

Versollan™ OM 1255NX-9

Thermoplastic Elastomer

PolyOne Corporation

Message:

Versollan™OM 1255NX-9 is a high-performance polyurethane (TPU) alloy designed for thin-walled overlapping molding with polycarbonate (PC), ABS, PC/ABS and other substrates.

Matte, imitation rubber surface is easier to grasp
tested by practice

Excellent adhesion to PC, ABS, PC/ABS, PC/PBT and copolyester

General Information			
UL YellowCard	E76261-101061813		
Features	Gloss, low		
	Workability, good		
	Good formability		
Uses	overmolding		
	Thin wall parts		
	Electrical/Electronic Applications		
	Power/other tools		
	Soft handle		
	Business equipment		
	Consumer goods application field		
Agency Ratings	UL 94 .QMFZ2.E76261		
RoHS Compliance	RoHS compliance		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	6.0	g/10 min	ASTM D1238
200°C/5.0 kg	60	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.1 - 1.7	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	59		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
100% strain, 23°C ²	1.93	MPa	ASTM D412
300% strain, 23°C ³	3.39	MPa	ASTM D412

Tensile Strength (Break, 23°C)	6.58	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	650	%	ASTM D412
Tear Strength	38.5	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	24	%	ASTM D395B
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature ⁴	-68.5	°C	ASTM D746
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	HB		UL 94
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 11200 sec ⁻¹)	16.7	Pa·s	ASTM D3835
Injection	Nominal Value	Unit	
Drying Temperature	51.7 - 54.4	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	< 0.030	%	
Suggested Max Re grind	20	%	
Rear Temperature	163 - 188	°C	
Middle Temperature	182 - 199	°C	
Front Temperature	188 - 210	°C	
Nozzle Temperature	193 - 216	°C	
Mold Temperature	21.1 - 48.9	°C	
Back Pressure	0.00 - 0.552	MPa	
Screw Speed	75 - 125	rpm	
Injection instructions			

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.Versollan™ OM 1255NX-9 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.Versollan™ OM 1255NX-9 不应在机筒内闲置过长时间(5 分钟以上).建议露点:-40°F注射速度:0.5 - 2 英寸/秒第一阶段 - 提升压力:200 - 800 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. 2 hours
2. Mouth die c
3. C mould
4. Thickness = 1.90mmConditioned for 40hrs at 23C at 50% RH

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