

Versaflex™ OM 1245X-1

Thermoplastic Elastomer

PolyOne Corporation

Message:

Versaflex™OM 1245X-1 is designed to be bonded to PC (polycarbonate), ABS, PC/ABS and other matrix materials by overlapping molding.

Strong adhesion to PC, ABS, PC/ABS

Similar to rubber

Soft to the touch

General Information			
Features	Good processing stability		
	Soft		
Uses	overmolding		
	Electrical/Electronic Applications		
	Soft touch application		
	Soft handle		
	Consumer goods application field		
Agency Ratings	FDA not rated		
RoHS Compliance	RoHS compliance		
Appearance	Translucent		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.968	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	1.0 - 12	g/10 min	ASTM D1238
200°C/5.0 kg	45 - 65	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.4 - 1.8	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shaw A, 10 seconds, 23°C)	46		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
100% strain, 23°C ²	1.79	MPa	ASTM D412
300% strain, 23°C ³	3.50	MPa	ASTM D412
Tensile Strength (Break, 23°C)	6.11	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	490	%	ASTM D412
Compression Set (23°C, 22 hr)	31	%	ASTM D395B
Fill Analysis	Nominal Value	Unit	Test Method

Apparent Viscosity (200°C, 11200 sec ⁻¹)	13.0	Pa·s	ASTM D3835
Injection	Nominal Value	Unit	
Drying Temperature	43.3 - 46.1	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	< 0.030	%	
Suggested Max Regrind	20	%	
Rear Temperature	160 - 193	°C	
Middle Temperature	177 - 193	°C	
Front Temperature	182 - 204	°C	
Nozzle Temperature	193 - 216	°C	
Processing (Melt) Temp	182 - 216	°C	
Mold Temperature	21.1 - 32.2	°C	
Back Pressure	0.00 - 0.862	MPa	
Screw Speed	75 - 125	rpm	

Injection instructions

以乙烯醋酸乙烯共聚物 (EVA),聚丙烯 (PP) 或低密度聚乙烯 (LDPE) 为基础的色母料最适合 Versaflex™ OM 1245X-1 着色.典型的母料浓度为 50:1 到 25:1 - 要最大限度减少对粘接的影响,用量应该尽可能低.若使用 GLS 可供的预着色复合材料,则可达到较好的配色一致性.不应采用以 PVC 为基础的色母料.色母料是否适用,应由用户通过试验来最终确定.在使用此产品之前或之后,均须用熔体流动速率较低 (0.5 - 2.5 MFR) 的聚乙烯 (PE) 或聚丙烯 (PP) 彻底进行置换.Versaflex™ OM 1245X-1 可利用高达 20% 的回收料同时其性能所受影响却极小,但该回收料必须是未受到污染的.为了最大限度地减小模塑期间其性能所受的影响,熔体温度应维持得尽可能低.回收料的有效性应由用户最终确定.Versaflex™ OM 1245X-1 具有良好的熔体稳定性.最长停留时间可能会根据机筒尺寸有所变化.通常,如果机器闲置 5 - 8 分钟或以上,则应将机筒排空.建议露点:-40°F注射速度:1 - 3 英寸/秒第一阶段 - 提升压力:100 - 800 psi第二阶段 - 保持压力:30% 的升压保持时间(厚部件):4 - 10 秒保持时间(薄部件):1 - 3 秒

NOTE

- | | |
|----|-------------|
| 1. | 2 hours |
| 2. | Mouth die c |
| 3. | C mould |

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