

# Elastron

D100.A72.B

## TECHNICAL DATASHEET

### PRODUCT DESCRIPTION

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

### GENERAL PROPERTIES

<b>Color</b>	Black
<b>Certifications</b>	RoHS
<b>Processing Method</b>	Injection
<b>Available Standards</b>	ASTM

### Physical Properties

Property	Unit	Standard	Value
Density	g/cm <sup>3</sup>	ASTM D 792	1.09
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	72.00
Tensile Strength at Break	MPa	ASTM D412, Method A	3.50
Mod.of Elasticity %100	MPa	ASTM D412, Method A	2.40
Mod.of Elasticity %300	MPa	ASTM D412, Method A	3.10
Elongation at break	%	ASTM D412, Method A	450.00
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	25.00
Tear Resistance	N/mm	ASTM D624	23.00

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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	%	20

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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	3.00
Across Flow	%	ASTM D955	1.54

### Notes

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