

## Elastron

V206.A60.B

### TECHNICAL DATASHEET

#### PRODUCT DESCRIPTION

A soft , black thermoplastic vulcanizate, TPV (EPDM/PP) in the thermoplastic elastomer (TPE) family designed for low coefficient of friction requirements

#### 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	0.91
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	60.00
Tensile Strength at Break	MPa	ASTM D412, Method A	4.00
Mod.of Elasticity %100	MPa	ASTM D412, Method A	1.80
Mod.of Elasticity %300	MPa	ASTM D412, Method A	2.90
Elongation at break	%	ASTM D412, Method A	550.00
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	34.00
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	41.00
Tear Resistance	N/mm	ASTM D624	25.00

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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	-	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	°C	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	
Drying temperatures	°C	90	
Drying time	hours	2	
Screw Comp. Ratio	-	2.0:1- 4.0:1	
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	
Across Flow	%	ASTM D955	

### Notes

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