

Elastron

V101.A90.B

TECHNICAL DATASHEET

PRODUCT DESCRIPTION

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

GENERAL PROPERTIES

Color	Black
Certifications	RoHS
Processing Method	Injection Extrusion
Available Standards	ASTM

Automotive Specifications

TOYOTA/ TSM5746G CLASS 4

Physical Properties

Property	Unit	Standard	Value
Density	g/cm³	ASTM D 792	0.97
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	90.00
Tensile Strength at Break	MPa	ASTM D412, Method A	12.00
Mod.of Elasticity %100	MPa	ASTM D412, Method A	5.40
Mod.of Elasticity %300	MPa	ASTM D412, Method A	7.30
Elongation at break	%	ASTM D412, Method A	750.00
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	28.00
Compression Set	% at 70°C, 22 h	ASTM D 395, Type 2, Method B	48.00
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	69.00
Tear Resistance	N/mm	ASTM D624	50.00

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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		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	2.53
Across Flow	%	ASTM D955	1.46

Notes

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