Technical Data Sheet

Softflex 6018

Thermoplastic Elastomer
LyondellBasell Industries
Engineering Plastics

Product Description
Softflex 6500 is suitable for overmolding polypropylene and polyethylene.

General	
Uses	• Overmolding
Forms	• Pellets
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity (Natural)	1.18	1.18 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°c/2.16 Kg)	12 g/10 min	12 g/10 min	ASTM D1238
Elastomers	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength [1]			ASTM D412
Yield, 73°f (23°c), 0.125 In (3.18 Mm)	700 psi	4.83 MPa	
Tear Strength	130 lbf/in	22.8 kN/m	ASTM D624
Hardness	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Shore Hardness			ASTM D2240
Shore A, 73°f (23°c), 0.125 In (3.18 Mm), Injection Molded	60	60	
Aging	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Change in Ultimate Elongation	900 %	900 %	ASTM D412

Additional Information
Overmold Bonding To: PP, PE

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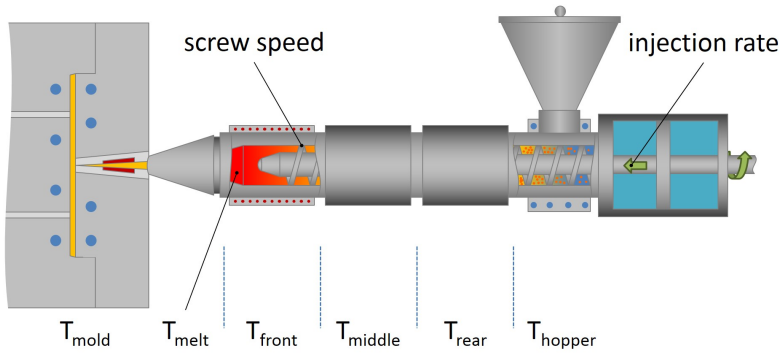

Injection	Nominal Value (English)	Nominal Value (SI)
Rear Temperature	340 to 360 °F	171 to 182 °C
Middle Temperature	370 to 390 °F	188 to 199 °C
Front Temperature	400 to 420 °F	204 to 216 °C
Nozzle Temperature	395 to 415 °F	202 to 213 °C
Mold Temperature	70 to 110 °F	21 to 43 °C
Injection Rate	Moderate-Fast	Moderate-Fast
Back Pressure	90.0 to 175 psi	0.621 to 1.21 MPa
Screw L/D Ratio	20.0:1.0	20.0:1.0
Screw Compression Ratio	1.5:1.0	1.5:1.0

Notes

[1] 20 in/min (510 mm/min)

Notes

These are typical property values not to be construed as specification limits.