

PRODUCT DESCRIPTION

A soft , black thermoplastic vulcanizate, TPV in the thermoplastic elastomer (TPE) family which offers higher temperature resistance and excellent compression set with superior UV resistance.

GENERAL PROPERTIES

<b>Material Status</b>	Active
<b>Availability</b>	Europe North America Asia- Pasific Africa & Middle East
<b>Features</b>	Excellent UV Resistance Excellent Compression Set Ozone Resistance Compliant with RoHS Directive 2011/65/EU 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>	0.95 g/cm <sup>3</sup>	0,95 g/cm <sup>3</sup>	ASTM D 792
<b>Durometer Hardness, 3 sec (Shore A)</b>	55.00	55,00	ASTM D 2240
<b>Tensile Strength at Break</b>	653 Psi	4,50 MPa	ASTM D412, Method A
<b>Mod.of Elasticity %100</b>	218 Psi	1,50 MPa	ASTM D412, Method A
<b>Mod.of Elasticity %300</b>	348 Psi	2,40 MPa	ASTM D412, Method A
<b>Elongation at break</b>	600.00 %	600,00 %	ASTM D412, Method A
<b>Compression Set (at 73 °F, 22 h)</b>	17.00 %	17,00 %	ASTM D 395, Type 2, Method B
<b>Compression Set (at 158 °F, 22 h)</b>	38.00 %	38,00 %	ASTM D 395, Type 2, Method B
<b>Compression Set (at 212 °F, 22 h)</b>	56.00 %	56,00 %	ASTM D 395, Type 2, Method B
<b>Tear Resistance</b>	102.78 lbf/in	18,00 N/mm	ASTM D624

Shrinkage

Property	Typical Value (English)	Typical Value (SI)	Test Method
<b>Flow</b>			ASTM D955
<b>Across Flow</b>			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.

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

