

## Elastron

V216.A38.B(Preliminary Data)

### 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 with good adhesion properties to TPV and EPDM rubber. This grade is specially designed for GRC corner molding applications.

#### GENERAL PROPERTIES

|                            |           |
|----------------------------|-----------|
| <b>Color</b>               | Black     |
| <b>Certifications</b>      | RoHS      |
| <b>Processing Method</b>   | Injection |
| <b>Available Standards</b> | ASTM      |

#### Physical Properties

| Property                  | Unit              | Standard                     | Value  |
|---------------------------|-------------------|------------------------------|--------|
| Density                   | g/cm <sup>3</sup> | ASTM D 792                   | 0.90   |
| Durometer Hardness, 3 sec | Shore A           | ASTM D 2240                  | 38.00  |
| Tensile Strength at Break | MPa               | ASTM D412, Method A          | 2.20   |
| Mod.of Elasticity %100    | MPa               | ASTM D412, Method A          | 0.60   |
| Mod.of Elasticity %300    | MPa               | ASTM D412, Method A          | 1.50   |
| Elongation at break       | %                 | ASTM D412, Method A          | 450.00 |
| Compression Set           | % at 70°C, 22 h   | ASTM D 395, Type 2, Method B | 27.00  |
| Compression Set           | % at 100°C, 22 h  | ASTM D 395, Type 2, Method B | 35.00  |
| Tear Resistance           | N/mm              | ASTM D624                    | 12.00  |

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| Ageing Tests     |          |             |           |
|------------------|----------|-------------|-----------|
| Property         | Unit     | Standard    | Value     |
| Ozone Resistance | Stressed | ASTM D 1149 | No cracks |
| Bondable to      |          |             |           |

PE-EPDM-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           |
| Drying time           | hours | -            |
| Screw Comp. Ratio     | -     | -            |
| Screw L/D             | -     | -            |
| Feed Zone temp.       | °C    | -            |
| Rear Zone temp.       | °C    | -            |
| Center Zone temp.     | °C    | -            |
| Front Zone temp.      | °C    | -            |
| Head temp.            | °C    | -            |
| Die temp.             | °C    | -            |
| Suggested Max Regrind | %     | -            |

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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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