

# Elastron

D100.A75.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 <sup>3</sup>	ASTM D 792	1.09
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	75.00
Tensile Strength at Break	MPa	ASTM D412, Method A	3.50
Mod.of Elasticity %100	MPa	ASTM D412, Method A	2.20
Mod.of Elasticity %300	MPa	ASTM D412, Method A	3.00
Elongation at break	%	ASTM D412, Method A	350.00
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	28.00
Tear Resistance	N/mm	ASTM D624	26.00

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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	3.20
Across Flow	%	ASTM D955	1.58

### Notes

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