



**Elastron**

G301.A65.B

| Ageing Tests           |          |             |              |
|------------------------|----------|-------------|--------------|
| Property               | Unit     | Standard    | Value        |
| Ozone Resistance       | Stressed | ASTM D 1149 | No cracks    |
| <b>Bondable to</b>     |          |             |              |
| PE-PP-EVA              |          |             |              |
| Drying time            | hours    |             | No need      |
| Rear Zone temp.        | °C       |             | 145- 175     |
| Middle Zone temp.      | °C       |             | 155- 185     |
| Front Zone temp.       | °C       |             | 160- 190     |
| Nozzle Temperature     | °C       |             | 175- 205     |
| Injection Speed        | -        |             | Low/ Mod     |
| 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 Re grind | %        |             | 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     |
| Die temp.              | °C       |             | 190- 210     |
| Suggested Max Re grind | %        |             | 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 | 2.10  |
| Across Flow | %    | ASTM D955 | 1.30  |

### Notes

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

