

G993.A60.N(Preliminary Data)

PRODUCT DESCRIPTION

A soft , colorable SEBS based thermoplastic elastomer (TPE) compound designed for carpet backing application.

GENERAL PROPERTIES

Material Status	Active
Availability	Europe North America Asia- Pasific Africa & Middle East
Features	
Certification	RoHS
Appearance	Natural
Form	Pellets
Processing Method	Injection

Physical Properties

Property	Typical Value (English)	Typical Value (SI)	Test Method
Density	1.11 g/cm ³	1,11 g/cm ³	ASTM D 792
Durometer Hardness, 3 sec (Shore A)	60.00	60,00	ASTM D 2240
Tensile Strength at Break	363 Psi	2,50 MPa	ASTM D412, Method A
Mod.of Elasticity %100	276 Psi	1,90 MPa	ASTM D412, Method A
Mod.of Elasticity %300	305 Psi	2,10 MPa	ASTM D412, Method A
Elongation at break	400.00 %	400,00 %	ASTM D412, Method A
Tear Resistance	108.49 lbf/in	19,00 N/mm	ASTM D624
Melt Flow Rate (374 °F/11 lb)	0.606 lb/10 min	5 g/10 min,	ASTM D1238
pH	7.500 -	7,500 -	In- house
Water content	0.500 %	0,500 %	ASTM D6980

Shrinkage

Property	Typical Value (English)	Typical Value (SI)	Test Method
Flow			ASTM D955
Across Flow			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.	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	-	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

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