

UNISOFT ADHESION™ AD-40A-NT-1-32

DESCRIPTION	TPE Compound based on Styrene-Ethylene/Butylene-Styrene Block Copolymer
FEATURES	Special bonding grade to PC/ABS, PC/PBT, PC, ABS, excellent processing, soft grip;
APPLICATIONS	Unisoft Adhesion™ AD-40A-NT-1-32 is an adhesion grade intended for use in injection molding. Typically this material is used for 2-component over molding applications, such as handles or sealing.
COLOR	Natural color (about RAL 9010)
SUPPLIER	UNITED SOFT PLASTICS, INC. 720 Raco Drive Lawrenceville, GA 30045 USA Assistance: +1 770 339 9362

MECHANICAL PROPERTIES	TEST METHOD	ENGLISH - UNITS	SI - UNITS
SHORE HARDNESS	ASTM D - 2240	39 A	39 A
SPECIFIC GRAVITY	ASTM D - 792	1.04 (g/cc)	1.04 (g/cc)
TENSILE STRENGTH	ASTM D - 412	375 (psi)	2.6 (Mpa)
ELONGATION AT BREAK	ASTM D - 412	425 (%)	425 (%)

PROCESSING INFORMATION

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PURGING	Purge thoroughly before and after use of this product (e.g. Polystyrene or Polypropylene with MFI between 0.5 – 2.5)		
DRYING TIME	Material is not hygroscopic and drying is only necessary if material was stored under moisture, however pre-drying can be useful to achieve a better adhesion result to the Nylon substrate. (Pre-drying conditions: 2-4hours at appr. 150 °F / 65°C)		
COLORING	Material can be easily colored with all standard color concentrates based on EVA, LDPE or PP. Colorant can have a negative effect on adhesion, therefore lowest possible loading levels are recommended.		
SHRINKAGE PROPERTIES	Unisoft Adhesion grades are anisotropic materials. Their shrinkage properties are higher in the flow direction, and the shrinkage in the cross-flow direction is less. Unisoft Adhesion AD-40A-NT-1-32 shows shrinkage values between 0.8 – 2.6 %.		
RHEOLOGICAL PROPERTIES	The rheology of Unisoft Adhesion materials is shear dependant, and the viscosity is increasing at low shear rates and vice versa flow rates increase at higher shear rates. Therefore we recommend that this fact should be considered when designing injection molds and also when setting mold conditions during processing.		
MOLDING TEMPERATURES	Temperatures are shown for PC/ABS adhesion. For better adhesion results please increase temperatures in the first 3 zones up to 25°F/15°C per zone.		
	Zone 1) Rear	390 - 410 °F	200 - 210 °C
	Zone 2) Front	425 - 445 °F	220 - 230 °C
	Zone 3) Nozzle	445 - 495 °F	230 - 255 °C
	Mold	105 - 150 °F	40 – 65 °C

NOTICE

The properties shown are typical values and are not intended as product specification. All information given should serve only as a guide. There is no implied warranty of merchantability or fitness for a particular purpose. Establishing satisfactory performance of the product for the intended application is the customer's role responsibility. No warranty is given concerning the existence or non-existence of any patents claiming any pertinent subject matter presented herein.