

Technical Data Sheet

Softflex 6018

Thermoplastic Elastomer
 LyondellBasell Industries
 Engineering Plastics

Product Description

Softflex 6500 is suitable for overmolding polypropylene and polyethylene.

General

| | |
|-------------------|---------------------|
| Uses | • Overmolding |
| Forms | • Pellets |
| Processing Method | • Injection Molding |

| Physical | Nominal Value (English) | Nominal Value (SI) | Test Method |
|---|-------------------------|------------------------|-------------|
| Density / Specific Gravity (Natural) | 1.18 | 1.18 g/cm ³ | ASTM D792 |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 Kg) | 12 g/10 min | 12 g/10 min | ASTM D1238 |

| Elastomers | Nominal Value (English) | Nominal Value (SI) | Test Method |
|--|-------------------------|--------------------|-------------|
| Tensile Strength ¹ | | | ASTM D412 |
| Yield, 73°F (23°C), 0.125 In (3.18 Mm) | 700 psi | 4.83 MPa | |
| Tear Strength | 130 lbf/in | 22.8 kN/m | ASTM D624 |

| Hardness | Nominal Value (English) | Nominal Value (SI) | Test Method |
|--|-------------------------|--------------------|-------------|
| Shore Hardness | | | ASTM D2240 |
| Shore A, 73°F (23°C), 0.125 In (3.18 Mm), Injection Molded | 60 | 60 | |

| Aging | Nominal Value (English) | Nominal Value (SI) | Test Method |
|-------------------------------|-------------------------|--------------------|-------------|
| Change in Ultimate Elongation | 900 % | 900 % | ASTM D412 |

| Additional Information | Nominal Value (English) | Nominal Value (SI) | Test Method |
|-----------------------------|-------------------------|--------------------|-------------|
| Overmold Bonding To: PP, PE | | | |

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| Injection | Nominal Value (English) | Nominal Value (SI) |
|-------------------------|-------------------------|--------------------|
| Rear Temperature | 340 to 360 °F | 171 to 182 °C |
| Middle Temperature | 370 to 390 °F | 188 to 199 °C |
| Front Temperature | 400 to 420 °F | 204 to 216 °C |
| Nozzle Temperature | 395 to 415 °F | 202 to 213 °C |
| Mold Temperature | 70 to 110 °F | 21 to 43 °C |
| Injection Rate | Moderate-Fast | Moderate-Fast |
| Back Pressure | 90.0 to 175 psi | 0.621 to 1.21 MPa |
| Screw L/D Ratio | 20.0:1.0 | 20.0:1.0 |
| Screw Compression Ratio | 1.5:1.0 | 1.5:1.0 |

Notes

¹ 20 in/min (510 mm/min)

Notes

These are typical property values not to be construed as specification limits.