

Versaflex™ FFC 2882-87

Thermoplastic Elastomer

PolyOne Corporation

Message:

Versaflex™ FFC 2882-87 is a design that can pass some migration tests of fatty foods specified in food standards 2002/72/EC, FDA21 CFR177.2600 and GB4806.1-94.

Versaflex™ FFC 2882-87 can be bonded or co-extruded with polypropylene

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 7hrs, 2hrs distilled water 2 FDA 21 CFR 177.2600 7hrs, 2hrs n-hexane 2 Europe 2002/72/EC 0.5 hrs at 40C in Iso-octane 3 Europe 2002/72/EC 3 hrs at 60C in 95% ethanol 3		
RoHS Compliance	RoHS compliance		
Appearance	Translucent		
Forms	Particle		
Processing Method	Extrusion Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.878	g/cm ³	ASTM D792
Molding Shrinkage - Flow (Injection Molded)	0.90 - 1.5	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	88		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain, 23°C	7.25	MPa	ASTM D412
300% strain, 23°C	7.65	MPa	ASTM D412
Tensile Strength (Break, 23°C)	9.03	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	700	%	ASTM D412
Fill Analysis	Nominal Value	Unit	Test Method

Apparent Viscosity (200°C, 11200 sec ⁻¹)	34.8	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	12.8 - 32.2	°C	
Back Pressure	0.00 - 0.552	MPa	
Screw Speed	50 - 100	rpm	

Injection instructions

以聚丙烯(PP),乙烯-醋酸乙烯(EVA),或低密度的聚乙烯(LDPE)为载体的色母粒最适合用于Versaflex™ FFC 2882-87的着色.高流动性的色母粒(熔融指数在25-40克/10分钟)有助于提高颜色的分散.典型的色母粒添加重量比例为1%-5%.也可以使用色油进行着色,但以矿物油作为载体的色油对产品的最终硬度有显著的影响.不建议使用以PVC做载体的色母粒.如需高质量的颜色控制, GLS公司可以提供预着色产品.色母粒的适用性应由客户根据实际的试生产情况而最终确定.在使用前和后,都要用熔融指数在0.5-2.5的聚乙烯(PE)或聚丙烯(PP)进行彻底的清洗.在回收料没有污染的前提下,最高可以用20%比例的Versaflex™ FFC 2882-87 回收料和新料混和使用,同时不至于影响材料的特性.为尽可能降低对材料特性的影响和损耗,加工温度应尽可能的低.回收料的最终使用效果应由客户实际试生产情况决定.Versaflex™ FFC 2882-87

有优异的熔体稳定性.最大的停留时间因料筒尺寸差异而不同.一般在闲置8-10分钟或更长时间后,料筒内材料应被清空.该产品不需要干燥注射速度: 1-3英寸/秒一段: 注射压力: 500-700 psi二段: 保压压力: 10%-30%注射压力保压时间(厚部件):2-4秒保压时间(薄部件):1-2秒

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

Extrusion instructions

Rear: 380-400F Center: 390-420F Front: 400-440F Screw: 100-500rpm

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