

PRODUCT DESCRIPTION

A soft , black 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>          | Excellent UV Resistance<br>Excellent Compression Set<br>Ozone Resistance<br>Compliant with RoHS Directive 2011/65/EU<br>Adhesion to Polyolefins |
| <b>Certification</b>     | RoHS                                                                                                                                            |
| <b>Appearance</b>        | Black                                                                                                                                           |
| <b>Form</b>              | Pellets                                                                                                                                         |
| <b>Processing Method</b> | Injection                                                                                                                                       |

Physical Properties

| Property                                   | Typical Value (English) | Typical Value (SI)     | Test Method                  |
|--------------------------------------------|-------------------------|------------------------|------------------------------|
| <b>Density</b>                             | 1.06 g/cm <sup>3</sup>  | 1,06 g/cm <sup>3</sup> | ASTM D 792                   |
| <b>Durometer Hardness, 3 sec (Shore A)</b> | 65.00                   | 65,00                  | ASTM D 2240                  |
| <b>Tensile Strength at Break</b>           | 870 Psi                 | 6,00 MPa               | ASTM D412, Method A          |
| <b>Mod.of Elasticity %100</b>              | 232 Psi                 | 1,60 MPa               | ASTM D412, Method A          |
| <b>Mod.of Elasticity %300</b>              | 363 Psi                 | 2,50 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>    | 22.00 %                 | 22,00 %                | ASTM D 395, Type 2, Method B |
| <b>Compression Set (at 158 °F, 22 h)</b>   | 53.00 %                 | 53,00 %                | ASTM D 395, Type 2, Method B |
| <b>Compression Set (at 212 °F, 22 h)</b>   | 78.00 %                 | 78,00 %                | ASTM D 395, Type 2, Method B |
| <b>Tear Resistance</b>                     | 142.75 lbf/in           | 25,00 N/mm             | ASTM D624                    |

Shrinkage

| Property           | Typical Value (English) | Typical Value (SI) | Test Method |
|--------------------|-------------------------|--------------------|-------------|
| <b>Flow</b>        | 2.10%                   | 2.10%              | ASTM D955   |
| <b>Across Flow</b> | 1.30%                   | 1.30%              | ASTM D955   |

**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.

**Processing**

| 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 %               |

# Notes

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

