VERSAFLEX™ OM 1060X-1
GLS Corp., Thermoplastic Elastomers Div. - Thermoplastic Elastomer

Tuesday, April 29, 2008

General Information

Product Description

Versaflex® OM 1060X-1 is a cost-effective overmolding TPE with very good adhesion to PC or ABS-based plastics.

General

Material Status	• Commercial: Active	
Regional Availability	• Africa & Middle East • Asia Pacific • Europe	• North America • South America
Features	• Adhesion, Good • Appearance, Pleasing Surface	• Bondability • Soft
Uses	• Overmolding	
Appearance	• Natural Color	
Forms	• Pellets	
Processing Method	• Injection Molding	

ASTM and ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.930		ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
(190°C/2.16 kg)	19		
(200°C/5.0 kg)	29		
Molding Shrink (Flow)	1.0 to 1.6		ASTM D955

Elastomers	Nominal Value	Unit	Test Method
Tensile Stress at 100% (73.4 °F)	310		ASTM D412 [2]
Tensile Stress at 300% (73.4 °F)	500		ASTM D412 [2]
Tensile Strength at Break (73 °F)	520		ASTM D412 [2]
Elongation at Break (73.4 °F)	410		ASTM D412 [2]
Tear Strength	150		ASTM D624
Compression Set (22.0 hr)	29		ASTM D395 [3]

Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	60		ASTM D2240

Processing Information

Injection	Nominal Value	Unit
Suggested Max Regrind	20	
Rear Temperature	330 to 370	
Middle Temperature	360 to 390	
Front Temperature	380 to 440	
Nozzle Temperature	410 to 460	
Processing (Melt) Temp	380 to 430	
Mold Temperature	70.0 to 100	
Injection Pressure	300 to 900	
Back Pressure	0.00 to 125	
Screw Speed	75 to 125	

Injection Notes
Holding Pressure: 50-70% of Injection Pressure
Injection Velocity: 1 to 3 in/sec
Hold Time (Thick Part): 3 to 10 sec
Hold Time (Thin Part): 1 to 3 sec

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] Die C

[3] Method B