Elastron

V251.D51.B

TECHNICAL DATASHEET

PRODUCT DESCRIPTION

A hard , 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

Color	Black	
Certifications	RoHS	
Processing Method	Injection	Extrusion
Available Standards	ASTM	

Automotive Specifications

GM/ GMW 15812P (TYPE 10E) FCA/ MS-AR-100 HGV

Physical Properties

Property	Unit	Standard	Value
Density	g/cm³	ASTM D 792	0.95
Durometer Hardness, 3 sec	Shore D	ASTM D 2240	51.00
Tensile Strength at Break	MPa	ASTM D412, Method A	26.00
Mod.of Elasticity %100	MPa	ASTM D412, Method A	11.00
Mod.of Elasticity %300	MPa	ASTM D412, Method A	14.50
Elongation at break	%	ASTM D412, Method A	750.00
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	48.00
Compression Set	% at 70°C, 22 h	ASTM D 395, Type 2, Method B	59.00
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	70.00
Tear Resistance	N/mm	ASTM D624	120.00

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Ageing Tests			
Property	**Unit**	**Standard**	**Value**
Ozone Resistance	Stressed	ASTM D 1149	No cracks

Bondable to		
PE-PP-EVA		
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	1.92
Across Flow	%	ASTM D955	1.58

Notes

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