
Drying Time	4.0 to 6.0	hr
Rear Temperature	320 to 360	°F
Middle Temperature	340 to 379	°F
Front Temperature	410 to 430	°F
Nozzle Temperature	390 to 421	°F
Processing (Melt) Temp	379 to 410	°F
Mold Temperature	81 to 120	°F

## Softflex 2701 3694 Teal

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Injection	Nominal Value	Unit
Injection Pressure	500 to 600	psi
Holding Pressure	200 to 801	psi
Back Pressure	75.0 to 149	psi
Screw Speed	20 to 40	rpm

#### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> Procedure A

<sup>3</sup> 20 in/min