

Technical Data Sheet

Softflex 0826

Thermoplastic Elastomer
LyondellBasell Industries
Engineering Plastics

Product Description

Softflex 0826 is suitable for overmolding ABS, PC, ABS/PC and PPO.

General

Forms	• Pellets
Processing Method	• Coating • Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	0.954	0.952 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
200°C/5.0 Kg ¹	8.5 g/10 min	8.5 g/10 min	
235°C/1.0 Kg	8.0 g/10 min	8.0 g/10 min	
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Flexural Modulus	820 psi	5.65 MPa	ASTM D790
Taber Abrasion Resistance			ASTM D3389
1000 Cycles, 1000 G, H-22 Wheel	44.0 mg	44.0 mg	
Elastomers	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Set (100% Strain)	7 %	7 %	ASTM D412
Tensile Stress			ASTM D412
50% Strain	121 psi	0.834 MPa	
100% Strain	178 psi	1.23 MPa	
300% Strain	322 psi	2.22 MPa	
Tensile Strength (Yield)	1030 psi	7.11 MPa	ASTM D412
Tensile Elongation (Break)	740 %	740 %	ASTM D412
Tear Strength	145 lbf/in	25.4 kN/m	ASTM D624
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Gardner Impact (-22°F (-30°C))	> 320 in-lb	> 36.2 J	ASTM D5420
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Durometer Hardness			ASTM D2240
Shore A	44 to 50	44 to 50	
Shore A, 10 Sec	38 to 44	38 to 44	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	130 to 140 °F	54 to 60 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Suggested Shot Size	40 to 80 %	40 to 80 %
Rear Temperature	320 to 360 °F	160 to 182 °C
Middle Temperature	340 to 380 °F	171 to 193 °C
Front Temperature	410 to 430 °F	210 to 221 °C
Nozzle Temperature	390 to 420 °F	199 to 216 °C
Processing (Melt) Temp	380 to 410 °F	193 to 210 °C
Mold Temperature	80 to 120 °F	27 to 49 °C
Injection Pressure	5000 to 6000 psi	34.5 to 41.4 MPa
Holding Pressure	4000 to 4500 psi	27.6 to 31.0 MPa
Back Pressure	75.0 to 150 psi	0.517 to 1.03 MPa
Screw Speed	20 to 40 rpm	20 to 40 rpm