

Elastron

V860.A65.N(Preliminary Data)

TECHNICAL DATASHEET

PRODUCT DESCRIPTION

A soft , colorable thermoplastic vulcanizate, TPV in the thermoplastic elastomer (TPE) family which offers higher temperature resistance and very good compression set with very good UV resistance.

GENERAL PROPERTIES

Color	Natural
Certifications	RoHS
Processing Method	Injection
Available Standards	ASTM

Physical Properties			
Property	Unit	Standard	Value
Density	g/cm ³	ASTM D 792	1.00
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	65.00
Tensile Strength at Break	MPa	ASTM D412, Method A	6.50
Mod.of Elasticity %100	MPa	ASTM D412, Method A	1.90
Mod.of Elasticity %300	MPa	ASTM D412, Method A	2.90
Elongation at break	%	ASTM D412, Method A	550.00
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	47.00
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	57.00
Tear Resistance	N/mm	ASTM D624	22.00

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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	-
Drying time	hours	No need
Rear Zone temp.	°C	145- 175
Middle Zone temp.	°C	155- 185
Front Zone temp.	°C	160- 190
Nozzle Temperature	°C	175- 205
Injection Speed	-	Low/ Mod
Injection Time	sec.	3- 5
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- 2.0:1
Screw L/D ratio	-	18- 24
Residence time	-	1-2 shot
Cushion size	mm	8
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	1.83
Across Flow	%	ASTM D955	1.00

Notes

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