

Elastron

V206.A70.B

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	2.20
Across Flow	%	ASTM D955	1.90

Notes

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