

PRODUCT DESCRIPTION

A soft , colorable SBS based thermoplastic elastomer (TPE) compound designed for injection molding applications.

GENERAL PROPERTIES

<b>Material Status</b>	Active
<b>Availability</b>	Europe North America Asia- Pasific Africa & Middle East
<b>Features</b>	Ozone Resistance Adhesion to Polyolefins Recyclable Compliant with RoHS Directive 2011/65/EU
<b>Certification</b>	RoHS
<b>Appearance</b>	Natural
<b>Form</b>	Pellets
<b>Processing Method</b>	Injection

Physical Properties

Property	Typical Value (English)	Typical Value (SI)	Test Method
Density	1.09 g/cm <sup>3</sup>	1,09 g/cm <sup>3</sup>	ASTM D 792
Durometer Hardness, 3 sec (Shore A)	45.00	45,00	ASTM D 2240
Tensile Strength at Break	261 Psi	1,80 MPa	ASTM D412, Method A
Mod.of Elasticity %100	129 Psi	0,89 MPa	ASTM D412, Method A
Mod.of Elasticity %300	184 Psi	1,27 MPa	ASTM D412, Method A
Elongation at break	650.00 %	650,00 %	ASTM D412, Method A
Tear Resistance	79.94 lbf/in	14,00 N/mm	ASTM D624

Shrinkage

Property	Typical Value (English)	Typical Value (SI)	Test Method
Flow			ASTM D955
Across Flow			ASTM D955

Ageing Tests

Additional Information	Typical Value (English)	Typical Value (SI)	Test Method
Ozone Resistance-Stressed			ASTM D 1149

Bondable to

PE-EVA-PS

Additional Information

Elastron products are not compatible with PVC and Acetal.  
Regrinding level up to %20 is recommended with minimum property loss.

Processing

Injection Molding	Typical Value (English)		Typical Value (SI)	
Drying temperatures	-	°F	-	°C
Drying time	No need	hours	No need	hours
Rear Zone temp.	284-302	°F	140-150	°C
Middle Zone temp.	293-320	°F	145-160	°C
Front Zone temp.	302-329	°F	150-165	°C
Nozzle Temperature	329-365	°F	165-185	°C
Injection Speed	Low	-	Low	-
Injection Time	3-5	sec.	3-5	sec.
Injection Pressure	10-40	bar	10-40	bar
Hold Pressure	5-20	bar	5-20	bar
Back Pressure	5-40	bar	5-40	bar
Screw Speed	50-200	rpm	50-200	rpm
Mold Temperature	77-122	°F	25-50	°C
Screw Comp. ratio	1.5:1- 2.0:1	-	1.5:1- 2.0:1	-
Screw L/D ratio	18-24	-	18-24	-
Residence time	1-2 shot	-	1-2 shot	-
Cushion size	0.3120	inc	8	mm
Suggested Max Regrind	-	%	-	%

Notes

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