

Versaflex™ OM 6160-9

Thermoplastic Elastomer

PolyOne Corporation

Message:

Versaflex™ OM 6160-9 is specifically designed to bond to a variety of standard and modified nylon materials, including those which are glass-filled, heat stabilized and/or impact modified.

Excellent Surface Appearance

Outstanding Adhesion in Both Two-Shot and Insert Molding Processes

Soft, Rubbery Grip

Very Easy to Process

General Information			
UL YellowCard	E76261-101061809		
Features	Workability, good		
	Good adhesion		
	Excellent appearance		
Agency Ratings	UL 94 .QMFZ2.E76261		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	5.0	g/10 min	ASTM D1238
200°C/5.0 kg	38	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.7 - 2.1	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	60		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
100% strain, 23°C ²	2.28	MPa	ASTM D412
300% strain, 23°C ³	2.95	MPa	ASTM D412
Tensile Strength (Break, 23°C)	3.06	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	370	%	ASTM D412
Tear Strength	24.5	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	31	%	ASTM D395B
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	HB		UL 94
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 11200 sec ⁻¹)	19.6	Pa · s	ASTM D3835
Injection	Nominal Value	Unit	
Suggested Max Regrind	20	%	

Rear Temperature	166 - 193	°C
Middle Temperature	249 - 260	°C
Front Temperature	254 - 277	°C
Nozzle Temperature	254 - 277	°C
Processing (Melt) Temp	260 - 277	°C
Mold Temperature	15.6 - 37.8	°C
Back Pressure	0.00 - 0.689	MPa
Screw Speed	75 - 175	rpm

Injection instructions

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 6160-9 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 6160-9 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 8 - 10 分钟或以上,则应将机筒排空.不需要干燥注射速度:2.5 - 5 英寸/秒第一阶段 - 提升压力:400 - 600 psi第二阶段 - 保持压力:30% 的升压保持时间(厚部件):3 - 6 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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