Versaflex™ CE 3120-65 GREY

Thermoplastic Elastomer

Key Characteristics

Product Description			
Versaflex™ CE 3120-65 GREY is custom grade where excellent abrasion resistance, chemical resistance and silky feel are required. Versaflex™ CE 3120-65 GREY can also overmold to a variety of substrates including PC, ABS, PC/ABS, and Copolyester.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific		
Features	• Specialty Grade		
Uses	• Consumer Applications	• Overmolding	• Soft Touch Applications
RoHS Compliance	• RoHS Compliant		
Appearance	• Grey		
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	ASTM D792
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2, 3] (300% Strain, 73°F (23°C))	626 psi	4.32 MPa	ASTM D412
Tensile Strength [2, 3] (Break, 73°F (23°C))	1690 psi	11.7 MPa	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F (23°C))	720 %	720 %	ASTM D412
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	65	65	ASTM D2240
Flammability	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Flame Rating			UL 94
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	18.3 Pa·s	18.3 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	140 to 194 °F	60 to 90 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.020 to 0.030 %	0.020 to 0.030 %
Rear Temperature	340 to 360 °F	171 to 182 °C
Middle Temperature	360 to 410 °F	182 to 210 °C
Front Temperature	370 to 420 °F	188 to 216 °C
Nozzle Temperature	380 to 430 °F	193 to 221 °C
Processing (Melt) Temp	380 to 425 °F	193 to 218 °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 50.0 psi	0.00 to 0.345 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).

Versaflex CE 3120-65 GREY 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] Die C

[3] 2 hr

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