

PRODUCT DESCRIPTION

A soft , colorable SEBS based thermoplastic elastomer (TPE) compound that offers good physical properties and chemical resistance.

GENERAL PROPERTIES

|                          |   |
|--------------------------|---|
| <b>Material Status</b>   | Active  |
| <b>Availability</b>      | Europe<br>North America<br>Asia- Pasific<br>Africa & Middle East  |
| <b>Features</b>          | Good Mechanical Properties<br>Good Chemical Resistance<br>Ozone Resistance<br>Adhesion to Polyolefins<br>Compliant with RoHS Directive 2011/65/EU |
| <b>Certification</b>     | RoHS  |
| <b>Appearance</b>        | Natural   |
| <b>Form</b>              | Pellets   |
| <b>Processing Method</b> | Injection, Extrusion  |

Physical Properties

| Property                                   | Typical Value (English) | Typical Value (SI)     | Test Method                  |
|--|-------------------------|------------------------|------------------------------|
| <b>Density</b>                             | 1.19 g/cm <sup>3</sup>  | 1,19 g/cm <sup>3</sup> | ASTM D 792                   |
| <b>Durometer Hardness, 3 sec (Shore A)</b> | 58.00                   | 58,00                  | ASTM D 2240                  |
| <b>Tensile Strength at Break</b>           | 798 Psi                 | 5,50 MPa               | ASTM D412, Method A          |
| <b>Mod.of Elasticity %100</b>              | 247 Psi                 | 1,70 MPa               | ASTM D412, Method A          |
| <b>Mod.of Elasticity %300</b>              | 377 Psi                 | 2,60 MPa               | ASTM D412, Method A          |
| <b>Elongation at break</b>                 | 750.00 %                | 750,00 %               | ASTM D412, Method A          |
| <b>Compression Set (at 73 °F, 22 h)</b>    | 16.00 %                 | 16,00 %                | ASTM D 395, Type 2, Method B |
| <b>Compression Set (at 158 °F, 22 h)</b>   | 45.00 %                 | 45,00 %                | ASTM D 395, Type 2, Method B |
| <b>Compression Set (at 212 °F, 22 h)</b>   | 72.00 %                 | 72,00 %                | ASTM D 395, Type 2, Method B |
| <b>Tear Resistance</b>                     | 148.46 lbf/in           | 26,00 N/mm             | ASTM D624                    |

Shrinkage

| Property           | Typical Value (English) | Typical Value (SI) | Test Method |
|--------------------|-------------------------|--------------------|-------------|
| <b>Flow</b>        | 2.16%                   | 2.16%              | ASTM D955   |
| <b>Across Flow</b> | 1.07%                   | 1.07%              | ASTM D955   |

Flammability

| Property                   | Typical Value (English) | Typical Value (SI) | Test Method |
|----------------------------|-------------------------|--------------------|-------------|
| <b>Flammability Rating</b> | HB                      | HB                 | UL 94       |

**Ageing Tests**

| Additional Information    | Typical Value (English) | Typical Value (SI) | Test Method |
|---------------------------|-------------------------|--------------------|-------------|
| Ozone Resistance-Stressed | No cracks               | No cracks          | 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.

| Injection Molding     | Typical Value (English) |       | Typical Value (SI) |       |
|-----------------------|-------------------------|-------|--------------------|-------|
| Drying temperatures   | -                       | °F    | -                  | °C    |
| Drying time           | No need                 | hours | No need            | hours |
| Rear Zone temp.       | 293-347                 | °F    | 145- 175           | °C    |
| Middle Zone temp.     | 311-365                 | °F    | 155- 185           | °C    |
| Front Zone temp.      | 320-374                 | °F    | 160- 190           | °C    |
| Nozzle Temperature    | 347-401                 | °F    | 175- 205           | °C    |
| Injection Speed       | Low/ Mod                | -     | Low/ Mod           | -     |
| 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                 | %     |

| Extrusion Molding     | Typical Value (English) |       | Typical Value (SI) |       |
|-----------------------|-------------------------|-------|--------------------|-------|
| Drying temperatures   | -                       | °F    | -                  | °C    |
| Drying time           | No need                 | hours | No need            | 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.       | 302-338                 | °F    | 150- 170           | °C    |
| Rear Zone temp.       | 311-347                 | °F    | 155- 175           | °C    |
| Center Zone temp.     | 329-365                 | °F    | 165- 185           | °C    |
| Front Zone temp.      | 347-401                 | °F    | 175- 205           | °C    |
| Head temp.            | 356-410                 | °F    | 180- 210           | °C    |
| Die temp.             | 374-410                 | °F    | 190- 210           | °C    |
| Suggested Max Regrind | 20                      | %     | 20                 | %     |

Notes

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