The Leader in Total TPE Solutions

Versaflex® OM 6240-1

Thermoplastic Elastomer Compound

Technical Data Sheet

February 27, 2008

Product Description	Features
Versaflex® OM 6240-1 is specifically designed to bond to a variety of standard and modified nylon materials, including those which are glass-filled, heat stabilized and/or impact modified. New Product. Commercial specifications have not been established.	-Outstanding Adhesion in Both Two-Shot and Insert Molding Processes -Soft, Rubbery Grip -Very Easy to Process -Exceptional Colorability
Color	**Processing Method**
Natural	Injection Molding

Mechanical Properties	English	SI	Test Method
Shore Hardness, 10 sec delay	42 A	42 A	ASTM D2240
Specific Gravity	1.10	1.10	ASTM D792, 23/23°C
Tensile Strength	290 psi	1999 kPa	ASTM D412-Die C, 2hrs,23°C
Elongation at Break	500 %	500 %	ASTM D412-Die C, 2hrs,23°C
100% Modulus	150 psi	1034 kPa	ASTM D412-Die C, 2hrs,23°C
300% Modulus	265 psi	1827 kPa	ASTM D412-Die C, 2hrs,23°C
Tear Strength	90 pli	16 kN/m	ASTM D624

Thermal/Rheological Properties	English	SI	Test Method
Apparent Viscosity @ 200°C 11170/sec	31900 cPs	32 Pa-sec	ASTM D 3835

Aged Properties	English	SI	Test Method
Compression Set, 22 hrs @ RT	22 %	22 %	ASTM D 395B

Coloring

Color concentrates with EVA or LDPE carriers are most suitable for coloring Versaflex® OM 6240-1. Typical 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. Polypropylene (PP) based color concentrates are not recommended because they can significantly affect adhesion of the TPE to the nylon. Concentrates based on PVC should not be used. The final determination of color concentrate suitability should be determined by customer trials.

Purging

Purge thoroughly before and after use of this product with a low flow (0.5 - 2.5 MFR) polyethylene (PE) or polypropylene (PP).

Regrind

Regrind levels up to 20% can be used with Versaflex® OM 6240-1 with minimal property loss, provided that the regrind is free of contamination. To minimize losses during molding, the melt temperature should remain as low as possible. The final determination of regrind effectiveness should be determined by the customer.

Shrinkage Properties	English	SI	Test Method
Flow	0.019 - 0.026 in/in	0.019 - 0.026 mm/mm	ASTM D 955

Residence Time

Versaflex® OM 6240-1 has good melt stability. Maximum residence times may vary, depending on the size of the barrel. Generally, the barrel should be emptied if it is idle for periods of 8 - 10 minutes or longer.

Drying Time	**English**	**SI**
Drying is not Required		

Molding Temperatures	**English**	**SI**
Rear	360 - 400 °F	182 - 204 °C
Center	470 - 410 °F	243 - 210 °C
Front	480 - 520 °F	249 - 271 °C
Nozzle	490 - 530 °F	254 - 277 °C
Melt	480 - 520 °F	249 - 271 °C
Mold	55 - 85 °F	13 - 29 °C

Molding Parameters	**English**	**SI**
Screw Speed	80 - 120 rpm	80 - 120 rpm
Injection Speed	3 - 5 in/sec	76 - 127 mm/sec
1st Stage - Boost Pressure	300 - 800 psi	2068 - 5516 kPa
2nd Stage - Hold Pressure	0 % of Boost	50 % of Boost
Back Pressure	0 - 80 psi	0 - 552 kPa

Hold Time (Thick Part)	0 - 4 sec	0 - 4 sec
Hold Time (Thin Part)	0 - 3 sec	0 - 3 sec