# Versaflex™ CL 3000-80 BL1424

## Thermoplastic Elastomer

### Key Characteristics

| Product Description | | | |
|---|---|---|---|
| Versaflex CL 3000-80 BL1424 is a custom thermoplastic elastomer formulation. Product has high flow and can overmold onto PC, ABS, PC/ABS, and Copolyester. | | | |
| **General** | | | |
| Material Status | • Commercial: Active | | |
| Regional Availability | • Asia Pacific | | |
| Features | • Specialty Grade | | |
| Uses | • Consumer Applications | • Overmolding | • Soft Touch Applications |
| Appearance | • Black | | |
| Forms | • Pellets | | |
| Processing Method | • Injection Molding | | |

### Technical Properties [1]

| Physical | Typical Value (English) | Typical Value (SI) | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 1.12 | 1.12 | ASTM D792 |
| **Elastomers** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Tensile Stress (300% Strain) | 1210 psi | 8.35 MPa | ASTM D412 |
| Tensile Strength [2, 3] (Break, 73°F (23°C)) | 3080 psi | 21.2 MPa | ASTM D412 |
| Tensile Elongation [2, 3] (Break, 73°F (23°C)) | 730 % | 730 % | ASTM D412 |
| **Hardness** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Durometer Hardness (Shore A, 10 sec) | 81 | 81 | ASTM D2240 |
| **Fill Analysis** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Apparent Viscosity | | | ASTM D3835 |
| 392°F (200°C), 11200 sec^-1 | 49.0 Pa·s | 49.0 Pa·s | |

**Legal Statement**

Bags of Versaflex CL 3000-80 BL1424 should be left in the box with the top closed and not stored in direct sunlight.

### Processing Information

| Injection | Typical Value (English) | Typical Value (SI) |
|---|---|---|
| Drying Temperature | 140 to 194 °F | 60 to 90 °C |
| Drying Time | 3.0 to 4.0 hr | 3.0 to 4.0 hr |
| Suggested Max Moisture | 0.020 to 0.030 % | 0.020 to 0.030 % |
| Rear Temperature | 347 to 365 °F | 175 to 185 °C |
| Middle Temperature | 356 to 392 °F | 180 to 200 °C |
| Front Temperature | 356 to 419 °F | 180 to 215 °C |
| Nozzle Temperature | 374 to 446 °F | 190 to 230 °C |
| Processing (Melt) Temp | 374 to 446 °F | 190 to 230 °C |
| Mold Temperature | 55 to 130 °F | 13 to 54 °C |
| Back Pressure | 0.00 to 50.0 psi | 0.00 to 0.345 MPa |
| Screw Speed | 50 to 80 rpm | 50 to 80 rpm |

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## Injection Notes

Typical colorant letdown ratios are 50:1 to 25:1 - loading levels should be as low as possible to minimize the effect on adhesion. A high color match consistency can be obtained by the use of precolored compounds available from GLS. Concentrates based on PVC should not be used. The final determination of color concentrate suitability should be determined by customer trials. Contact Avient for more information on appropriate color concentrate base resins.

Purge thoroughly before and after use of this product with a low flow (0.5 - 2.5 MFR) polyethylene (PE) or polypropylene (PP).

Versaflex CL 3000-80 BL 1424 should not be left in the barrel for extended idle periods (greater than 5 minutes).

Suggested Dewpoint: -40°F

Hot Runners: 380°F-440°F
Hot Tip: 380°F-450°F

Injection Speed: 0.5 to 2 in/sec
1st Stage - Boost Pressure: 500 to 1,000 psi
2nd Stage - Hold Pressure: 20-60% of Boost
Hold Time (Thick Part): 2 to 4 sec
Hold Time (Thin Part): 1 to 2 sec

### Notes

[1] Typical values are not to be construed as specifications.

[2] Die C

[3] 2 hr

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