

Versaflex™ Versaflex™ HC 1100-40

Translucent EU

Thermoplastic Elastomer
PolyOne Corporation

Message:

The Versaflex™ HC 1100-40 Translucent EU is an overmolding TPE with very good adhesion to PC or ABS-based plastics.
Good Surface Aesthetics
Rubbery Feel
Soft Touch
Very Good Bond to PC, ABS, PC/ABS

General Information			
Features	Workability, good		
	Good formability		
	Good processing stability		
	Good coloring		
	Excellent appearance		
Uses	overmolding		
	Soft touch application		
	Soft handle		
	Transparent or Translucent Accessories		
	Medical/nursing supplies		
RoHS Compliance	RoHS compliance		
Appearance	Translucent		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.917	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/5.0 kg)	75	g/10 min	ISO 1133
Molding Shrinkage - Flow	2.0 - 2.6	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 3 sec)	44		DIN 53505
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ISO 37
100% strain, 23°C, 2.00mm	1.00	MPa	ISO 37
300% strain, 23°C, 2.00mm	2.00	MPa	ISO 37
Tensile Strength ² (Break, 23°C, 2.00 mm)	5.40	MPa	ISO 37
Tensile Elongation ³ (Break, 23°C, 2.00 mm)	730	%	ISO 37

Tear Strength	18.0	kN/m	ISO 34
Compression Set (23°C, 22 hr)	22	%	ASTM D395B
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 11200 sec ⁻¹)	10.5	Pa·s	Internal method
Injection	Nominal Value	Unit	
Suggested Max Regrind	20	%	
Rear Temperature	165 - 190	°C	
Middle Temperature	180 - 200	°C	
Front Temperature	185 - 205	°C	
Nozzle Temperature	195 - 215	°C	
Processing (Melt) Temp	185 - 210	°C	
Mold Temperature	20 - 40	°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 1040 Translucent EU 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 1040 Translucent EU 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 1040 Translucent EU 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:1 - 5 英寸/秒第一阶段 - 提升压力:200 - 600 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. 200 mm/min
2. 200 mm/min
3. 200 mm/min

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