产品比较

Technical Data

产品说明	
Versaflex™ CE 3120-80 Black	Versaflex CE 3120-80 Black is a customized grade designed for overmolding onto polycarbonate (PC), ABS,PC/ABS substrates.
Versaflex™ CE 3120-80N	Versaflex™ CE 3120-80N is targeted for consumer electronics applications where excellent abrasion resistance, chemical resistance and silky feel are required. Versaflex™ CE 3120-80N can also overmold to a variety of substrates including PC, ABS, PC/ABS, and Copolyester.

总览	Versaflex™ CE 3120-80 Black	Versaflex™ CE 3120-80N
生产商/供应商	• 普立万公司	• 普立万公司
通用符号	• TPE	• TPE
特性	• 耐紫外光安定化 • 柔软	• 特殊规格
用途	• 包覆成型 • 电气/电子应用领域 • 消费品应用领域	• 包覆成型 • 柔软触感应用 • 消费品应用领域
机构评级	• UL 94	• UL 94
RoHS 合规性	• RoHS 合规	• RoHS 合规
外观	• 黑色	• 自然色
形式	• 粒子	• 粒子
加工方法	• 注射成型	• 注射成型

物理性能	Versaflex™ CE 3120-80 Black	Versaflex™ CE 3120-80N	单位制	测试方法
密度 / 比重	1.09	1.08	g/cm³	ASTM D792
收缩率 - 流动	--	0.20 到 0.80	%	ASTM D955
弹性体	**Versaflex™ CE 3120-80 Black**	**Versaflex™ CE 3120-80N**	**单位制**	**测试方法**
拉伸应力 [3]				ASTM D412
300%应变, 23°C [4]	6.18	--	MPa	
300%应变, 23°C [5]	--	6.89	MPa	
抗张强度 [3]				ASTM D412
断裂, 23°C [4]	20.9	--	MPa	
断裂, 23°C [5]	--	13.5	MPa	
伸长率 [3]				ASTM D412
断裂, 23°C [4]	840	--	%	
断裂, 23°C [5]	--	750	%	
硬度	**Versaflex™ CE 3120-80 Black**	**Versaflex™ CE 3120-80N**	**单位制**	**测试方法**
肖氏硬度				ASTM D2240
邵氏 A, 10 秒, 23°C	77	--		
邵氏 A, 10 秒	--	79		
充模分析	**Versaflex™ CE 3120-80 Black**	**Versaflex™ CE 3120-80N**	**单位制**	**测试方法**
表观粘度 (200°C, 11200 sec^-1)	36.0	32.0	Pa·s	ASTM D3835

产品比较

注射	Versaflex™ CE 3120-80 Black	Versaflex™ CE 3120-80N	单位制
干燥温度	80 到 90	49 到 60	°C
干燥时间	3.0 到 4.0	3.0 到 4.0	hr
建议的最大水分含量	< 0.040	0.020 到 0.030	%
料筒后部温度	170 到 180	177 到 188	°C
料筒中部温度	175 到 200	182 到 199	°C
料筒前部温度	185 到 210	188 到 216	°C
射嘴温度	190 到 220	193 到 221	°C
加工（熔体）温度	180 到 220	193 到 218	°C
模具温度	10 到 50	13 到 54	°C
背压	0.100 到 1.50	0.00 到 0.345	MPa
螺杆转速	50 到 80	50 到 80	rpm

注射说明	
Versaflex™ CE 3120-80 Black	Versaflex CE 3120-80 Black must be dried in the dehumidification dryer and the dewpoint must be set at -40°C or below.The molecular sieve of dehumidification dryer should be active.This material should not be left in the barrel for extened idle periods (greater than 5 minutes). Hot Runners :190 to 226°C Hot tip:190 to 232°C Injection speed: low to middle, suggested: 12 to 45 mm/s 1st stage -Boost Pressure: 500 to 1200 psi 2nd stage- Hold pressure: 20 to 60% of Boost Hold time (Thick Part): 2 to 4 sec Hold time (Thin Part) 1 to 2 sec The injection parameters here mentioned is typical value based on our experience, the user are suggested to pay attention and optimize the parameters according to the exact application.
Versaflex™ CE 3120-80N	Typical colorant letdown 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. Concentrates based on PVC should not be used. The final determination of color concentrate suitability should be determined by customer trials. Contact GLS for more information on appropriate color concentrate base resins. 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 3120-80N 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