



# **Elastron**

G101.A65.B

# **TECHNICAL DATASHEET**

## PRODUCT DESCRIPTION

A soft , black SEBS based thermoplastic elastomer (TPE) compound that offers good physical properties and chemical resistance.

# GENERAL PROPERTIES

Color Black
Certifications RoHS

Processing Method Injection Extrusion

Available Standards ASTM

## **Automotive Specifications**

GM/QK007000

Physical Properties					
Property	Unit	Standard	Value		
Density	g/cm³	ASTM D 792	1.18		
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	65.00		
Tensile Strength at Break	MPa	ASTM D412, Method A	7.00		
Mod.of Elasticity %100	MPa	ASTM D412, Method A	2.10		
Mod.of Elasticity %300	MPa	ASTM D412, Method A	3.20		
Elongation at break	%	ASTM D412, Method A	750.00		
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	18.00		
Compression Set	% at 70°C, 22 h	ASTM D 395, Type 2, Method B	44.00		
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	74.00		
Tear Resistance	N/mm	ASTM D624	36.00		
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Suggested Max Regrind

Stressed   ASTM D 1148   No cracks	G101.A65.B						
Siressed   ASTM D 1149   No cracks   No	Ageing Tests						
PE-PP-EVA   PE-PP-EVA	Property	Unit	Standard	Value			
PE-PP-EVA   Processing   Proc	Ozone Resistance	Stressed	ASTM D 1149	No cracks			
Processing   Pr		Вс	ondable to				
Dying temperatures   "C	PE-PP-EVA						
Prying temperatures  CC  Prying temperatures  No need  No need  No need  145-175  145-175  145-185  160-180  160-180  160-180  160-180  160-180  160-180  160-180  160-180  160-180  160-180  175-205  160-180  175-205  160-180  175-205  160-180  175-205  1	Processing						
No need	Injection	Unit	Valu	ıe			
Care   Zone temp.   Care   C	Drying temperatures	°C	-				
C	Drying time	hours	No ne	No need			
Front Zone temp.  **C 160-190  **Lozzie Temperature  **C 175-205  **Low Mod  **Injection Speed  - Low Mod  **Injection Speed  - Low Mod  **Injection Time  **Sec.  - 3-5  **Sec.  - 3-5  **Sec.  - 3-6  **Sec.  - 3-7  **Sec.  - 3-7	Rear Zone temp.	°C	145-	145- 175			
Abozzle Temperature         "C         175-205           njection Speed         -         Low/ Mod           njection Time         sec.         3 · 5           njection 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 LD ratio         -         1.2 · shot           Assidence time         -         1 · 2 · shot           Subspinon size         mm         8           Suggested Max Regrind         %         20           Scxtrusion         Unit         Value           Onlying temperatures         "C         -           Onlying time         hours         No need           Screw LD         -         1.5:1 · 2.0:1           Screw LD         -         15:0 · 170           Seed Zone temp.         "C         15:5 · 175           Scent Zone temp.         "C         15:5 · 175           Scent Zone temp.         "C         16:5 · 185 <t< td=""><td>Middle Zone temp.</td><td>°C</td><td>155-</td><td colspan="2">155- 185</td></t<>	Middle Zone temp.	°C	155-	155- 185			
	Front Zone temp.	°C	160-	160- 190			
Sec.   3-5     Sec.   3-5     Section Time   Sec.   3-5     Section Pressure   Dar   10-40     Section Pressure   Dar   5-20     Seack Pressure   Dar   5-40     Section Speed   Company   Company   Company     Section Company   Company   Company     Section Company   Company	Nozzle Temperature	°C	175-2	175- 205			
Description	Injection Speed	-	Low/ N	Low/ Mod			
Section   Sect	Injection Time	sec.	3- !	3- 5			
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           Extrusion         Unit         Value           Orying temperatures         °C         -           Orying time         hours         No need           Screw Comp. Ratio         -         1.5:1- 2.0:1           Screw L/D         -         18- 30           Greed Zone temp.         °C         150- 170           Rear Zone temp.         °C         155- 175           Center Zone temp.         °C         165- 185           Front Zone temp.         °C         175- 205           Head temp.         °C         180- 210	Injection Pressure	bar	10-4	10- 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     Suggested Max Regrind   % 20     Extrusion   Unit   Value     Orying temperatures   °C   - 1.5:1-2.0:1     Screw L/D   - 1.5:1-1.5	Hold Pressure	bar	5- 2	5- 20			
Add 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           Extrusion         Unit         Value           Drying temperatures         °C         -           Drying time         hours         No need           Screw Comp. Ratio         -         1.5:1-2.0:1           Screw L/D         -         18-30           Great Zone temp.         °C         150-170           Rear Zone temp.         °C         155-175           Center Zone temp.         °C         165-185           Front Zone temp.         °C         175-205           flead temp.         °C         180-210	Back Pressure	bar	5- 4	5- 40			
1.5:1-2.0:1	Screw Speed	rpm	50- 2	50- 200			
Screw L/D ratio   -	Mold Temperature	°C	25- 9	25- 50			
Residence time	Screw Comp. ratio	-	1.5:1-2	1.5:1- 2.0:1			
Cushion size         mm         8           Suggested Max Regrind         %         20           Extrusion         Unit         Value           Orying temperatures         °C         -           Orying time         hours         No need           Screw Comp. Ratio         -         1.5:1- 2.0:1           Screw L/D         -         18- 30           Seed Zone temp.         °C         150- 170           Rear Zone temp.         °C         155- 175           Center Zone temp.         °C         165- 185           Front Zone temp.         °C         175- 205           Head temp.         °C         180- 210	Screw L/D ratio	-	18- 2	18- 24			
Suggested Max Regrind         %         20           Extrusion         Unit         Value           Orying temperatures         °C         -           Orying time         hours         No need           Screw Comp. Ratio         -         1.5:1- 2.0:1           Screw L/D         -         18- 30           Feed Zone temp.         °C         150- 170           Rear Zone temp.         °C         155- 175           Center Zone temp.         °C         165- 185           Front Zone temp.         °C         175- 205           Head temp.         °C         180- 210	Residence time	-	1-2 s	1-2 shot			
Extrusion         Unit         Value           Orying temperatures         °C         -           Orying time         hours         No need           Grew Comp. Ratio         -         1.5:1- 2.0:1           Grew L/D         -         18- 30           Feed Zone temp.         °C         150- 170           Rear Zone temp.         °C         155- 175           Center Zone temp.         °C         165- 185           Front Zone temp.         °C         175- 205           Head temp.         °C         180- 210	Cushion size	mm	8	8			
Orying temperatures         °C         -           Orying time         hours         No need           Screw Comp. Ratio         -         1.5:1- 2.0:1           Screw L/D         -         18- 30           Feed Zone temp.         °C         150- 170           Rear Zone temp.         °C         155- 175           Center Zone temp.         °C         165- 185           Front Zone temp.         °C         175- 205           Head temp.         °C         180- 210	Suggested Max Regrind	%	20				
Drying time         hours         No need           Screw Comp. Ratio         -         1.5:1- 2.0:1           Screw L/D         -         18- 30           Feed Zone temp.         °C         150- 170           Rear Zone temp.         °C         155- 175           Center Zone temp.         °C         165- 185           Front Zone temp.         °C         175- 205           Head temp.         °C         180- 210	Extrusion	Unit	Valu	ıe			
Screw Comp. Ratio     -     1.5:1- 2.0:1       Screw L/D     -     18- 30       Feed Zone temp.     °C     150- 170       Rear Zone temp.     °C     155- 175       Center Zone temp.     °C     165- 185       Front Zone temp.     °C     175- 205       Head temp.     °C     180- 210	Drying temperatures	°C	-				
Screw L/D     -     18- 30       Feed Zone temp.     °C     150- 170       Rear Zone temp.     °C     155- 175       Center Zone temp.     °C     165- 185       Front Zone temp.     °C     175- 205       Head temp.     °C     180- 210	Drying time	hours	No ne	No need			
Feed Zone temp.         °C         150- 170           Rear Zone temp.         °C         155- 175           Center Zone temp.         °C         165- 185           Front Zone temp.         °C         175- 205           Head temp.         °C         180- 210	Screw Comp. Ratio	-	1.5:1-2	1.5:1- 2.0:1			
Rear Zone temp.         °C         155- 175           Center Zone temp.         °C         165- 185           Front Zone temp.         °C         175- 205           Head temp.         °C         180- 210	Screw L/D	-	18-3	18- 30			
Center Zone temp.         °C         165- 185           Front Zone temp.         °C         175- 205           Head temp.         °C         180- 210	Feed Zone temp.	°C	150-	170			
Front Zone temp.         °C         175- 205           Head temp.         °C         180- 210	Rear Zone temp.	°C	155-	175			
lead temp. °C 180- 210	Center Zone temp.	°C	165-	165- 185			
	Front Zone temp.	°C	175-2	175- 205			
Die temp. °C 190- 210	Head temp.	°C	180-2	180- 210			
	Die temp.	°C	190- 2	190- 210			

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%





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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	2.37
Across Flow	%	ASTM D955	1.00

#### **Notes**

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## ISO 9001: 2015 & IATF16949: 2016 & ISO 14001: 2015 REGISTERED QUALITY SYSTEMS









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