Versaflex™ OM6360B

Thermoplastic Elastomer

PolyOne Corporation

Message:

Versaflex™ OM 6360B is specifically designed to bond to a variety of standard and modified nylon materials, including those which are glass-filled, heat stabilized and/or impact modified.
Outstanding Adhesion in Both Two-Shot and Insert Molding Processes
Soft, Rubbery Grip
Very Easy to Process

General Information			
Features	Workability, good Good adhesion		
Uses	overmolding Lawn and Garden Equipment Power/other tools		
RoHS Compliance	RoHS compliance		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.09	g/cm³	ASTM D792
Molding Shrinkage - Flow	1.6 - 2.2	%	ASTM D955
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	60		ASTM D2240
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [1]			ASTM D412
100% strain, 23°C [2]	1.72	MPa	ASTM D412
300% strain, 23°C [3]	2.21	MPa	ASTM D412
Tensile Strength (Break, 23°C)	2.55	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	780	%	ASTM D412
Tear Strength	22.9	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	25	%	ASTM D395B
Fill Analysis	**Nominal Value**	**Unit**	**Test Method**
Apparent Viscosity (200°C, 11200 sec^-1)	32.5	Pa·s	ASTM D3835
Injection	**Nominal Value**	**Unit**	
Suggested Max Regrind	20	%	
Rear Temperature	182 - 204	°C	
Middle Temperature	243 - 266	°C	

Front Temperature	249 - 271	°C
Nozzle Temperature	254 - 277	°C
Processing (Melt) Temp	249 - 271	°C
Mold Temperature	12.8 - 29.4	°C
Back Pressure	0.00 - 0.552	MPa
Screw Speed	80 - 120	rpm

Injection instructions
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 6360B 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 regrind effectiveness should be determined by the customer.Versaflex™ OM 6360B 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 8 - 10 minutes or longer.Drying is not RequiredInjection Speed: 3 to 5 in/sec1st Stage - Boost Pressure: 300 to 800 psi2nd Stage - Hold Pressure: 0% of BoostHold Time (Thick Part): 0 to 4 secHold Time (Thin Part): 0 to 3 sec

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

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China