

Elastron

G301.A90.B

Ageing Tests			
Property	Unit	Standard	Value
Ozone Resistance	Stressed	ASTM D 1149	No cracks
Bondable to			
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	1.43
Across Flow	%	ASTM D955	1.15

Notes

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