Versollan™ OM 1262NX-9

Thermoplastic Elastomer

Key Characteristics

Product Description

Versollan™ OM 1262NX-9 is a performance TPU alloy designed for thin-wall overmolding onto polycarbonate (PC), ABS, PC/ABS and copolyester substrates.

- Excellent Grip with Matte, Rubbery Finish
- Proven Track Record
- Superior Adhesion to PC, ABS, PC/ABS, PC/PBT and Copolyester

General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Moldability	• Good Processability	• Low Gloss
Uses	• Business Equipment • Consumer Applications • Electrical/Electronic Applications	• Flexible Grips • Overmolding • Power/Other Tools	• Thin-walled Parts
Agency Ratings	• UL 94		
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.17	1.17	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	7.0 g/10 min	7.0 g/10 min	
200°C/5.0 kg	100 g/10 min	100 g/10 min	
Molding Shrinkage - Flow	9.0E-3 to 0.015 in/in	0.90 to 1.5 %	ASTM D955
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2, 3] (100% Strain, 73°F (23°C))	370 psi	2.55 MPa	ASTM D412
Tensile Stress [2, 3] (300% Strain, 73°F (23°C))	485 psi	3.34 MPa	ASTM D412
Tensile Strength [2, 3] (Break, 73°F (23°C))	1110 psi	7.64 MPa	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F (23°C))	710 %	710 %	ASTM D412
Tear Strength	230 lbf/in	40.3 kN/m	ASTM D624
Compression Set (73°F (23°C), 22 hr)	35 %	35 %	ASTM D395B
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	65	65	ASTM D2240
Flammability	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Flame Rating (0.06 in (1.5 mm))	HB	HB	UL 94
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	19.9 Pa·s	19.9 Pa·s	

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Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	125 to 130 °F	52 to 54 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	< 0.030 %	< 0.030 %
Suggested Max Regrind	20 %	20 %
Rear Temperature	325 to 365 °F	163 to 185 °C
Middle Temperature	335 to 385 °F	168 to 196 °C
Front Temperature	350 to 410 °F	177 to 210 °C
Nozzle Temperature	350 to 410 °F	177 to 210 °C
Mold Temperature	70 to 120 °F	21 to 49 °C
Back Pressure	25.0 to 50.0 psi	0.172 to 0.345 MPa
Screw Speed	25 to 75 rpm	25 to 75 rpm

Injection Notes

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

Regrind levels up to 20% can be used with Versollan™ OM 1262NX-9 with minimal property loss, provided that the regrind is free of contamination. To minimize losses during molding, the melt temperature should remain as low as possible. The final determination of regrind effectiveness should be determined by the customer.

Versollan™ OM 1262NX-9 should not be left in the barrel for extended idle periods (greater than 5 minutes).

Suggested Dewpoint: -40°F

Injection Speed: 1 to 5 in/sec
1st Stage - Boost Pressure: 200 to 800 psi
2nd Stage - Hold Pressure: 70% of Boost
Hold Time (Thick Part): 4 to 10 sec
Hold Time (Thin Part): 1 to 3 sec

Notes

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

[2] Die C

[3] 2 hr

CONTACT INFORMATION

North America
Avon Lake, United States
33587 Walker Road
Avon Lake, OH, United States , 44012
+1 440 930 1000
+1 844 4AVIENT

South America
Sao Paulo, Brazil
Av. Francisco Nakasato, 1700
13295-000 Itupeva
Sao Paulo, Brazil
+55 11 4593 9200

Asia
Shanghai, China
2F, Block C
200 Jinsu Road
Pudong, 201206
Shanghai, China
+86 (0) 21 6028 4888

Europe
Pommerloch, Luxembourg
19 Route de Bastogne
Pommerloch, Luxembourg , L-9638
+352 269 050 35

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