

Versaflex™ OM 9-802CL

Thermoplastic Elastomer

PolyOne Corporation

Message:

Versaflex™OM 9-802CL is a transparent and soft TPE designed to be bonded to the following thermoplastics: PC (polycarbonate), ABS, PC/ABS and copolymeric polyesters.

New Products. Commercial norms have not yet been established.

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

Soft to the touch

Transparent as water

General Information			
Features	Good coloring		
	Definition, high		
Uses	overmolding		
	Soft touch application		
	Soft handle		
	Consumer goods application field		
Agency Ratings	FDA not rated		
RoHS Compliance	RoHS compliance		
Appearance	Clear/transparent		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.918	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	15 - 26	g/10 min	ASTM D1238
200°C/5.0 kg	81 - 92	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 1.1	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	40		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
100% strain, 23°C ²	1.59	MPa	ASTM D412
300% strain, 23°C ³	2.14	MPa	ASTM D412
Tensile Strength (Break, 23°C)	7.76	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	1200	%	ASTM D412
Tear Strength	24.5	kN/m	ASTM D624
Compression Set			ASTM D395B
23°C, 22 hr	20	%	ASTM D395B

70°C, 22 hr	99	%	ASTM D395B
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 11200 sec ⁻¹)	16.0	Pa·s	ASTM D3835
Injection	Nominal Value	Unit	
Suggested Max Regrind	20	%	
Rear Temperature	166 - 188	°C	
Middle Temperature	182 - 204	°C	
Front Temperature	193 - 210	°C	
Nozzle Temperature	193 - 210	°C	
Mold Temperature	21.1 - 26.7	°C	
Back Pressure	0.00 - 0.621	MPa	
Screw Speed	25 - 75	rpm	

Injection instructions

此产品应使用以 Versaflex™ OM9-802CL 为载体的色母料着色.若欲采用以 OM 9-802CL 为载体的色母料,很重要的一点是所选择的着色工厂具有水下造粒的能力.典型的色母料用量为 1% 至 5%(重量).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.不应采用以聚丙烯 (PP) 为基础的色母料,因为它们将导致较差的分散性和透明度,还能显著地影响此 TPE 材料与基体之间的粘接.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) 的聚苯乙烯 (PS) 或聚丙烯 (PP) 彻底进行置换.Versaflex™ OM 9-802CL 可利用高达 20% 的回收料同时其性能受影响却极小,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.不需要干燥注射速度:1 - 3 英寸/秒第一阶段 - 提升压力:300 - 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

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

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