

**D101.D35.B(Preliminary Data)**

**PRODUCT DESCRIPTION**

A hard , black SBS based thermoplastic elastomer (TPE) compound designed for general purpose 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>	Black
<b>Form</b>	Pellets
<b>Processing Method</b>	Injection,Extrusion

**Physical Properties**

Property	Typical Value (English)	Typical Value (SI)	Test Method
Density	1.13 g/cm <sup>3</sup>	1,13 g/cm <sup>3</sup>	ASTM D 792
Durometer Hardness, 3 sec (Shore D)	35.00	35,00	ASTM D 2240
Tensile Strength at Break	1015 Psi	7,00 MPa	ASTM D412, Method A
Mod.of Elasticity %100	769 Psi	5,30 MPa	ASTM D412, Method A
Mod.of Elasticity %300	943 Psi	6,50 MPa	ASTM D412, Method A
Elongation at break	500.00 %	500,00 %	ASTM D412, Method A
Compression Set (at 73 °F, 22 h)	24.00 %	24,00 %	ASTM D 395, Type 2, Method B
Tear Resistance	216.98 lbf/in	38,00 N/mm	ASTM D624

**Shrinkage**

Property	Typical Value (English)	Typical Value (SI)	Test Method
Flow	2.08%	2.08%	ASTM D955
Across Flow	1.33%	1.33%	ASTM D955

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**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	-	%	-	%

Extrusion Molding	Typical Value (English)		Typical Value (SI)	
Drying temperatures	-	°F	-	°C
Drying time	-	hours	-	hours
Screw Comp. Ratio	1.5:1- 2.0:1	-	1.5:1- 2.0:1	-
Screw L/D	18-30	-	18-30	-
Feed Zone temp.	284-320	°F	140-160	°C
Rear Zone temp.	284-320	°F	140-160	°C
Center Zone temp.	293-329	°F	145-165	°C
Front Zone temp.	311-347	°F	155-175	°C
Head temp.	311-365	°F	155-185	°C
Die temp.	329-383	°F	165-195	°C
Suggested Max Regrind	20	%	20	%

Notes

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