

Softflex® 0954

Thermoplastic Elastomer

Network Polymers, Inc.

Message:

Softflex® 0954 is a Thermoplastic Elastomer (TPE) product. It can be processed by coating or injection molding and is available in North America.

General Information			
Forms	Pellets		
Processing Method	Coating Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹			ASTM D1238
200°C/5.0 kg	21	g/10 min	
235°C/1.0 kg	19	g/10 min	
Molding Shrinkage			ASTM D955
Flow : 3.18 mm	3.2	%	
Across Flow : 3.18 mm	3.6	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A	68 to 78		
Shore A, 10 sec	64 to 74		
Mechanical	Nominal Value	Unit	Test Method
Taber Abrasion Resistance (1000 Cycles, 1000 g, H-22 Wheel)	238	mg	ASTM D3389
Elastomers	Nominal Value	Unit	Test Method
Tensile Set (100% Strain)	7	%	ASTM D412
Tensile Stress			ASTM D412
50% Strain	2.57	MPa	
100% Strain	3.27	MPa	
300% Strain	4.90	MPa	
Tensile Strength ² (Yield)	9.54	MPa	ASTM D412
Tensile Elongation (Break)	810	%	ASTM D412
Tear Strength	45.5	kN/m	ASTM D624
Compression Set ³			ASTM D395B
23°C, 22 hr	24	%	
70°C, 22 hr	78	%	
100°C, 22 hr	96	%	
Impact	Nominal Value	Unit	Test Method

Gardner Impact (-30°C)	> 36.2	J	ASTM D5420
Additional Information	Nominal Value		
Overmold Bonding	ABS, PC, ABS/PC, PPO		
Injection	Nominal Value	Unit	
Drying Temperature	54.4 to 60.0	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Shot Size	40 to 80	%	
Rear Temperature	160 to 182	°C	
Middle Temperature	171 to 193	°C	
Front Temperature	210 to 221	°C	
Nozzle Temperature	199 to 216	°C	
Processing (Melt) Temp	193 to 210	°C	
Mold Temperature	26.7 to 48.9	°C	
Injection Pressure	34.5 to 41.4	MPa	
Holding Pressure	27.6 to 31.0	MPa	
Back Pressure	0.517 to 1.03	MPa	
Screw Speed	20 to 40	rpm	
NOTE			
1.	Procedure A		
2.	510 mm/min		
3.	25% Deflection		

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