

Softflex® 6018

Thermoplastic Elastomer
Network Polymers, Inc.

Message:

Softflex 6500 is suitable for overmolding polypropylene and polyethylene.

General Information			
Uses	overmolding		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity (Natural)	1.18	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (23°C, 3.18 mm, Injection Molded)	1.3 - 1.8	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 23°C, 3.18mm, injection molding)	60		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 23°C, 3.18 mm)	4.83	MPa	ASTM D412
Tear Strength	22.8	kN/m	ASTM D624
Aging	Nominal Value	Unit	Test Method
Change in Ultimate Elongation	900	%	ASTM D412
Additional Information			
Overmold Bonding To: PP, PE			
Injection	Nominal Value	Unit	
Suggested Max Regrind	50	%	
Rear Temperature	171 - 182	°C	
Middle Temperature	188 - 199	°C	
Front Temperature	204 - 216	°C	
Nozzle Temperature	202 - 213	°C	
Mold Temperature	21.1 - 43.3	°C	
Injection Rate	Moderate-Fast		
Back Pressure	0.621 - 1.21	MPa	
Screw L/D Ratio	20.0:1.0		
Screw Compression Ratio	1.5:1.0		
NOTE			

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Recommended distributors for this material

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