

Elastron

G500.A60.B.ABS

TECHNICAL DATASHEET

PRODUCT DESCRIPTION

A soft , black SEBS based thermoplastic elastomer (TPE) compound specially designed for excellent adhesion to ABS/PC/PMMA/SAN/ASA/PET and PET-G.

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 | 1.10 |
| Durometer Hardness, 3 sec | Shore A | ASTM D 2240 | 60.00 |
| Tensile Strength at Break | MPa | ASTM D412, Method A | 7.80 |
| Mod.of Elasticity %100 | MPa | ASTM D412, Method A | 1.90 |
| Mod.of Elasticity %300 | MPa | ASTM D412, Method A | 3.90 |
| Elongation at break | % | ASTM D412, Method A | 600.00 |
| Compression Set | % at 23°C, 22 h | ASTM D 395, Type 2, Method B | 15.00 |
| Compression Set | % at 70°C, 22 h | ASTM D 395, Type 2, Method B | 62.00 |
| Compression Set | % at 100°C, 22 h | ASTM D 395, Type 2, Method B | 84.00 |
| Tear Resistance | N/mm | ASTM D624 | 35.00 |

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| Ageing Tests | | | |
|------------------|----------|-------------|-----------|
| Property | Unit | Standard | Value |
| Ozone Resistance | Stressed | ASTM D 1149 | No cracks |
| Bondable to | | | |

PMMA-ABS/PC-ASA-SAN-PET-PET-G

| Processing | | |
|-----------------------|-------|--------------|
| Injection | Unit | Value |
| Drying temperatures | °C | 90 |
| Drying time | hours | 2 |
| Rear Zone temp. | °C | 180- 200 |
| Middle Zone temp. | °C | 190- 210 |
| Front Zone temp. | °C | 205- 220 |
| Nozzle Temperature | °C | 220- 230 |
| Injection Speed | - | Mod/ High |
| Injection Time | sec. | 1- 4 |
| 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 | - | 2.0:1- 4.0:1 |
| Screw L/D ratio | - | 18- 24 |
| Residence time | - | 1-2 shot |
| Cushion size | mm | 8 |
| 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 | 1.33 |
| Across Flow | % | ASTM D955 | 0.80 |

Notes

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