

**VS/AD1 Series**
**COPEC®**

The VS/AD1 Series is your material solution for applications in the consumer electronics section. The compounds feature an exceptionally silky and velvety surface, accompanied by excellent adhesion properties to polar thermoplastics such as ABS, PC and PC/ABS.

**Typical applications**

- Game consoles
- Handles and grips for consumer applications
- Headphones
- Remote controls
- Seals

**Material advantages**

- Easy coloring (compounds in natural colors)
- Excellent color stability
- Good weathering resistance
- Insert molding possible
- Pleasant surface feel (Soft touch)
- Resistance against skin oil, sunscreens and olive oil
- Smooth and silky surface
- UL 94 HB listed

**Processing Method:** Extrusion, Injection Molding

	Color / RAL DESIGN	Hardness DIN ISO 7619-1 ShoreA	Density DIN EN ISO 1183-1 g/cm <sup>3</sup>	Tensile Strength <sup>1</sup> DIN 53504/ISO 37 MPa	Elongation at Break <sup>1</sup> DIN 53504/ISO 37 %	Tear Resistance ISO 34-1 Methode B (b)(Graves) N/mm	CS 72 h/23 °C DIN ISO 815-1 Method A %	CS 24 h/70 °C DIN ISO 815-1 Method A %	CS 24 h/100 °C DIN ISO 815-1 Method A %	Adhesion to ABS <sup>2</sup> VDI 2019 two-component injection molding N/mm	Adhesion to PC <sup>2</sup> VDI 2019 two-component injection molding N/mm
<b>CC60CN</b>	natural	60	1.260	6.0	1000	23.5	21	51	76	5.5 (A)	5.5 (A)
<b>CC60CZ</b>	black	59	1.260	5.5	900	23.5	18	52	72	6.0 (D)	5.5 (B)
<b>CC70CN</b>	natural	67	1.290	6.5	1000	28.0	15	51	70	7.0 (D)	8.0 (D)
<b>CC70CZ</b>	black	68	1.280	6.5	900	28.0	16	52	70	8.5 (B/D)	8.0 (B/D)
<b>CC80CN</b>	natural	78	1.330	8.5	850	35.0	21	52	73	10.5 (D)	10.0 (B/D)
<b>CC80CZ</b>	black	78	1.310	8.5	900	35.0	18	57	69	10.5 (D)	10.0 (D)

<sup>1</sup> Deviating from ISO 37 standard test piece S2 is tested with a traverse speed of 200 mm/min.

<sup>2</sup> The adhesion quality depends on mold design, product geometry and process parameters.

Please note: Frozen stresses in Polycarbonate (PC) may cause stress cracking in 2-component applications with PC and COPEC®.

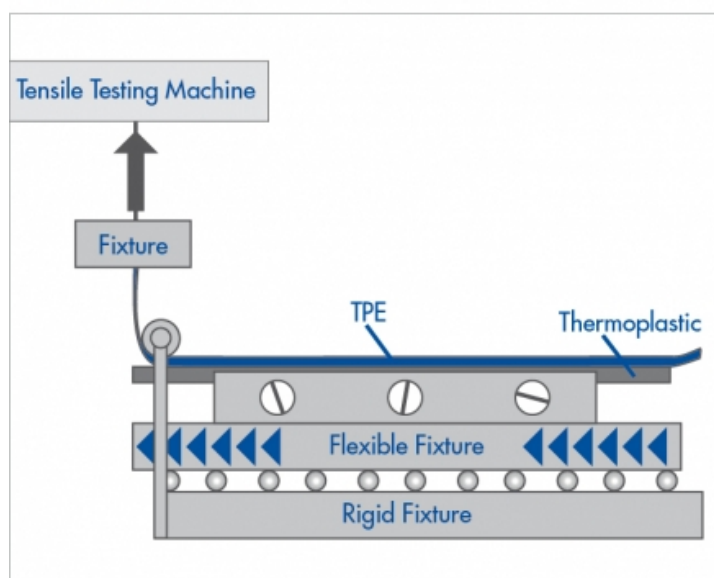


All values published in this data sheet are rounded average values.

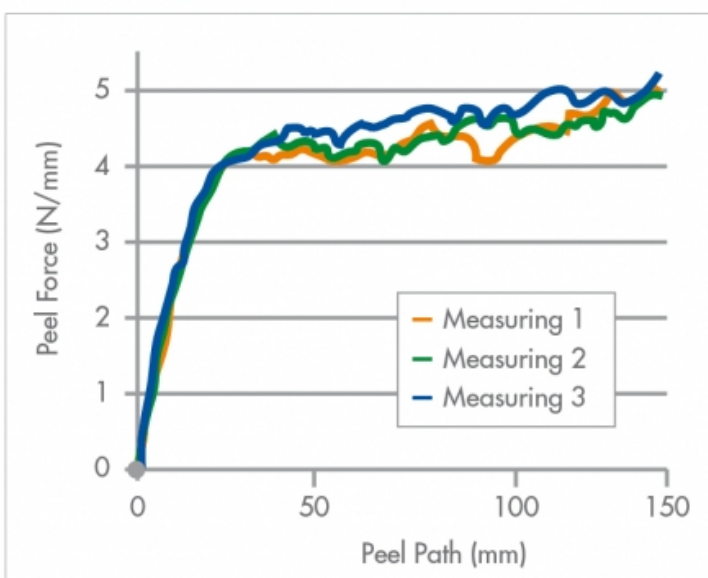
## Description peel test

# Peel test according to VDI guide line 2019

## Test Setup



## Example diagram for results of a peel test



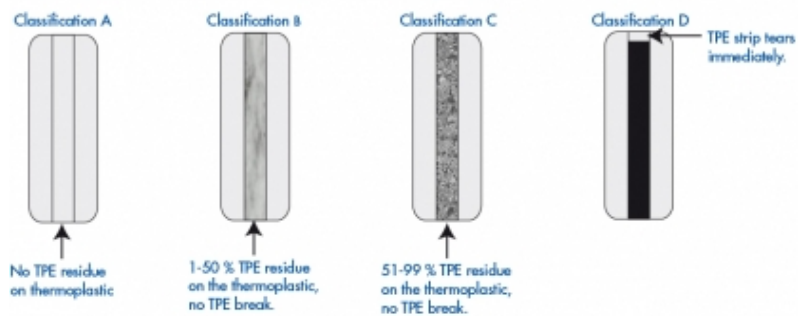
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Classification

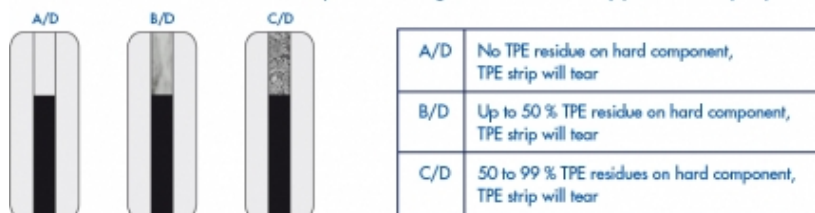
Peel test according to VDI Guideline 2019

For the VDI peel test we add two characters to the peel force value.  
The first character describes the TPE residue on the hard component.



A	No TPE residue on hard component
B	Up to 50 % TPE residue on hard component
C	50 to 99 % TPE residue on hard component
D	TPE strip tears immediately

The second character describes if the TPE strip will tear during the measurement at any position on the peel path.



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**Processing Guideline Injection Molding**

Cylinder temperature	180 - 190 - 200 °C, max. 220 °C (360 - 370 - 390 °F, max. 425 °F)
Hotrunner	Hot runner temperatures: 180 - 220 °C (356 - 428 °F). The runner should be empty after a maximum of 2 - 3 shots.
Injection pressure	200 - 1000 bar (2900 - 14504 psi) (depending on the size and weight of the part).
Injection rate	In general, the fill time should not be more than 1–2 seconds.
Hold pressure	We recommend to derive the optimum hold pressure from determining the solidification point, starting with 40 % - 60 % of the required injection pressure.
Back pressure	20 - 100 bar; if color batches are used, higher back pressure is necessary.
Screw retraction	If an open nozzle is used processing with screw retraction is advisable.
Mold temperature	The mold temperature depends on the hard component. A temperature exceeding 80 °C (175 °F) should be avoided. The common temperature is 40 - 60 °C (105 - 140° F).
Predrying	To maintain a high level of mechanical properties the resin must be pre-dried. The use of a desiccant dehumidifying dryer is recommended. Drying conditions: 80 °C for 2-6 hrs; maximum dew point of the inlet air: -25 °C. The maximum residual moisture of the material should not exceed 0,02%.
Needle valve	The use of a needle valve nozzle is advisable .
Screw geometry	Standard 3-zone polyolefine screw.
Residence time	The residence time is to be set as short as possible with a maximum of 10 minutes.
Cleaning recommendation	For cleaning and purging of the machine it is appropriate to use polypropylene or polyethylene. Machine must be PVC-free.



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**Processing Guideline Extrusion**

Cylinder temperature	160 - 180 - 200 °C (320 - 360 - 390 °F). For Coextrusion with engineering thermoplastics temperature profile should be increased up to 30 °C (85 °F); maximum 230 °C (440 °F)
Screw geometry	Standard three-zone screw (e.g. polyolefin screw). The screw must be able to provide sufficient shearing.
L/D ratio	At least 25
Compression ratio	At least 3 : 1
Screens / breaker plate	A breaker plate and a screen pack are generally recommended in the extruder configuration in order to increase pressure.
Die land	<= 3 mm ( <= 0,12 in.)
Extruder Head	Ca. 220 °C (430 °F)
Die temperature	Ca. 220 °C (430 °F)
Predrying	Drying of the material for at least four hours at 80°C (175°F) is recommended. The moisture level of material has to be below 0.02 %. To avoid porosity in the profile a pre drying is recommended for wall thickness > 3mm.
Calibration	Generally not necessary; support elements may be required when extruding THERMOLAST® compounds with high hardness or when coextruding with standard thermoplastics.
Cleaning recommendation	For cleaning and purging of the machine it is appropriate to use polypropylene or polyethylene. Machine must be PVC-free.

