Versaflex™ OM 1060X-9

Thermoplastic Elastomer

Key Characteristics

Product Description

Versaflex™ OM 1060X-9 is an overmolding TPE with very good adhesion to PC or ABS-based plastics.

- Excellent Bond to PC, ABS, PC/ABS
- Good Surface Aesthetics
- Rubbery Feel
- Soft Touch

General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific		
Features	• Good Moldability • Good Processability	• Good Processing Stability • Good Surface Finish	
Uses	• Consumer Applications • Electrical/Electronic Applications	• Flexible Grips • Overmolding	• Power/Other Tools
Agency Ratings	• UL 94		
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	0.930	0.930	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	17 to 27 g/10 min	17 to 27 g/10 min	
200°C/5.0 kg	26 to 36 g/10 min	26 to 36 g/10 min	
Molding Shrinkage - Flow	8.0E-3 to 0.013 in/in	0.80 to 1.3 %	ASTM D955
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2, 3] (100% Strain, 73°F (23°C))	310 psi	2.14 MPa	ASTM D412
Tensile Stress [2, 3] (300% Strain, 73°F (23°C))	470 psi	3.24 MPa	ASTM D412
Tensile Strength [2, 3] (Break, 73°F (23°C))	550 psi	3.79 MPa	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F (23°C))	510 %	510 %	ASTM D412
Tear Strength	150 lbf/in	26.3 kN/m	ASTM D624
Compression Set (73°F (23°C), 22 hr)	29 %	29 %	ASTM D395B
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	60	60	ASTM D2240
Flammability	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Flame Rating (0.06 in (1.5 mm))	HB	HB	UL 94
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	11.7 Pa·s	11.7 Pa·s	

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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 380 °F	182 to 193 °C
Front Temperature	380 to 440 °F	193 to 227 °C
Nozzle Temperature	390 to 450 °F	199 to 232 °C
Processing (Melt) Temp	380 to 440 °F	193 to 227 °C
Mold Temperature	70 to 100 °F	21 to 38 °C
Back Pressure	0.00 to 125 psi	0.00 to 0.862 MPa
Screw Speed	75 to 125 rpm	75 to 125 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 1060X-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.

Versaflex™ OM 1060X-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 5 - 8 minutes or longer.

Drying is not Required

Injection Speed: 1 to 3 in/sec
1st Stage - Boost Pressure: 350 to 800 psi
2nd Stage - Hold Pressure: 30% of Boost
Hold Time (Thick Part): 3 to 10 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

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