D103.A60.N

PRODUCT DESCRIPTION

A soft , colorable SBS based thermoplastic elastomer (TPE) compound designed for eraser 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	1.44 g/cm³	1,44 g/cm³	ASTM D 792
Durometer Hardness, 3 sec (Shore A)	60.00	60,00	ASTM D 2240

Shrinkage

Property	Typical Value (English)	Typical Value (SI)	Test Method
Flow	1.50%	1.50%	ASTM D955
Across Flow	1.33%	1.33%	ASTM D955

D103.A60.N

Ageing Tests

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

Bondable to

PE-EVA

Additional Information

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

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	-	-	-	-
Screw L/D	-	-	-	-
Feed Zone temp.	-	°F	-	°C
Rear Zone temp.	-	°F	-	°C
Center Zone temp.	-	°F	-	°C
Front Zone temp.	-	°F	-	°C
Head temp.	-	°F	-	°C
Die temp.	-	°F	-	°C
Suggested Max Regrind	-	%	-	%

Notes

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