

PRODUCT DESCRIPTION

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

GENERAL PROPERTIES

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

Physical Properties

Property	Typical Value (English)	Typical Value (SI)	Test Method
Density	1.13 g/cm³	1,13 g/cm³	ASTM D 792
Durometer Hardness, 3 sec (Shore A)	58.00	58,00	ASTM D 2240
Tensile Strength at Break	508 Psi	3,50 MPa	ASTM D412, Method A
Mod.of Elasticity %100	203 Psi	1,40 MPa	ASTM D412, Method A
Mod.of Elasticity %300	290 Psi	2,00 MPa	ASTM D412, Method A
Elongation at break	500.00 %	500,00 %	ASTM D412, Method A
Compression Set (at 73 °F, 22 h)	26.00 %	26,00 %	ASTM D 395, Type 2, Method B
Tear Resistance	119.91 lbf/in	21,00 N/mm	ASTM D624

Shrinkage

Property	Typical Value (English)	Typical Value (SI)	Test Method
Flow	3.00%	3.00%	ASTM D955
Across Flow	1.48%	1.48%	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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