

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	1.09 g/cm³	1,09 g/cm³	ASTM D 792
Durometer Hardness, 3 sec (Shore A)	72.00	72,00	ASTM D 2240
Tensile Strength at Break	508 Psi	3,50 MPa	ASTM D412, Method A
Mod.of Elasticity %100	348 Psi	2,40 MPa	ASTM D412, Method A
Mod.of Elasticity %300	450 Psi	3,10 MPa	ASTM D412, Method A
Elongation at break	450.00 %	450,00 %	ASTM D412, Method A
Compression Set (at 73 °F, 22 h)	25.00 %	25,00 %	ASTM D 395, Type 2, Method B
Tear Resistance	131.33 lbf/in	23,00 N/mm	ASTM D624

Shrinkage

Property	Typical Value (English)	Typical Value (SI)	Test Method
Flow	3.00%	3.00%	ASTM D955
Across Flow	1.54%	1.54%	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
Drying time	No need	hours
Rear Zone temp.	284-302	°F
Middle Zone temp.	293-320	°F
Front Zone temp.	302-329	°F
Nozzle Temperature	329-365	°F
Injection Speed	Low	-
Injection Time	3-5	sec.
Injection Pressure	10-40	bar
Hold Pressure	5-20	bar
Back Pressure	5-40	bar
Screw Speed	50-200	rpm
Mold Temperature	77-122	°F
Screw Comp. ratio	1.5:1- 2.0:1	-
Screw L/D ratio	18-24	-
Residence time	1-2 shot	-
Cushion size	0.3120	inc
Suggested Max Regrind	-	%

Notes

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