



The Leader in Total TPE Solutions

Versaflex® OM 6258-1

Thermoplastic Elastomer Compound

Technical Data Sheet

May 8, 2008

<p><u>Product Description</u></p> <p>Versaflex® OM 6258-1 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.</p> <p>New Product. Commercial specifications have not been established.</p>	<p><u>Features</u></p> <ul style="list-style-type: none"> -Outstanding Adhesion in Both Two-Shot and Insert Molding Processes -Soft, Rubbery Grip -Very Easy to Process -Exceptional Colorability
<p><u>Color</u></p> <p>Natural</p>	<p><u>Processing Method</u></p> <p>Injection Molding</p>

Mechanical Properties	English	SI	Test Method
Shore Hardness, 10 sec delay	60 A	60 A	ASTM D2240
Specific Gravity	1.09	1.09	ASTM D792, 23/23°C
Tensile Strength	405 psi	2792 kPa	ASTM D412-Die C, 2hrs,23°C

Elongation at Break	390 %	390 %	ASTM D412-Die C, 2hrs,23°C
100% Modulus	275 psi	1896 kPa	ASTM D412-Die C, 2hrs,23°C
300% Modulus	385 psi	2654 kPa	ASTM D412-Die C, 2hrs,23°C
Tear Strength	105 pli	18 kN/m	ASTM D624

Thermal/Rheological Properties	English	SI	Test Method
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Apparent Viscosity @ 200°C 11170/sec	31000 cPs	31 Pa-sec	ASTM D 3835
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Aged Properties	English	SI	Test Method
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Compression Set, 22 hrs @ RT	23 %	23 %	ASTM D 395B
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Coloring

Color concentrates with EVA or LDPE carriers are most suitable for coloring Versaflex® OM 6258-1. 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 6258-1 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

0.014 - 0.020 in/in

0.014 - 0.020 mm/mm

ASTM D 955

Residence Time

Versaflex® OM 6258-1 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
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Drying is not Required

Molding Temperatures	English	SI
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Rear	360 - 400 °F	182 - 204 °C
Center	470 - 510 °F	243 - 266 °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