

Elastron

V101.A50.N

TECHNICAL DATASHEET

PRODUCT DESCRIPTION

A soft , colorable thermoplastic vulcanizate, TPV (EPDM/PP) in the thermoplastic elastomer family that offers good physical properties and chemical 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	0.97			
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	50.00			
Tensile Strength at Break	MPa	ASTM D412, Method A	4.50			
Mod.of Elasticity %100	MPa	ASTM D412, Method A	1.20			
Mod.of Elasticity %300	MPa	ASTM D412, Method A	2.30			
Elongation at break	%	ASTM D412, Method A	550.00			
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	16.00			
Compression Set	% at 70°C, 22 h	ASTM D 395, Type 2, Method B	28.00			
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	50.00			
Tear Resistance	N/mm	ASTM D624	23.00			
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ENGI-NEERING LIFE



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Ageing Tests					
Property	Unit	Standard	Value		
Ozone Resistance	Stressed	ASTM D 1149	No cracks		
	Во	ndable to			
	PI	E-PP-EVA			
	Pr	ocessing			
Injection	Unit	Value			
Drying temperatures	°C	90			
Drying time	hours	2			
Rear Zone temp.	°C	155- 175			
Middle Zone temp.	°C	165- 185	1		
Front Zone temp.	°C	170- 190	1		
Nozzle Temperature	°C	180- 210			
Injection Speed	-	Moderate	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			
Extrusion	Unit	Value			
Drying temperatures	°C	90			
Drying time	hours	2			
Screw Comp. Ratio	-	1.5:1- 2.0:	1.5:1- 2.0:1		
Screw L/D	-	18- 30			
Feed Zone temp.	C°	155- 165	155- 165		
Rear Zone temp.	C°	160- 180	160- 180		
Center Zone temp.	C°	165- 185	165- 185		
Front Zone temp.	C°	170- 190	170- 190		
Head temp.	C°	180- 210			
Die temp.	C°	185- 215			
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	3.14				
Across Flow	%	ASTM D955	1.17				

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



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