Versaflex™ OM 6258-1 Natural EU

Thermoplastic Elastomer

Key Characteristics

Product Description

Versaflex™ OM 6258-1 Natural EU is specifically designed to bond to a variety of standard and modified nylon materials, including those which are glass-filled, heat stabilized and/or impact modified.

Exceptional Colorability
Outstanding Adhesion in Both Two-Shot and Insert Molding Processes
Soft, Rubbery Grip
Very Easy to Process

General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East	• Asia Pacific	• Europe
Features	• Good Adhesion	• Good Colorability	• Good Processability
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density	1.10 g/cm³	1.10 g/cm³	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress - Flow [2]			ISO 37
100% Strain, 73°F (23°C), 0.0787 in (2.00 mm)	305 psi	2.10 MPa	
Tensile Stress - Flow [2]			ISO 37
Break, 73°F (23°C), 0.0787 in (2.00 mm)	450 psi	3.10 MPa	
Tensile Elongation - Flow [2]			ISO 37
Break, 73°F (23°C), 0.0787 in (2.00 mm)	440 %	440 %	
Compression Set (73°F (23°C), 22 hr)	18 %	18 %	ISO 815
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	63	63	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 1340 sec^-1	150 Pa·s	150 Pa·s	
392°F (200°C), 11200 sec^-1	31.0 Pa·s	31.0 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	356 to 392 °F	180 to 200 °C
Middle Temperature	428 to 473 °F	220 to 245 °C
Front Temperature	446 to 491 °F	230 to 255 °C
Nozzle Temperature	473 to 500 °F	245 to 260 °C
Processing (Melt) Temp	446 to 500 °F	230 to 260 °C
Mold Temperature	55 to 85 °F	13 to 29 °C

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Injection	Typical Value (English)	Typical Value (SI)
Back Pressure	0.00 to 80.0 psi	0.00 to 0.552 MPa
Screw Speed	80 to 120 rpm	80 to 120 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
Versaflex™ OM 6258-1 Natural EU 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™ OM 6258-1 Natural EU 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: 3 to 6 in/sec
1st Stage - Boost Pressure: 300 to 800 psi
2nd Stage - Hold Pressure: 0% of Boost
Hold Time (Thick Part): 0 to 4 sec
Hold Time (Thin Part): 0 to 3 sec

Notes

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

[2] 7.9 in/min (200 mm/min)

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