

Elastron

G400.A65.B

TECHNICAL DATASHEET**PRODUCT DESCRIPTION**

A soft , black unfilled SEBS based thermoplastic elastomer (TPE) compound which has very good physical properties and chemical resistance. This product is a good option when good abrasion resistance is required.

GENERAL PROPERTIES

Color	Black
Certifications	RoHS
Processing Method	Injection
Available Standards	ASTM

Physical Properties

Property	Unit	Standard	Value
Density	g/cm ³	ASTM D 792	0.89
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	65.00
Tensile Strength at Break	MPa	ASTM D412, Method A	10.00
Mod.of Elasticity %100	MPa	ASTM D412, Method A	1.80
Mod.of Elasticity %300	MPa	ASTM D412, Method A	3.00
Elongation at break	%	ASTM D412, Method A	950.00
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	20.00
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	66.00
Tear Resistance	N/mm	ASTM D624	41.00

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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 Regrind	%		20
Drying time	hours		-
Screw Comp. Ratio	-		-
Screw L/D	-		-
Feed Zone temp.	°C		-
Rear Zone temp.	°C		-
Center Zone temp.	°C		-
Front Zone temp.	°C		-
Head temp.	°C		-
Die temp.	°C		-
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	3.04
Across Flow	%	ASTM D955	1.36

Notes

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