

Elastron

V201.A45.B

TECHNICAL DATASHEET

PRODUCT DESCRIPTION

A soft , black thermoplastic vulcanizate, TPV (EPDM/PP) in the thermoplastic elastomer (TPE) family which offers higher temperature resistance and good compression set with good UV resistance

GENERAL PROPERTIES			
Color	Black		
Certifications	RoHS		
Processing Method	Injection	Extrusion	
Available Standards	ASTM		

Automotive Specifications

GM/GMW 15813 (TYPE 3)

Physical Properties						
Property	Unit	Standard	Value			
Density	g/cm³	ASTM D 792	0.95			
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	45.00			
Tensile Strength at Break	MPa	ASTM D412, Method A	4.00			
Mod.of Elasticity %100	MPa	ASTM D412, Method A	1.30			
Mod.of Elasticity %300	MPa	ASTM D412, Method A	2.80			
Elongation at break	%	ASTM D412, Method A	500.00			
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	25.00			
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	30.00			
Tear Resistance	N/mm	ASTM D624	16.00			
FR07.03.16 Rev.06		1	Rev.00002 Page 1 / 3			

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Elastron

V201.A45.B

Ageing Tests						
Property	Unit	Standard	Value			
Ozone Resistance	Stressed	ASTM D 1149	No cracks			
	Bo	ondable to				
	Р	E-PP-EVA				
Processing						
Injection	Unit	Value	3			
Drying temperatures	°C	90				
Drying time	hours	2				
Rear Zone temp.	°C	155- 17	75			
Middle Zone temp.	°C	165- 185				
Front Zone temp.	°C	170- 190				
Nozzle Temperature	°C	180- 210				
Injection Speed	-	High				
Injection Time	sec.	1-3				
Injection Pressure	bar	10-40				
Hold Pressure	bar	5- 20				
Back Pressure	bar	5- 40				
Screw Speed	rpm	50- 200				
Mold Temperature	٦°	25- 50				
Screw Comp. ratio	-	2.0:1- 4.0:1				
Screw L/D ratio	-	18-24				
Residence time	-	1-2 shot				
Cushion size	mm	8				
Suggested Max Regrind	%	20				
Extrusion	Unit	Value	9			
Drying temperatures	°C	90				
Drying time	hours	2				
Screw Comp. Ratio	-	2.0:1- 4.0:1				
Screw L/D	-	18- 30	18- 30			
Feed Zone temp.	°C	155- 16	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				
FR07.03.16 Rev.06		Re	ev.00002 Page 2 / 3			



Page 3/3

Elastron

V201.A45.B

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	2.63				
Across Flow	%	ASTM D955	1.50				

Notes

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



FR07.03.16 Rev.06