



<p>Product Description</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>Features</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>Color</p> <p>Natural</p>	<p>Processing Method</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
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
Apparent Viscosity @ 200°C 11170/sec	31000 cPs	31 Pa-sec	ASTM D 3835

Aged Properties

	English	SI	Test Method
Compression Set, 22 hrs @ RT	23 %	23 %	ASTM D 395B

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

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

Residence Time

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.

Drying Time

Drying is not Required

English**SI****Molding Temperatures**

	English	SI
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

Notes

The properties shown are typical values and are not intended as product specifications.

The test methods referenced are modifications of the ASTM procedures listed. All tests are conducted on injection molded samples.

No warranties, expressed or implied, including patent warranties, or warranties of merchantability or fitness for use, are made with respect to the product information described above.

VERSAFLEX® is a registered trademark of GLS Corporation.

New Product. Commercial specifications have not been formalized.



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