

Elastron

V601.A70.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		
Color	Black	
Certifications	RoHS	
Processing Method	Injection	Extrusion
Available Standards	ASTM	

Physical Properties						
Property	Unit	Standard	Value			
Density	g/cm³	ASTM D 792	1.12			
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	70.00			
Tensile Strength at Break	MPa	ASTM D412, Method A	4.50			
Mod.of Elasticity %100	MPa	ASTM D412, Method A	2.40			
Mod.of Elasticity %300	MPa	ASTM D412, Method A	3.30			
Elongation at break	%	ASTM D412, Method A	500.00			
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	21.00			
Compression Set	% at 70°C, 22 h	ASTM D 395, Type 2, Method B	43.00			
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	62.00			
Flammability Rating	HB, V0, V1, V2	UL 94	V0			
Tear Resistance	N/mm	ASTM D624	29.00			
	Electrica	Properties				
Property	Unit	Standard	Value			
Dielectric Strength, KV/mm	KV/mm	ASTM D149	13.60			
Dielectric Constant		ASTM D150	2.99			
Volume resistivity	Ω.cm	ASTM D257	3.71E+15			
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Ageing Tests						
Property	Unit	Standard	Value			
Ozone Resistance	Stressed	ASTM D 1149	No cracks			
	Bor	idable to				
	PE	-PP-EVA				
Processing						
Injection	Unit	Value				
Drying temperatures	°C	90				
Drying time	hours	2				
Rear Zone temp.	°C	155- 175	5			
Middle Zone temp.	°C	165- 18	5			
Front Zone temp.	°C	170- 190				
Nozzle Temperature	C	180- 210				
Injection Speed	-	Moderat	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- 21	5			
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.							
Flow	%	ASTM D955	0.95				
Across Flow	%	ASTM D955	1.41				

Notes

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



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