

Versaflex™ CL30

Thermoplastic Elastomer

PolyOne Corporation

Message:

Versaflex™CL30 is an easy-to-process composite material designed for injection molding and extrusion molding applications that require extremely high transparency and excellent coloring characteristics.

Extremely high transparency

Excellent coloring

It can be bonded to polypropylene by overlapping molding

Soft to the touch

General Information			
Features	Good coloring		
	Definition, high		
Uses	overmolding		
	Optical applications		
	Soft touch application		
	Soft handle		
	Transparent or Translucent Accessories		
	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	0.888	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	18	g/10 min	ASTM D1238
200°C/5.0 kg	110	g/10 min	ASTM D1238
Molding Shrinkage - Flow	2.1 - 2.5	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	30		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
100% strain, 23°C ²	0.689	MPa	ASTM D412
300% strain, 23°C ³	1.38	MPa	ASTM D412
Tensile Strength (Break, 23°C)	5.18	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	870	%	ASTM D412
Tear Strength	19.3	kN/m	ASTM D624

Compression Set (23°C, 22 hr)	11	%	ASTM D395B
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 11200 sec ⁻¹)	14.8	Pa·s	ASTM D3835
Injection	Nominal Value	Unit	
Suggested Max Regrind	20	%	
Rear Temperature	160 - 188	°C	
Middle Temperature	177 - 199	°C	
Front Temperature	182 - 227	°C	
Nozzle Temperature	188 - 227	°C	
Mold Temperature	15.6 - 37.8	°C	
Back Pressure	0.00 - 0.862	MPa	
Screw Speed	75 - 125	rpm	

Injection instructions

以聚丙烯 (PP), 乙烯醋酸乙烯共聚物 (EVA) 或聚乙烯 (PE) 为基础的色母料最适合 Versaflex™ CL30 着色. 使用熔体流动速率较高(范围为 25 - 40 克/10 分钟)的色母料, 则能达到较好的颜色分散效果. 典型的色母料用量为 1% 至 5%(重量). 可以使用液体颜料, 但以矿物油为基础的载体对最终硬度值会有显著的影响. 不应采用以 PVC 为基础的色母料. 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. 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™ CL30 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. 不需要干燥注射速度: 1 - 5 英寸/秒
 第一阶段 - 提升压力: 400 - 1000 psi
 第二阶段 - 保持压力: 30% 的升压保持时间(厚部件): 3 - 10 秒
 保持时间(薄部件): 1 - 3 秒

NOTE

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

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