Versaflex™ CE 3115 Black

Thermoplastic Elastomer

Key Characteristics

Product Description			
Versaflex CE 3115 Black is targeted for consumer electronics applications where excellent surface appearance with long-term life, excellent abrasion resistance, performed UV and chemical resistance are required. Versaflex CE 3115 Black can also overmold to a variety of substrates including PC, ABS and PC/ABS.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific		
Features	• Good Processability	• Low Friction	• Pleasing Surface Appearance
Uses	• Consumer Applications	• Electrical/Electronic Applications	• Overmolding
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	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2, 3] (300% Strain, 73°F (23°C))	748 psi	5.16 MPa	ISO 37
Tensile Strength [2, 3] (Break, 73°F (23°C))	2610 psi	18.0 MPa	ISO 37
Tensile Elongation [2, 3] (Break, 73°F (23°C))	650 %	650 %	ISO 37
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	64	64	ISO 48-4
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			Internal Method
392°F (200°C), 11200 sec^-1	16.6 Pa·s	16.6 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 to 0.030 %	0.020 to 0.030 %
Suggested Max Regrind	20 %	20 %
Rear Temperature	340 to 360 °F	171 to 182 °C
Middle Temperature	360 to 430 °F	182 to 221 °C
Front Temperature	370 to 440 °F	188 to 227 °C
Nozzle Temperature	380 to 460 °F	193 to 238 °C
Processing (Melt) Temp	380 to 450 °F	193 to 232 °C
Mold Temperature	55 to 110 °F	13 to 43 °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

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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).

Versaflex CE 3115 Black 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

Injection Speed: 0.5 to 2 in/sec
1st Stage - Boost Pressure: 500 to 1,000 psi
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] 7.9 in/min (200 mm/min)

[3] 2 hr

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