

# Elastron

V250.A64.B

## TECHNICAL DATASHEET

### PRODUCT DESCRIPTION

A soft , black TPV (EPDM /PP ) material belongs to thermoplastic elastomer (TPE) family with very good UV resistance and very good compression set. This product is specially designed for weatherseal applications.

### GENERAL PROPERTIES

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

### Automotive Specifications

GM/GMW 15812P (TYPE 5M)

### Physical Properties

Property	Unit	Standard	Value
Density	g/cm <sup>3</sup>	ASTM D 792	0.96
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	65.00
Tensile Strength at Break	MPa	ASTM D412, Method A	6.00
Mod.of Elasticity %100	MPa	ASTM D412, Method A	2.10
Mod.of Elasticity %300	MPa	ASTM D412, Method A	3.20
Elongation at break	%	ASTM D412, Method A	650.00
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	16.00
Compression Set	% at 70°C, 22 h	ASTM D 395, Type 2, Method B	37.00
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	49.00
Tear Resistance	N/mm	ASTM D624	25.00

FR07.03.16 Rev.06

Rev.00001

Page 1 / 3

## Elastron

V250.A64.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
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	1.35
Across Flow	%	ASTM D955	1.30

### Notes

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