

# Versaflex™ OM 6258-1

Thermoplastic Elastomer

Avient Corporation

**PROSPECTOR®**

www.ulprospector.com

## Technical Data

### Product Description

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.

- Exceptional Colorability
- Outstanding Adhesion in Both Two-Shot and Insert Molding Processes
- Soft, Rubbery Grip
- Very Easy to Process

### General

Material Status	• Commercial: Active
Literature <sup>1</sup>	• <a href="#">Technical Datasheet</a>
Search for UL Yellow Card	• <a href="#">Avient Corporation</a> • <a href="#">Versaflex™</a>
Availability	• Africa & Middle East • Asia Pacific • Latin America • North America
Features	• Good Adhesion • Good Colorability • Good Processability
Uses	• Lawn & Garden Equipment • Overmolding • Power/Other Tools
RoHS Compliance	• RoHS Compliant
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Physical	Nominal Value Unit	Test Method
Density / Specific Gravity	1.09 g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow	1.4 to 2.0 %	ASTM D955

Elastomers	Nominal Value Unit	Test Method
Tensile Stress <sup>3, 4</sup>		ASTM D412
100% Strain, 23°C	1.90 MPa	
300% Strain, 23°C	2.65 MPa	
Tensile Strength <sup>3, 4</sup> (Break, 23°C)	2.76 MPa	ASTM D412
Tensile Elongation <sup>3, 4</sup> (Break, 23°C)	350 %	ASTM D412
Tear Strength	18.4 kN/m	ASTM D624
Compression Set (23°C, 22 hr)	23 %	ASTM D395B

Hardness	Nominal Value Unit	Test Method
Durometer Hardness (10 sec)	62	ASTM D2240

Fill Analysis	Nominal Value Unit	Test Method
Apparent Viscosity (200°C, 11200 sec <sup>-1</sup> )	31.6 Pa·s	ASTM D3835

Injection	Nominal Value Unit
Suggested Max Regrind	20 %
Rear Temperature	182 to 204 °C
Middle Temperature	243 to 266 °C
Front Temperature	249 to 271 °C
Nozzle Temperature	254 to 277 °C
Processing (Melt) Temp	249 to 271 °C



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Injection	Nominal Value Unit
Mold Temperature	13 to 29 °C
Back Pressure	0.00 to 0.552 MPa
Screw Speed	80 to 120 rpm

## Injection Notes

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

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.

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 is not Required

Injection Speed: 3 to 6 in/sec

1st Stage - Boost Pressure: 300 to 800 psi

2nd Stage - Hold Pressure: 0% of Boost

Hold Time (Thick Part): 0 to 4 sec

Hold Time (Thin Part): 0 to 3 sec

## Notes

<sup>1</sup> These links provide you with access to supplier literature. We work hard to keep them up to date; however you may find the most current literature from the supplier.

<sup>2</sup> Typical properties: these are not to be construed as specifications.

<sup>3</sup> Die C

<sup>4</sup> 2 hr

