

Versaflex™ 9545-1

Thermoplastic Elastomer

PolyOne Corporation

Message:

Versaflex™9545-1 has strong fluidity and good surface aesthetic effect, which is suitable for various applications.

Very suitable for long and narrow runners

Very strong coloring ability

It can be bonded to polypropylene by overlapping molding

Excellent surface aesthetics

General Information			
Features	Good liquidity		
	Good coloring		
	Excellent appearance		
Uses	overmolding		
	Soft touch application		
	Soft handle		
	General		
	Consumer goods application field		
Agency Ratings	FDA not rated		
RoHS Compliance	RoHS compliance		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.988	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	3.6	g/10 min	ASTM D1238
200°C/5.0 kg	21	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.90 - 1.7	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	45		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
100% strain, 23°C ²	0.931	MPa	ASTM D412
300% strain, 23°C ³	1.86	MPa	ASTM D412
Tensile Strength (Break, 23°C)	2.76	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	630	%	ASTM D412
Tear Strength	16.1	kN/m	ASTM D624

Compression Set (23°C, 22 hr)	20	%	ASTM D395B
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity			ASTM D3835
200°C, 1340 sec ⁻¹	30.0	Pa·s	ASTM D3835
200°C, 11200 sec ⁻¹	6.50	Pa·s	ASTM D3835
Injection	Nominal Value	Unit	
Suggested Max Regrind	20	%	
Rear Temperature	149 - 188	°C	
Middle Temperature	160 - 199	°C	
Front Temperature	171 - 210	°C	
Nozzle Temperature	171 - 210	°C	
Mold Temperature	15.6 - 26.7	°C	
Back Pressure	0.00 - 0.689	MPa	
Screw Speed	50 - 100	rpm	

Injection instructions

以聚丙烯 (PP) 为基础的色母料最适合 Versalfex® 9545-1 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).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™ 9545-1 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.Versaflex™ 9545-1 具有良好的熔体稳定性.如果机器闲置十五 (15) 分钟或以上,则应将机筒排空.不需要干燥注射速度:1 - 5 英寸/秒第一阶段 - 提升压力:300 - 700 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

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

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