

Elastron

D101.D35.B(Preliminary Data)

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	%	-
Drying time	hours	-
Screw Comp. Ratio	-	1.5:1- 2.0:1
Screw L/D	-	18-30
Feed Zone temp.	°C	140-160
Rear Zone temp.	°C	140-160
Center Zone temp.	°C	145-165
Front Zone temp.	°C	155-175
Head temp.	°C	155-185
Die temp.	°C	165-195
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	2.08
Across Flow	%	ASTM D955	1.33

Notes

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