Elastron

V101.A60.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	60.00
Tensile Strength at Break	MPa	ASTM D412, Method A	5.50
Mod.of Elasticity %100	MPa	ASTM D412, Method A	1.90
Mod.of Elasticity %300	MPa	ASTM D412, Method A	3.80
Elongation at break	%	ASTM D412, Method A	600.00
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	17.00
Compression Set	% at 70°C, 22 h	ASTM D 395, Type 2, Method B	33.00
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	46.00
Tear Resistance	N/mm	ASTM D624	31.00

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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
Extrusion	**Unit**	**Value**
Drying temperatures	°C	90
Drying time	hours	2
Screw Comp. Ratio	-	1.5:1- 2.0:1
Screw L/D	-	18- 30
Feed Zone temp.	°C	155- 165
Rear Zone temp.	°C	160- 180
Center Zone temp.	°C	165- 185
Front Zone temp.	°C	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	2.70
Across Flow	%	ASTM D955	0.93

Notes

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