

# Elastron

G601.A80.N

## TECHNICAL DATASHEET

### PRODUCT DESCRIPTION

A soft , colorable copper stabilised halogen free flame retardant (HFFR) SEBS based thermoplastic elastomer (TPE) compound with good UV resistance.

### GENERAL PROPERTIES

Color	Natural	
Certifications	RoHS	
Processing Method	Injection	Extrusion
Available Standards	ASTM	

### Physical Properties

Property	Unit	Standard	Value
Density	g/cm <sup>3</sup>	ASTM D 792	1.14
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	80.00
Tensile Strength at Break	MPa	ASTM D412, Method A	6.00
Mod.of Elasticity %100	MPa	ASTM D412, Method A	3.30
Mod.of Elasticity %300	MPa	ASTM D412, Method A	4.30
Elongation at break	%	ASTM D412, Method A	500.00
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	53.00
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	79.00
Flammability Rating	HB, V0, V1, V2	UL 94	V0
Tear Resistance	N/mm	ASTM D624	35.00

### Electrical Properties

Property	Unit	Standard	Value
Dielectric Strength, KV/mm	KV/mm	ASTM D149	10.10
Volume resistivity	Ω.cm	ASTM D257	2.36E+15

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Ageing Tests			
Property	Unit	Standard	Value
Ozone Resistance	Stressed	ASTM D 1149	No cracks

### Bondable to

PE-PP-EVA

Processing		
Injection	Unit	Value
Drying temperatures	°C	90
Drying time	hours	2 hours
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.	2- 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	-	1.5:1- 3.0:1
Screw L/D ratio	-	18- 24
Residence time	-	1- 2 shot
Cushion size	mm	8
Suggested Max Regrind	%	20
Drying time	hours	2 hours
Screw Comp. Ratio	-	1.5:1- 3.0:1
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 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	1.40
Across Flow	%	ASTM D955	0.83

### Notes

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

