

PolyOne Versaflex™ OM 6258-1 Thermoplastic Elastomer (TPE)

Category : Polymer , Thermoplastic , Elastomer , TPE

Material Notes:

Versaflex™ OM 6258-1 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 Color concentrates with EVA or LDPE carriers are most suitable for coloring Versaflex™ OM 6258-1. Typical ratios are 50:1 to 25:1 - loading levels should be as low as possible to minimize the effect on adhesion. A high color match consistency can be obtained by the use of precolored compounds available from GLS. Polypropylene (PP) based color concentrates are not recommended because they can significantly affect adhesion of the TPE to the nylon. Concentrates based on PVC should not be used. The final determination of color concentrate suitability should be determined by customer trials. 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 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 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 5 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 Information provided by PolyOne

Order this product through the following link:

http://www.lookpolymers.com/polymer_PolyOne-Versaflex-OM-6258-1-Thermoplastic-Elastomer-TPE.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.09 g/cc	1.09 g/cc	ASTM D792
Viscosity	31000 cP	31000 cP	ASTM D3835
	@Shear Rate 11200 1/s, Temperature 200 °C	@Shear Rate 11200 1/s, Temperature 392 °F	
Linear Mold Shrinkage, Flow	0.014 - 0.020 cm/cm	0.014 - 0.020 in/in	ASTM D955

Mechanical Properties	Metric	English	Comments
Hardness, Shore A	60	60	10 sec; ASTM D2240
Tensile Strength at Break	2.79 MPa	405 psi	Die C2 hr; ASTM D412
	@Temperature 23.0 °C	@Temperature 73.4 °F	
Tensile Stress	1.90 MPa	276 psi	Die C2 hr; ASTM D412
	@Strain 100 %, Temperature 23.0 °C	@Strain 100 %, Temperature 73.4 °F	
	2.65 MPa	384 psi	Die C2 hr; ASTM D412
	@Strain 300 %,	@Strain 300 %,	

Mechanical Properties	Temperature 23.0 °C Metric	Temperature 73.4 °F English	Comments
Elongation at Break	390 % @Temperature 23.0 °C	390 % @Temperature 73.4 °F	Die C2 hr; ASTM D412
Tear Strength	18.4 kN/m	105 pli	ASTM D624
Compression Set	23 % @Temperature 23.0 °C, Time 79200 sec	23 % @Temperature 73.4 °F, Time 22.0 hour	ASTM D395B

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	182 - 204 °C	360 - 399 °F	
Middle Barrel Temperature	243 - 266 °C	469 - 511 °F	
Front Barrel Temperature	249 - 271 °C	480 - 520 °F	
Nozzle Temperature	254 - 277 °C	489 - 531 °F	
Melt Temperature	249 - 271 °C	480 - 520 °F	
Mold Temperature	12.8 - 29.4 °C	55.0 - 84.9 °F	
Back Pressure	0.000 - 0.552 MPa	0.000 - 80.1 psi	
Screw Speed	80 - 120 rpm	80 - 120 rpm	

Descriptive Properties	Value	Comments
Appearance	Natural Color	
Features	Good Adhesion	
	Good Colorability	
	Good Processability	
Forms	Pellets	
Generic Material	TPE	
Generic Name	Thermoplastic Elastomer (TPE)	
Manufacturer / Supplier	GLS Thermoplastic Elastomers	
Processing Method	Injection Molding	
Regional Availability	Africa & Middle East	
	Asia Pacific	

Descriptive Properties	Europe Value	Comments
	North America	
	South America	
RoHS Compliance	RoHS Compliant	
Suggested Max Regrind	20%	
Uses	Lawn and Garden Equipment	
	Overmolding	
	Power/Other Tools	

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