



Elastron

G601.A90.N

TECHNICAL DATASHEET

PRODUCT DESCRIPTION

A hard , 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/cm³	ASTM D 792	1.14		
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	90.00		
Tensile Strength at Break	MPa	ASTM D412, Method A	7.50		
Mod.of Elasticity %100	MPa	ASTM D412, Method A	3.80		
Mod.of Elasticity %300	MPa	ASTM D412, Method A	5.10		
Elongation at break	%	ASTM D412, Method A	500.00		
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	21.00		
Compression Set	% at 70°C, 22 h	ASTM D 395, Type 2, Method B	56.00		
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	80.00		
Flammability Rating	HB, V0, V1, V2	UL 94	V0		
Tear Resistance	N/mm	ASTM D624	42.00		
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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	1.33
Across Flow	%	ASTM D955	0.78

Notes

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









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