Versaflex[™] FFC 2882-70

Thermoplastic Elastomer

PolyOne Corporation

Message:

Versaflex[™] FFC 2882-70

| General Information | | | |
|--|----------------------------------|-------|-------------|
| Features | Compliance of Food Exposure | | |
| Uses | overmolding | | |
| | Kitchen utensils | | |
| | Washer | | |
| | Non-specific food applications | | |
| | Container | | |
| | Consumer goods application field | | |
| | | | |
| Agency Ratings | FDA 21 CFR 177.2600 2 | | |
| | NSF 51 3 | | |
| | Europe 10/1/2011 12:00:00 AM 4 | | |
| | | | |
| RoHS Compliance | RoHS compliance | | |
| Appearance | Translucent | | |
| | Black | | |
| | | | |
| Forms | Particle | | |
| Processing Method | Extrusion | | |
| | Injection molding | | |
| | | | |
| Physical | Nominal Value | Unit | Test Method |
| Specific Gravity | 0.878 | g/cm³ | ASTM D792 |
| Hardness | Nominal Value | Unit | Test Method |
| Durometer Hardness (Shore A, 10 sec) | 73 | | ASTM D2240 |
| Elastomers | Nominal Value | Unit | Test Method |
| Tensile Stress (300% Strain, 23°C) | 2.95 | MPa | ASTM D412 |
| Tensile Strength (Break, 23°C) | 6.21 | MPa | ASTM D412 |
| Tensile Elongation | | | ASTM D412 |
| Fracture | 1200 | % | ASTM D412 |
| Fracture, 23°C | 1200 | % | ASTM D412 |
| Fill Analysis | Nominal Value | Unit | Test Method |
| Apparent Viscosity (200°C, 11200 sec^-1) | 38.6 | Pa·s | ASTM D3835 |
| Injection | Nominal Value | Unit | |

| Suggested Max Regrind | 20 | % |
|------------------------|--------------|-----|
| Rear Temperature | 193 - 204 | °C |
| Middle Temperature | 199 - 216 | °C |
| Front Temperature | 204 - 227 | °C |
| Nozzle Temperature | 210 - 238 | °C |
| Processing (Melt) Temp | 204 - 227 | °C |
| Mold Temperature | 13 - 32 | °C |
| Back Pressure | 0.00 - 0.552 | MPa |
| Screw Speed | 50 - 100 | rpm |
| | | |

Injection instructions

Color concentrates based on polypropylene (PP), ethylene vinyl acetate (EVA), or low density polyethylene (LDPE) are most suitable for coloring Versaflex[™] FFC 2882-70. Improved color dispersion can be achieved by using higher melt flow concentrates (with a melt flow from 25-40 g/10 min). Typical loadings for color concentrates are 1% to 5% by weight. Liquid color can be used, but mineral oil based carriers may have a significant effect on the final hardness value. Concentrates based on PVC should not be used. A high color match consistency can be obtained by the use of precolored compounds available from GLS. 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[™] FFC 2882-70 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[™] FFC 2882-70 has excellent 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: 1 to 3 in/sec1st Stage - Boost Pressure: 500 to 700 psi2nd Stage -Hold Pressure: 10 to 30% of BoostHold Time (Thick Part): 2 to 4 secHold Time (Thin Part): 1 to 2 sec

| Extrusion | Nominal Value | Unit |
|------------------------|---------------|------|
| Melt Temperature | 204 - 227 | °C |
| Die Temperature | 216 - 238 | °C |
| Extrusion instructions | | |

Rear: 380-400FCenter: 390-420FFront: 400-440FScrew: 100-500rpm

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