



General Information

Product Description

The VERSAFLEX® OM 1245X-1 is designed for overmolding onto polycarbonate (PC), ABS, and PC/ABS substrates.

General

Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Regional Availability	<ul style="list-style-type: none"> <li>Africa &amp; Middle East</li> <li>Asia Pacific</li> <li>Europe</li> <li>North America</li> <li>South America</li> </ul>
Features	<ul style="list-style-type: none"> <li>Bondability</li> <li>Soft</li> </ul>
Uses	<ul style="list-style-type: none"> <li>Decorative Parts</li> <li>Electrical/Electronic Applications</li> <li>Grips, Flexible</li> <li>Handles</li> <li>Household Goods</li> <li>Tools, Power/Others</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Natural Color</li> </ul>
Forms	<ul style="list-style-type: none"> <li>Pellets</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

ASTM and ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.940		ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
(190°C/2.16 kg)	2.0		
(200°C/5.0 kg)	45		
Molding Shrink (Flow )	1.4 to 1.8		ASTM D955
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress at 100% (73.4 °F )	260		ASTM D412 <sup>2</sup>
Tensile Stress at 300% (73.4 °F )	560		ASTM D412 <sup>2</sup>
Tensile Strength at Break (73 °F )	940		ASTM D412 <sup>2</sup>
Elongation at Break (73.4 °F )	490		ASTM D412 <sup>2</sup>
Compression Set (22.0 hr )	31		ASTM D395 <sup>3</sup>
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec )	45		ASTM D2240

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	110 to 115	
Drying Time	3.0 to 4.0	
Suggested Max Moisture	0.10	
Suggested Max Regrind	20	
Rear Temperature	320 to 380	
Middle Temperature	350 to 380	
Front Temperature	360 to 400	
Nozzle Temperature	380 to 420	
Processing (Melt) Temp	360 to 420	
Mold Temperature	70.0 to 90.0	
Injection Pressure	100 to 800	

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Back Pressure	0.00 to 125
Screw Speed	75 to 125

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**Injection Notes**

Holding Pressure: 30% of Boost  
Injection Velocity: 1 to 3 in/sec  
Hold Time (Thick Part): 4 to 10 sec  
Hold Time (Thin Part): 1 to 3 sec  
Suggested Dewpoint: -40°F

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**Notes**

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<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> Die C

<sup>3</sup> Method B

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