

Technical Data Sheet

Softflex 0954 1402 BLACK



Thermoplastic Elastomer

Product Description

Softflex 0954 1402 BLACK is a Thermoplastic Elastomer material and is typically used in Coating, Injection Molding applications.

Processing Method Coating; Injection Molding

Forms Pellets

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate			
(200 °C/5.0 kg, Procedure A)	21	g/10 min	ASTM D1238
(235 °C/1.0 kg, Procedure A)	19	g/10 min	ASTM D1238
Density - Specific Gravity	1.09	g/cm ³	ASTM D792
Mechanical			
Tensile Stress at 100%	3.27	MPa	ASTM D412
Tensile Stress at 300%	4.9	MPa	ASTM D412
Tensile Stress at 50%	2.57	MPa	ASTM D412
Tensile Set, (100%)	7	%	ASTM D412
Tensile Strength at Yield, (510 mm/min)	9.54	MPa	ASTM D412
Tensile Elongation at Break	810	%	ASTM D412
Tear Strength	45.5	kN/m	ASTM D624
Impact			
Gardner Impact, (-30 °C)	>36.2	J	ASTM D5420
Hardness			
Durometer Hardness			
(Shore A)	68 to 78		ASTM D2240
(Shore A, 10 sec)	64 to 74		ASTM D2240
Additional Information			
Compression Set			
(100 °C, 22 hr, Method B)	96	%	ASTM D395
(23 °C, 22 hr, Method B)	24	%	ASTM D395
(70 °C, 22 hr, Method B)	78	%	ASTM D395
Taber Abrasion Resistance, (H-22 Wheel, 1000 g, 1000 Cycles)	238	mg	ASTM D3389

Injection Parameters	Nominal Value	Units
Drying Time	4.0 to 6.0	hr
Drying Temperature	54 to 60	°C
Nozzle Temperature	199 to 216	°C
Screw Speed	20 to 40	rpm
Processing (Melt) Temp	193 to 210	°C
Front Temperature	210 to 221	°C
Holding Pressure	27.6 to 31.0	MPa
Suggested Shot Size	40 to 80	%
Middle Temperature	171 to 193	°C
Rear Temperature	160 to 182	°C
Back Pressure	0.517 to 1.03	MPa
Mold Temperature	27 to 49	°C
Injection Pressure	34.5 to 41.4	MPa