Versalloy™ XL 9055X-9

Thermoplastic Elastomer

Key Characteristics

Product Description			
Versalloy™ XL 9055X-9 is a TPV alloy with exceptional flow properties and surface aesthetics for a variety of applications. • Excellent Flow for Long, Thin Flow Paths • Overmold Adhesion to Polypropylene • Superior Surface Aesthetics • Very Good Mar Resistance			
General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Flow	• Good Surface Finish	• Recyclable Material
Uses	• Consumer Applications • Overmolding	• Soft Touch Applications • Thin-walled Parts	
Agency Ratings	• FDA 21 CFR 177.1210 [1]	• UL 94	
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [2]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.890	0.890	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	22 g/10 min	22 g/10 min	
200°C/5.0 kg	386 g/10 min	386 g/10 min	
Molding Shrinkage - Flow	0.016 to 0.022 in/in	1.6 to 2.2 %	ASTM D955
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [3, 4] (100% Strain, 73°F (23°C))	210 psi	1.45 MPa	ASTM D412
Tensile Stress [3, 4] (300% Strain, 73°F (23°C))	335 psi	2.31 MPa	ASTM D412
Tensile Strength [3, 4] (Break, 73°F (23°C))	583 psi	4.02 MPa	ASTM D412
Tensile Elongation [3, 4] (Break, 73°F (23°C))	610 %	610 %	ASTM D412
Tear Strength [3, 4] (70°F (21°C))	120 lbf/in	21.0 kN/m	ASTM D624
Compression Set			ASTM D395B
73°F (23°C), 22 hr	20 %	20 %	
158°F (70°C), 22 hr	38 %	38 %	
212°F (100°C), 22 hr	43 %	43 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	53	53	ASTM D2240
Flammability	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Flame Rating (0.06 in (1.5 mm))	HB	HB	UL 94

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Fill Analysis	Typical Value (English)	Typical Value (SI)	Test Method
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	5.90 Pa·s	5.90 Pa·s	

Additional Information

Versalloy™ XL 9055X-9 can be recycled as a filler or impact modifier for polyolefins, or can be recycled by grinding and reintroduction to the molding process. Similar to PP or PE recycling process, if separated appropriately, it can be recycled many times.

Municipality waste stream recycle code is "7" which is designated for "Other".

Please contact GLS Thermoplastic Elastomers for a copy of our Recyclability Compliance letter.

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	300 to 370 °F	149 to 188 °C
Middle Temperature	320 to 390 °F	160 to 199 °C
Front Temperature	340 to 410 °F	171 to 210 °C
Nozzle Temperature	340 to 410 °F	171 to 210 °C
Mold Temperature	60 to 80 °F	16 to 27 °C
Back Pressure	0.00 to 80.0 psi	0.00 to 0.552 MPa
Screw Speed	50 to 100 rpm	50 to 100 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 Versalloy™ XL 9055X-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.

Versalloy™ XL 9055X-9 has good melt stability. Maximum residence times may vary, depending on the size of the barrel. Generally, the barrel should be emptied if it is idle for periods of 8 - 10 minutes or longer.

Drying is not Required

Injection Speed: 1 to 5 in/sec
1st Stage - Boost Pressure: 300 to 700 psi
2nd Stage - Hold Pressure: 30% of Boost
Hold Time (Thick Part): 4 to 10 sec
Hold Time (Thin Part): 1 to 3 sec

Notes

[1] Please contact GLS Thermoplastic Elastomers for a copy of the FDA compliance letter.

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

[3] Die C

[4] 2 hr

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