



General Information

Product Description

Versaflex® OM 9-802CL is a clear, soft touch TPE designed to bond to the following thermoplastics: PC, ABS, PC/ABS 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>Adhesion, Good</li> <li>Bondability</li> <li>Clarity, High</li> <li>Soft</li> </ul>
Uses	<ul style="list-style-type: none"> <li>Bonding</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Clear/Transparent</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	0.930		ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
(190°C/2.16 kg)	24		
(200°C/5.0 kg)	100		
Molding Shrink (Flow)	0.40 to 1.1		ASTM D955
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress at 100% (73.4 °F)	230		ASTM D412 <sup>2</sup>
Tensile Stress at 300% (73.4 °F)	310		ASTM D412 <sup>2</sup>
Tensile Strength at Break (73 °F)	930		ASTM D412 <sup>2</sup>
Elongation at Break (73.4 °F)	1100		ASTM D412 <sup>2</sup>
Tear Strength	140		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)	40		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 Regrind	20	
Rear Temperature	330 to 370	
Middle Temperature	360 to 400	
Front Temperature	380 to 410	
Nozzle Temperature	380 to 410	
Mold Temperature	70.0 to 80.0	
Injection Pressure	300 to 600	
Back Pressure	0.00 to 90.0	

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Screw Speed

25 to 75

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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

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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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