



General Information

Product Description

Versaflex® OM 9-801N is designed for overmolding onto a wide variety of substrates including PC, ABS, PC/ABS, HIPS, PPO, HDPE, acetal, acrylic and copolyester.

New Product. Commercial specifications have not been established.

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>Appearance, Pleasing Surface</li> <li>Bondability</li> <li>Soft</li> </ul>
Uses	<ul style="list-style-type: none"> <li>Overmolding</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	1.04		ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
(190°C/2.16 kg)	22		
(200°C/5.0 kg)	100		
Molding Shrink (Flow )	0.30 to 0.90		ASTM D955
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress at 100% (73.4 °F )	210		ASTM D412 <sup>2</sup>
Tensile Stress at 300% (73.4 °F )	290		ASTM D412 <sup>2</sup>
Tensile Strength at Break (73 °F )	610		ASTM D412 <sup>2</sup>
Elongation at Break (73.4 °F )	750		ASTM D412 <sup>2</sup>
Tear Strength	100		ASTM D624
Compression Set (22.0 hr )	43		ASTM D395 <sup>3</sup>
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec )	47		ASTM D2240
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (392 °F, 11200 sec <sup>-1</sup> )	16.0		ASTM D3835

Processing Information

Injection	Nominal Value	Unit
Suggested Max Re grind	20	
Rear Temperature	360 to 380	
Middle Temperature	370 to 395	
Front Temperature	380 to 400	
Nozzle Temperature	390 to 425	
Mold Temperature	70.0 to 100	

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Injection Pressure	500 to 900
Back Pressure	25.0 to 50.0
Screw Speed	75 to 125

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**Injection Notes**

Holding Pressure: 70% of Boost  
Injection Velocity: 0.5 to 3 in/sec  
Hold Time (Thick Part): 4 to 10 sec  
Hold Time (Thin Part): 1 to 3 sec

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**Notes**

<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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