



# Versaflex™ OM6360B

## Thermoplastic Elastomer

### Key Characteristics

#### Product Description

Versaflex™ OM 6360B 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.

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

#### General

Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Adhesion • Good Processability		
Uses	• Lawn and Garden Equipment	• Overmolding	• Power/Other Tools
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

### Technical Properties <sup>1</sup>

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.09	1.09 g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow	0.016 to 0.022 in/in	1.6 to 2.2 %	ASTM D955
Elastomers	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Stress <sup>2, 3</sup> (100% Strain, 73°F (23°C))	250 psi	1.72 MPa	ASTM D412
Tensile Stress <sup>2, 3</sup> (300% Strain, 73°F (23°C))	320 psi	2.21 MPa	ASTM D412
Tensile Strength <sup>2, 3</sup> (Break, 73°F (23°C))	370 psi	2.55 MPa	ASTM D412
Tensile Elongation <sup>2, 3</sup> (Break, 73°F (23°C))	780 %	780 %	ASTM D412
Tear Strength	131 lbf/in	22.9 kN/m	ASTM D624
Compression Set (73°F (23°C), 22 hr)	25 %	25 %	ASTM D395B
Hardness	Typical Value (English)	Typical Value (SI)	Test Method
Durometer Hardness (Shore A, 10 sec)	60	60	ASTM D2240
Fill Analysis	Typical Value (English)	Typical Value (SI)	Test Method
Apparent Viscosity 392°F (200°C), 11200 sec <sup>-1</sup>	32.5 Pa·s	32.5 Pa·s	ASTM D3835

### Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	360 to 400 °F	182 to 204 °C
Middle Temperature	470 to 510 °F	243 to 266 °C
Front Temperature	480 to 520 °F	249 to 271 °C
Nozzle Temperature	490 to 530 °F	254 to 277 °C

Copyright © 2015 PolyOne Corporation. PolyOne makes no representations, guarantees, or warranties of any kind with respect to the Information contained in this document about its accuracy, suitability for particular applications, or the results obtained or obtainable using the information. Some of the Information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as "typical" or stated without a range do not state minimum or maximum properties; consult your sales representative for property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the Information. PolyOne makes no warranties or guarantees respecting suitability of either PolyOne's products or the Information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the Information and/or use or handling of any product. POLYONE MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the Information or products reflected by the Information. This data sheet shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner.

Injection	Typical Value (English)	Typical Value (SI)
Processing (Melt) Temp	480 to 520 °F	249 to 271 °C
Mold Temperature	55.0 to 85.0 °F	12.8 to 29.4 °C
Back Pressure	0.00 to 80.0 psi	0.00 to 0.552 MPa
Screw Speed	80 to 120 rpm	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 6360B 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 6360B 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 5 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> Typical values are not to be construed as specifications.

<sup>2</sup> Die C

<sup>3</sup> 2 hr

**CONTACT INFORMATION****Americas**

United States - Avon Lake  
 +1 440 930 1000

United States - McHenry  
 +1 815 385 8500

**Asia**

China - Guangzhou  
 +86 20 8732 7260

China - Shenzhen  
 +86 755 2969 2888

China - Suzhou  
 +86 512 6823 24 38

China - Suzhou  
 +86 512 6265 2600

Hong Kong -  
 +852 2690 5332

Taiwan - Yonghe City,  
 +886 9396 99740, +886 2929 1849

**Europe**

Germany - Gaggenau  
 +49 7225 6802 0

Spain - Barbastro (Huesca)  
 +34 974 310 314



*Beyond Polymers.*

*Better Business Solutions. SM*

www.polyone.com

**PolyOne Americas**

33587 Walker Road  
 Avon Lake, Ohio 44012  
 United States  
 +1 440 930 1000  
 +1 866 POLYONE

**PolyOne Asia**

No. 88 Guoshoujing Road  
 Z.J Hi-tech Park, Pudong  
 Shanghai, 201203, China  
 +86 21 5080 1188

**PolyOne Europe**

6 Giällewee  
 +352 269 050 35

Copyright ©, 2015 PolyOne Corporation. PolyOne makes no representations, guarantees, or warranties of any kind with respect to the Information contained in this document about its accuracy, suitability for particular applications, or the results obtained or obtainable using the information. Some of the Information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as "typical" or stated without a range do not state minimum or maximum properties; consult your sales representative for property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the Information. PolyOne makes no warranties or guarantees respecting suitability of either PolyOne's products or the Information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the Information and/or use or handling of any product. POLYONE MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the Information or products reflected by the Information. This data sheet shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner.