# Versaflex™ XP 2850

## Thermoplastic Elastomer

### Key Characteristics

| Product Description | | |
|---|---|---|
| The Versaflex XP 2850 is designed for improved feel and grip under wet conditions.<br>• Low Specific Gravity<br>• Rubbery Feel, Soft Touch<br>• Tactile Grip, Even When Wet | | |
| **General** | | |
| Material Status | • Commercial: Active | |
| Regional Availability | • North America | |
| Uses | • Soft Touch Grips | |
| Appearance | • Natural Color | |
| Processing Method | • Extrusion | • Injection Molding |

### Technical Properties [1]

| Physical | Typical Value (English) | Typical Value (SI) | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 0.880 | 0.880 | ASTM D792 |
| **Elastomers** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Tensile Stress [2, 3] (300% Strain, 73°F (23°C)) | 445 psi | 3.07 MPa | ASTM D412 |
| Tensile Strength (Break) | 700 psi | 4.83 MPa | ASTM D412 |
| Tensile Elongation [2, 3] (Break, 73°F (23°C)) | 500 % | 500 % | ASTM D412 |
| **Hardness** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Durometer Hardness (Shore A, 10 sec) | 55 | 55 | ASTM D2240 |
| **Fill Analysis** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Apparent Viscosity | | | ASTM D3835 |
| 392°F (200°C), 1340 sec^-1 | 57.2 Pa·s | 57.2 Pa·s | |
| 392°F (200°C), 11200 sec^-1 | 10.1 Pa·s | 10.1 Pa·s | |

### Processing Information

| Injection | Typical Value (English) | Typical Value (SI) |
|---|---|---|
| Suggested Max Regrind | 20 % | 20 % |
| Rear Temperature | 330 to 370 °F | 166 to 188 °C |
| Middle Temperature | 360 to 420 °F | 182 to 216 °C |
| Front Temperature | 370 to 440 °F | 188 to 227 °C |
| Nozzle Temperature | 400 to 470 °F | 204 to 243 °C |
| Processing (Melt) Temp | 380 to 460 °F | 193 to 238 °C |
| Mold Temperature | 50 to 80 °F | 10 to 27 °C |
| Back Pressure | 0.00 to 80.0 psi | 0.00 to 0.552 MPa |
| Screw Speed | 80 to 120 rpm | 80 to 120 rpm |

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## 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 Versaflex XP 2850 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.

Versaflex XP 2850 has excellent 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 4 in/sec
Hold Pressure: 40-60% of peak injection pressure
Hold Time (Thick Part): 2 to 7 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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