

Softflex® 0470

Thermoplastic Elastomer

Network Polymers, Inc.

Message:

Softflex 0470 is suitable for overmolding ABS, PC, ABS/PC and PPO.

General Information			
Forms	Pellets		
Processing Method	Coating Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.970	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/1.0 kg)	1.0	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow : 3.18 mm	1.6 to 3.3	%	
Across Flow : 3.18 mm	1.7 to 2.9	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A	42 to 48		
Shore A, 10 sec	37 to 43		
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	5.92	MPa	ASTM D790
Taber Abrasion Resistance (1000 Cycles, 1000 g, H-22 Wheel)	1640	mg	ASTM D3389
Elastomers	Nominal Value	Unit	Test Method
Tensile Set (100% Strain)	105	%	ASTM D412
Tensile Stress			ASTM D412
50% Strain	0.834	MPa	
100% Strain	1.18	MPa	
300% Strain	2.14	MPa	
Tensile Strength (Yield)	4.21	MPa	ASTM D412
Tensile Elongation (Break)	680	%	ASTM D412
Tear Strength	16.3	kN/m	ASTM D624
Compression Set (23°C)	24	%	ASTM D395
Impact	Nominal Value	Unit	Test Method
Gardner Impact (-30°C)	> 36.2	J	ASTM D5420
Injection	Nominal Value	Unit	Test Method
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
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

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