Versaflex™ CE 3320-80 Clear

Thermoplastic Elastomer

Key Characteristics

Product Description			
Versaflex™ CE 3320-80 CLEAR is targeted for where blue jean stain resistance,high transparency,excellent UV stability, chemical resistance and silky feel are required. It can also overmold to a variety of substrates including PC, ABS and PC/ABS, and is primarily for consumer electronics and consumer electronics accessories.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific	• North America	
Features	• Specialty Grade		
Uses	• Consumer Applications	• Overmolding	• Soft Touch Applications
RoHS Compliance	• RoHS Compliant		
Appearance	• Clear/Transparent		
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
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress (100% Strain)	825 psi	5.69 MPa	ASTM D412
Tensile Stress (300% Strain)	1730 psi	11.9 MPa	ASTM D412
Tensile Strength [2, 3] (Break, 73°F (23°C))	3300 psi	22.8 MPa	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F (23°C))	650 %	650 %	ASTM D412
Tear Strength	501 lbf/in	87.7 kN/m	ASTM D624
Compression Set (73°F (23°C))	31 %	31 %	ASTM D395
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	78	78	ASTM D2240
Optical	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Haze	5.30 %	5.30 %	ASTM D1003
Yellowness Index	0.78 YI	0.78 YI	ASTM D1925
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	55.0 Pa·s	55.0 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	158 to 176 °F	70 to 80 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Max Moisture	0.020 %	0.020 %
Rear Temperature	340 to 360 °F	171 to 182 °C
Middle Temperature	360 to 410 °F	182 to 210 °C
Front Temperature	370 to 420 °F	188 to 216 °C
Nozzle Temperature	380 to 430 °F	193 to 221 °C

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Injection	Typical Value (English)	Typical Value (SI)
Processing (Melt) Temp	380 to 425 °F	193 to 218 °C
Mold Temperature	70 to 120 °F	21 to 49 °C
Back Pressure	0.00 to 50.0 psi	0.00 to 0.345 MPa
Screw Speed	50 to 100 rpm	50 to 100 rpm

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 GLS 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 CE 3320-80 CLEAR 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

1st Stage - Injection speed 0.5 to 2 in/sec
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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