



Elastron

V206.A70.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

Color Black
Certifications RoHS

Processing Method Injection Extrusion

Available Standards ASTM

Physical Properties					
Unit	Standard	Value			
g/cm³	ASTM D 792	0.91			
Shore A	ASTM D 2240	70.00			
MPa	ASTM D412, Method A	6.00			
MPa	ASTM D412, Method A	2.40			
MPa	ASTM D412, Method A	3.90			
%	ASTM D412, Method A	550.00			
% at 23°C, 22 h	ASTM D 395, Type 2, Method B	23.00			
% at 70°C, 22 h	ASTM D 395, Type 2, Method B	40.00			
% at 100°C, 22 h	ASTM D 395, Type 2, Method B	48.00			
N/mm	ASTM D624	32.00			
	### Unit ### g/cm³ Shore A MPa MPa MPa MPa MPa % ### 423°C, 22 h % at 70°C, 22 h % at 100°C, 22 h	Unit Standard g/cm³ ASTM D 792 Shore A ASTM D 2240 MPa ASTM D412, Method A MPa ASTM D412, Method A MPa ASTM D412, Method A % ASTM D412, Method A % at 23°C, 22 h ASTM D 395, Type 2, Method B % at 70°C, 22 h ASTM D 395, Type 2, Method B % at 100°C, 22 h ASTM D 395, Type 2, Method B			

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Suggested Max Regrind

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Ageing Tests					
Property	Unit	Standard	Value		
Ozone Resistance	Stressed	ASTM D 1149	No cracks		
	В	ondable to			
	F	PE-PP-EVA			
Processing					
Injection	Unit	Valu	ie .		
Drying temperatures	°C	90	90		
Drying time	hours	2	2		
Rear Zone temp.	°C	155- 1	155- 175		
Middle Zone temp.	°C	165- 1	165- 185		
Front Zone temp.	°C	170- 1	170- 190		
Nozzle Temperature	°C	180- 2	180- 210		
Injection Speed	-	High	High		
Injection Time	sec.	1-3	1-3		
Injection Pressure	bar	10-4	10-40		
Hold Pressure	bar	5- 2	5- 20		
Back Pressure	bar	5- 4	5- 40		
Screw Speed	rpm	50- 2	50- 200		
Mold Temperature	°C	25- 5	25- 50		
Screw Comp. ratio	-	2.0:1- 4	2.0:1- 4.0:1		
Screw L/D ratio	-	18-2	18- 24		
Residence time	-	1-2 sl	1-2 shot		
Cushion size	mm	8	8		
Suggested Max Regrind	%	20	20		
Extrusion	Unit	Valu	Value		
Drying temperatures	°C	90			
Drying time	hours	2	2		
Screw Comp. Ratio	-	2.0:1- 4	2.0:1- 4.0:1		
Screw L/D	-	18-3	18- 30		
Feed Zone temp.	°C	155- 1	155- 165		
Rear Zone temp.	°C	160- 1	160- 180		
Center Zone temp.	°C	165- 1	165- 185		
Front Zone temp.	°C	170- 1	170- 190		
Head temp.	°C	180- 2	180- 210		
Die temp.	°C	185- 2	185- 215		

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









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