Technical Data Sheet

Softflex 0954

Thermoplastic Elastomer
LyondellBasell Industries
Engineering Plastics

General		
Forms	• Pellets	
Processing Method	• Coating	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.09	1.09 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) [1]			ASTM D1238
200°c/5.0 Kg	21 g/10 min	21 g/10 min	
235°c/1.0 Kg	19 g/10 min	19 g/10 min	
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Taber Abrasion Resistance			ASTM D3389
1000 Cycles, 1000 G, H-22 Wheel	238 mg	238 mg	
Elastomers	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Set (100% Strain)	7 %	7 %	ASTM D412
Tensile Stress			ASTM D412
50% Strain	373 psi	2.57 MPa	
100% Strain	474 psi	3.27 MPa	
300% Strain	711 psi	4.90 MPa	
Tensile Strength [2] (Yield)	1380 psi	9.54 MPa	ASTM D412
Tensile Elongation (Break)	810 %	810 %	ASTM D412
Tear Strength	260 lbf/in	45.5 kN/m	ASTM D624
Compression Set [3]			ASTM D395B
73°f (23°c), 22 Hr	24 %	24 %	
158°f (70°c), 22 Hr	78 %	78 %	
212°f (100°c), 22 Hr	96 %	96 %	
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Gardner Impact (-22°f (-30°c))	> 320 in·lb	> 36.2 J	ASTM D5420
Hardness	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A	68 to 78	68 to 78	
Shore A, 10 Sec	64 to 74	64 to 74	

Additional Information	Nominal Value (English)	Nominal Value (SI)
Overmold Bonding	ABS, PC, ABS/PC, PPO	ABS, PC, ABS/PC, PPO

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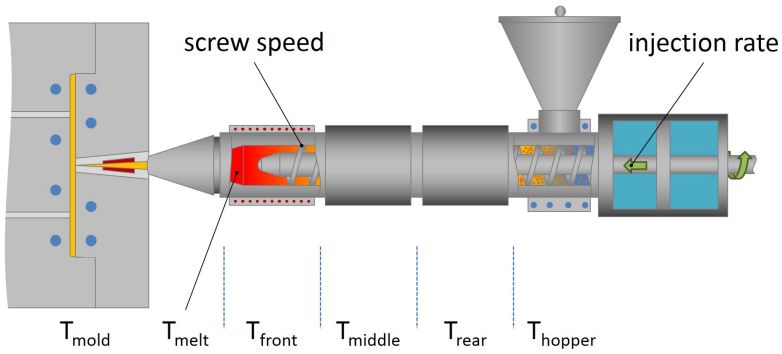

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	130 to 140 °F	54 to 60 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Suggested Shot Size	40 to 80 %	40 to 80 %
Rear Temperature	320 to 360 °F	160 to 182 °C
Middle Temperature	340 to 380 °F	171 to 193 °C
Front Temperature	410 to 430 °F	210 to 221 °C
Nozzle Temperature	390 to 420 °F	199 to 216 °C
Processing (Melt) Temp	380 to 410 °F	193 to 210 °C
Mold Temperature	80 to 120 °F	27 to 49 °C
Injection Pressure	5000 to 6000 psi	34.5 to 41.4 MPa
Holding Pressure	4000 to 4500 psi	27.6 to 31.0 MPa
Back Pressure	75.0 to 150 psi	0.517 to 1.03 MPa
Screw Speed	20 to 40 rpm	20 to 40 rpm

Notes

[1] Procedure A

[2] 20 in/min (510 mm/min)

[3] 25% Deflection