

# Elastron

V601.A60.B

## TECHNICAL DATASHEET

### PRODUCT DESCRIPTION

A soft , black copper stabilised halogen free flame retardant (HFFR) thermoplastic vulcanizate, TPV (EPDM/PP) with good UV – Ozone resistance

### GENERAL PROPERTIES

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

### Physical Properties

Property	Unit	Standard	Value
Density	g/cm <sup>3</sup>	ASTM D 792	1.12
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	60.00
Tensile Strength at Break	MPa	ASTM D412, Method A	3.00
Mod.of Elasticity %100	MPa	ASTM D412, Method A	1.70
Mod.of Elasticity %300	MPa	ASTM D412, Method A	2.30
Elongation at break	%	ASTM D412, Method A	450.00
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	59.00
Flammability Rating	HB, V0, V1, V2	UL 94	V0
Tear Resistance	N/mm	ASTM D624	18.00

### Electrical Properties

Property	Unit	Standard	Value
Dielectric Strength, KV/mm	KV/mm	ASTM D149	13.30
Dielectric Constant		ASTM D150	3.01
Volume resistivity	Ω.cm	ASTM D257	3.66E+15

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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	-	Moderate
Injection Time	sec.	2- 4
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	-	1.5:1- 3.0:1
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	-	1.5:1- 3.0:1
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	1.93
Across Flow	%	ASTM D955	1.10

### Notes

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

