

Versalloy™ HC 9220-70

Thermoplastic Elastomer

Key Characteristics

Product Description

Versalloy™ HC 9220-70 is a TPV alloy targeted for extrusion and injection molding healthcare applications such as medical tubing, disposable medical items and soft-touch overmolding for surgical grips.

- * Excellent Extrudability
- * Good Flow for Injection Molding
- * Exceptional Colorability
- * Overmold Adhesion to Polypropylene
- * Superior Surface Aesthetics

General

Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Latin America • North America	
Features	• Good Colorability • Good Processability	• Good Surface Finish • Non-Phthalate Plasticizer	• Recyclable Material
Uses	• Flexible Grips • Medical/Healthcare Applications	• Overmolding • Soft Touch Applications	• Tubing
Agency Ratings	• ISO 10993 Part 4	• ISO 10993 Part 5	
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.952	0.952	ASTM D792
Molding Shrinkage			ISO 294-4
Across Flow	1.9 %	1.9 %	
Flow	2.4 %	2.4 %	
Elastomers	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Stress ²			ASTM D412
Across Flow : 100% Strain, 70°F (21°C)	365 psi	2.52 MPa	
Flow : 100% Strain, 70°F (21°C) ³	540 psi	3.72 MPa	
Tensile Strength ^{3, 2}			ASTM D412
Across Flow : Break, 70°F (21°C)	588 psi	4.05 MPa	
Flow : Break, 73°F (23°C)	697 psi	4.81 MPa	
Tensile Elongation ^{3, 2}			ASTM D412
Across Flow : Break, 73°F (23°C)	290 %	290 %	
Flow : Break, 70°F (21°C)	240 %	240 %	
Tear Strength			ASTM D624
Across Flow	208 lbf/in	36.4 kN/m	
Flow	208 lbf/in	36.4 kN/m	

Copyright © 2020 Avient Corporation. Avient 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. Avient makes no warranties or guarantees respecting suitability of either Avient'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. Avient 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.

Elastomers	Typical Value (English)	Typical Value (SI)	Test Method
Compression Set			ASTM D395B
73°F (23°C), 22 hr	17 %	17 %	
73°F (23°C), 168 hr	18 %	18 %	
158°F (70°C), 22 hr	41 %	41 %	
158°F (70°C), 168 hr	42 %	42 %	
212°F (100°C), 22 hr	51 %	51 %	
212°F (100°C), 168 hr	62 %	62 %	
Hardness	Typical Value (English)	Typical Value (SI)	Test Method
Durometer Hardness (Shore A, 10 sec)	70	70	ASTM D2240
Fill Analysis	Typical Value (English)	Typical Value (SI)	Test Method
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec ⁻¹	18.7 Pa·s	18.7 Pa·s	

Additional Information

Versalloy™ HC 9220-70 can be recycled as a filler or impact modifier for polyolefins, or can be recycled by grinding and reintroduction to the molding process. Similar to PP or PE recycling process, if separated appropriately, it can be recycled many times.

Municipality waste stream recycle code is "7" which is designated for "Other".

Please contact GLS Thermoplastic Elastomers for a copy of our Recyclability Compliance letter.

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 hr	3.0 hr
Suggested Max Regrind	20 %	20 %
Rear Temperature	350 to 380 °F	177 to 193 °C
Middle Temperature	360 to 425 °F	182 to 218 °C
Front Temperature	380 to 435 °F	193 to 224 °C
Nozzle Temperature	380 to 435 °F	193 to 224 °C
Mold Temperature	60 to 80 °F	16 to 27 °C
Back Pressure	0.00 to 100 psi	0.00 to 0.689 MPa
Screw Speed	50 to 100 rpm	50 to 100 rpm

Injection Notes

Color concentrates with polypropylene (PP) carrier are most suitable for coloring Versalloy™ HC 9220-70. Improved color dispersion can be achieved by using higher melt flow concentrates (with a melt flow from 25 - 40 g/10 min). Typical loadings for color concentrates are 1% to 5% by weight. Concentrates based on PVC should not be used. The final determination of color concentrate suitability should be determined by customer trials.

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 Versalloy™ HC 9220-70 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.

Versalloy™ HC 9220-70 has good melt stability. Empty the barrel for idle periods of fifteen (15) minutes or longer.

Injection Speed: 1 to 5 in/sec
 1st Stage - Boost Pressure: 300 to 700 psi
 2nd Stage - Hold Pressure: 30% of Boost
 Hold Time (Thick Part): 4 to 10 sec
 Hold Time (Thin Part): 1 to 3 sec

Copyright © 2020 Avient Corporation. Avient 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. Avient makes no warranties or guarantees respecting suitability of either Avient'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. Avient 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.

Extrusion	Typical Value (English)	Typical Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 hr	3.0 hr
Cylinder Zone 1 Temp.	330 to 360 °F	166 to 182 °C
Cylinder Zone 2 Temp.	350 to 400 °F	177 to 204 °C
Cylinder Zone 3 Temp.	360 to 420 °F	182 to 216 °C
Die Temperature	360 to 410 °F	182 to 210 °C

Notes

¹ Typical values are not to be construed as specifications.

² 2 hr

³ Die C

CONTACT INFORMATION**North America**

Avon Lake, United States
33587 Walker Road
Avon Lake, OH, United States ,
44012
+1 440 930 1000
+1 844 4AVIENT

South America

Sao Paulo, Brazil
Av. Francisco Nakasato, 1700
13295-000 Itupeva
Sao Paulo, Brazil
+55 11 4593 9200

Asia

Shanghai, China
2F, Block C
200 Jinsu Road
Pudong, 201206
Shanghai, China
+86 (0) 21 6028 4888

Europe

Pommerloch, Luxembourg
19 Route de Bastogne
Pommerloch, Luxembourg , L-9638
+352 269 050 35



avient.com

Copyright ©, 2020 Avient Corporation. Avient 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. Avient makes no warranties or guarantees respecting suitability of either Avient'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. Avient 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.