

# Elastron

V251.A75.B

## TECHNICAL DATASHEET

### PRODUCT DESCRIPTION

A soft , black thermoplastic vulcanizate, TPV (EPDM/PP) in the thermoplastic elastomer (TPE) family which offers higher temperature resistance and very good compression set with very good UV resistance. This product is specially designed for weatherseal applications.

### GENERAL PROPERTIES

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

### Automotive Specifications

GM/GMW 15812P (TYPE 6E)                      FCA/MS-AR100-CGV

### Physical Properties

Property	Unit	Standard	Value
Density	g/cm³	ASTM D 792	0.96
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	75.00
Tensile Strength at Break	MPa	ASTM D412, Method A	8.00
Mod.of Elasticity %100	MPa	ASTM D412, Method A	3.20
Mod.of Elasticity %300	MPa	ASTM D412, Method A	4.70
Elongation at break	%	ASTM D412, Method A	600.00
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	20.00
Compression Set	% at 70°C, 22 h	ASTM D 395, Type 2, Method B	38.00
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	50.00
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-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	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	2.25
Across Flow	%	ASTM D955	1.10

### Notes

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