

Elastron

V100.D40.B

TECHNICAL DATASHEET

PRODUCT DESCRIPTION

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

GENERAL PROPERTIES

Color	Black
Certifications	RoHS
Processing Method	Injection
Available Standards	ASTM

Automotive Specifications

TOYOTA/ TSM5601G-4C

Physical Properties

Property	Unit	Standard	Value
Density	g/cm³	ASTM D 792	0.90
Durometer Hardness, 3 sec	Shore D	ASTM D 2240	40.00
Tensile Strength at Break	MPa	ASTM D412, Method A	15.00
Mod.of Elasticity %100	MPa	ASTM D412, Method A	7.90
Mod.of Elasticity %300	MPa	ASTM D412, Method A	9.70
Elongation at break	%	ASTM D412, Method A	450.00
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	40.00
Compression Set	% at 70°C, 22 h	ASTM D 395, Type 2, Method B	63.00
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	77.00
Tear Resistance	N/mm	ASTM D624	95.00

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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		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	1.75
Across Flow	%	ASTM D955	1.58

Notes

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