Versaflex™ OM 1360-9

Thermoplastic Elastomer

PolyOne Corporation

Message:

The Versaflex™ OM 1360-9 is designed for overmolding onto polycarbonate (PC), ABS, and PC/ABS susbstrates.
Excellent Bond to PC, ABS, PC/ABS
Rubbery Feel
Soft Touch

General Information			
UL YellowCard	E76261-101873478		
Features	Good processing stability Soft		
Uses	overmolding Electrical/Electronic Applications Soft touch application Soft handle Consumer goods application field		
RoHS Compliance	RoHS compliance		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.13	g/cm³	ASTM D792
Molding Shrinkage - Flow	0.90 - 2.1	%	ASTM D955
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shaw A, 10 seconds, 23°C)	60		ASTM D2240
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [1]			ASTM D412
100% strain, 23°C [2]	1.79	MPa	ASTM D412
300% strain, 23°C [3]	3.65	MPa	ASTM D412
Tensile Strength (Break, 23°C)	6.89	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	650	%	ASTM D412
Fill Analysis	**Nominal Value**	**Unit**	**Test Method**
Apparent Viscosity (200°C, 11200 sec^-1)	16.0	Pa·s	ASTM D3835
Injection	**Nominal Value**	**Unit**	
Drying Temperature	43.3 - 46.1	°C	
Drying Time	3.0 - 4.0	hr	

Suggested Max Moisture	< 0.030	%
Suggested Max Regrind	20	%
Rear Temperature	160 - 193	°C
Middle Temperature	177 - 193	°C
Front Temperature	182 - 204	°C
Nozzle Temperature	193 - 216	°C
Processing (Melt) Temp	182 - 216	°C
Mold Temperature	21.1 - 32.2	°C
Back Pressure	0.00 - 0.862	MPa
Screw Speed	75 - 125	rpm

Injection instructions

Color concentrates with EVA, polypropylene (PP) or LDPE carrier are most suitable for coloring Versaflex™ OM 1360-9. Typical letdown ratios are 50:1 to 25:1 - loading levels should be as low as possible to minimize the effect on adhesion. A high color match consistency can be obtained by the use of precolored compounds available from GLS. Concentrates based on PVC should not be used. The final determination of color concentrate suitability should be determined by customer trials.Purge thoroughly before and after use of this product with a low flow (0.5 - 2.5 MFR) polyethylene (PE) or polypropylene (PP).Regrind levels up to 20% can be used with Versaflex™ OM 1360-9 with minimal property loss, provided that the regrind is free of contamination. To minimize losses during molding, the melt temperature should remain as low as possible. The final determination of the regrind effectiveness should be determined by the customer.Versaflex™ OM 1360-9 has good melt stability. Maximum residence times may vary, depending on the size of the barrel. Generally, the barrel should be emptied if it is idle for periods of 5 - 8 minutes or longer.Suggested Dewpoint: -40°FInjection Speed: 1 to 3 in/sec1st Stage - Boost Pressure: 100 to 800 psi2nd Stage - Hold Pressure: 30% of BoostHold Time (Thick Part): 4 to 10 secHold Time (Thin Part): 1 to 3 sec

NOTE

1.	2 hours
2.	Mouth die c
3.	C mould

Recommended distributors for this material

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