

# Versaflex™ OM 1040 Translucent EU

Thermoplastic Elastomer

PolyOne Corporation

## Message:

The Versaflex™ OM 1040 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 <sup>3</sup> | 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 <sup>1</sup>                            |                                        |                   | 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 <sup>2</sup> (Break, 23°C, 2.00 mm)   | 5.40                                   | MPa               | ISO 37      |
| Tensile Elongation <sup>3</sup> (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 <sup>-1</sup> ) | 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                                     | 20.0 - 40.0   | °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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