

Elastron

D100.A65.N

TECHNICAL DATASHEET**PRODUCT DESCRIPTION**

A soft , colorable SBS based thermoplastic elastomer (TPE) compound designed for injection molding applications.

GENERAL PROPERTIES

Color	Natural
Certifications	RoHS
Processing Method	Injection
Available Standards	ASTM

Physical Properties			
Property	Unit	Standard	Value
Density	g/cm ³	ASTM D 792	1.11
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	65.00
Tensile Strength at Break	MPa	ASTM D412, Method A	3.30
Mod.of Elasticity %100	MPa	ASTM D412, Method A	2.00
Mod.of Elasticity %300	MPa	ASTM D412, Method A	2.80
Elongation at break	%	ASTM D412, Method A	550.00
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	33.00
Tear Resistance	N/mm	ASTM D624	27.00

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Ageing Tests

Ozone Resistance	Stressed	ASTM D 1149	
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Bondable to

PE-PP-EVA

Processing

Injection	Unit	Value
Drying temperatures	°C	-
Drying time	hours	No need
Rear Zone temp.	°C	140-150
Middle Zone temp.	°C	145-160
Front Zone temp.	°C	150-165
Nozzle Temperature	°C	165-185
Injection Speed	-	Low
Injection Time	sec.	3-5
Injection Pressure	bar	10-40
Hold Pressure	bar	5-20
Back Pressure	bar	5-40
Screw Speed	rpm	50-200
Mold Temperature	°C	25-50
Screw Comp. ratio	-	1.5:1- 2.0:1
Screw L/D ratio	-	18-24
Residence time	-	1-2 shot
Cushion size	mm	8
Suggested Max Regrind	%	-

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Additional Information

Elastron products are not compatible with PVC and Acetal.

Regrinding level up to %20 is recommended with minimum property loss.

Shrinkage	Unit	Standard	Value
Flow	%	ASTM D955	3.27
Across Flow	%	ASTM D955	1.55

Notes

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