

# Elastron

V101.A65.B

## TECHNICAL DATASHEET

### PRODUCT DESCRIPTION

A soft , black thermoplastic vulcanizate, TPV (EPDM/PP) in the thermoplastic elastomer family that offers good physical properties and chemical resistance

### GENERAL PROPERTIES

<b>Color</b>	Black
<b>Certifications</b>	RoHS
<b>Processing Method</b>	Injection                      Extrusion
<b>Available Standards</b>	ASTM

Physical Properties			
Property	Unit	Standard	Value
Density	g/cm <sup>3</sup>	ASTM D 792	0.97
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	65.00
Tensile Strength at Break	MPa	ASTM D412, Method A	6.50
Mod.of Elasticity %100	MPa	ASTM D412, Method A	2.30
Mod.of Elasticity %300	MPa	ASTM D412, Method A	4.70
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	37.00
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	53.00
Flammability Rating	HB, V0, V1, V2	UL 94	HB
Tear Resistance	N/mm	ASTM D624	29.00

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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	3.25
Across Flow	%	ASTM D955	1.08

### Notes

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