

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
<b>Density</b>	1.14 g/cm <sup>3</sup>	1,14 g/cm <sup>3</sup>	ASTM D 792
<b>Durometer Hardness, 3 sec (Shore A)</b>	50.00	50,00	ASTM D 2240
<b>Tensile Strength at Break</b>	290 Psi	2,00 MPa	ASTM D412, Method A
<b>Mod.of Elasticity %100</b>	145 Psi	1,00 MPa	ASTM D412, Method A
<b>Mod.of Elasticity %300</b>	203 Psi	1,40 MPa	ASTM D412, Method A
<b>Elongation at break</b>	500.00 %	500,00 %	ASTM D412, Method A
<b>Compression Set (at 73 °F, 22 h)</b>	13.00 %	13,00 %	ASTM D 395, Type 2, Method B
<b>Tear Resistance</b>	108.49 lbf/in	19,00 N/mm	ASTM D624

Shrinkage

Property	Typical Value (English)	Typical Value (SI)	Test Method
<b>Flow</b>	2.36%	2.36%	ASTM D955
<b>Across Flow</b>	1.45%	1.45%	ASTM D955

**Ageing Tests**

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

**Bondable to**

PE-PP-EVA

**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	20	%	20	%

# Notes

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## ISO 9001: 2015 & IATF16949: 2016 & ISO 14001: 2015 REGISTERED QUALITY SYSTEMS

