

GLS 466-007B TRANSLUCENT

Thermoplastic Elastomer

PolyOne Corporation

Message:

Versaflex™CL2000X is an ultra-soft TPE designed for injection molding applications that require extremely high transparency and ultra-soft touch.
good touch
super soft
Transparent as water

General Information			
Features	Definition, high Soft		
Uses	Personal care artificial skin Soft touch application Transparent or Translucent Accessories Toys Consumer goods application field		
Agency Ratings	FDA not rated		
RoHS Compliance	RoHS compliance		
Appearance	Clear/transparent		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.868	g/cm ³	ASTM D792
Molding Shrinkage - Flow	3.6 - 4.0	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	3		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
100% strain, 23°C ²	0.103	MPa	ASTM D412
300% strain, 23°C ³	0.241	MPa	ASTM D412
Tensile Strength (Break, 23°C)	2.07	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	1100	%	ASTM D412
Tear Strength	8.76	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	23	%	ASTM D395B
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 11200 sec ⁻¹)	2.20	Pa · s	ASTM D3835
Injection	Nominal Value	Unit	

Suggested Max Regrind	20	%
Rear Temperature	116 - 149	°C
Middle Temperature	138 - 182	°C
Front Temperature	154 - 188	°C
Nozzle Temperature	160 - 193	°C
Mold Temperature	12.8 - 32.2	°C
Back Pressure	0.00 - 0.552	MPa
Screw Speed	15 - 75	rpm

Injection instructions

此产品应使用以 Versaflex™ CL2000X 为色载体的色母料着色.若欲采用以 CL2000X 为色载体的色母料,很重要的一点是所选择的着色工厂具有水下造粒的能力.典型的色母料用量为 1% 至 5%(重量).可以使用液体颜料(颜料,而非染料);推荐采用白油载体.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.不应采用以聚丙烯 (PP) 为基础的色母料,因为它们将导致较差的分散性,并能显著地改变材料的硬度.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™ CL2000X 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.不需要干燥注射速度:0.5 - 2 英寸/秒第一阶段 - 提升压力:100 - 400 psi第二阶段 - 保持压力:30% 的升压保持时间(厚部件):2 - 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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