Elastron

V216.A80.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

Color	Black
Certifications	RoHS
Processing Method	Injection
Available Standards	ASTM

Physical Properties

Property	Unit	Standard	Value
Density	g/cm³	ASTM D 792	0.90
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	80.00
Tensile Strength at Break	MPa	ASTM D412, Method A	6.50
Mod.of Elasticity %100	MPa	ASTM D412, Method A	3.10
Mod.of Elasticity %300	MPa	ASTM D412, Method A	4.80
Elongation at break	%	ASTM D412, Method A	450.00
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	42.00
Compression Set	% at 70°C, 22 h	ASTM D 395, Type 2, Method B	52.00
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	63.00
Tear Resistance	N/mm	ASTM D624	32.00

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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

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