

Elastron

V206.D60.B

TECHNICAL DATASHEET

PRODUCT DESCRIPTION

A hard , 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			
Property	Unit	Standard	Value
Density	g/cm ³	ASTM D 792	0.89
Durometer Hardness, 3 sec	Shore D	ASTM D 2240	60.00
Tensile Strength at Break	MPa	ASTM D412, Method A	25.00
Mod.of Elasticity %100	MPa	ASTM D412, Method A	14.20
Mod.of Elasticity %300	MPa	ASTM D412, Method A	17.00
Elongation at break	%	ASTM D412, Method A	500.00
Tear Resistance	N/mm	ASTM D624	98.00

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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	1.65
Across Flow	%	ASTM D955	1.40

Notes

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