Elastron

V100.A60.N

TECHNICAL DATASHEET

PRODUCT DESCRIPTION

A soft , colorable thermoplastic vulcanizate, TPV (EPDM/PP) in the thermoplastic elastomer (TPE) family designed for injection applications.

GENERAL PROPERTIES

Color	Natural
Certifications	RoHS
Processing Method	Injection
Available Standards	ASTM

Physical Properties

Property	Unit	Standard	Value
Density	g/cm³	ASTM D 792	0.96
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	60.00
Tensile Strength at Break	MPa	ASTM D412, Method A	5.00
Mod.of Elasticity %100	MPa	ASTM D412, Method A	1.80
Mod.of Elasticity %300	MPa	ASTM D412, Method A	3.10
Elongation at break	%	ASTM D412, Method A	600.00
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	36.00
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	53.00
Tear Resistance	N/mm	ASTM D624	24.00

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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
Rear Zone temp.	°C	155- 175
Middle Zone temp.	°C	165- 185
Front Zone temp.	°C	170- 190
Nozzle Temperature	°C	180- 210
Injection Speed	-	Moderate
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- 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	2.83
Across Flow	%	ASTM D955	1.45

Notes

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