

PRODUCT DESCRIPTION

A soft , black SEBS based thermoplastic elastomer (TPE) compound specially designed for excellent adhesion to ABS/PC/PMMA/SAN/ASA/PET and PET-G.

GENERAL PROPERTIES

Material Status	Active
Availability	Europe North America Asia- Pasific Africa & Middle East
Features	Designed for Excellent Adhesion to ABS, PC, PMMA, SAN, ASA, PET AND PET-G Insert Molding or 2K Molding Possible Designed for Soft Touch Applications Ozone Resistance Compliant with RoHS Directive
Certification	RoHS
Appearance	Black
Form	Pellets
Processing Method	Injection

Physical Properties

Property	Typical Value (English)	Typical Value (SI)	Test Method
Density	1.10 g/cm ³	1,10 g/cm ³	ASTM D 792
Durometer Hardness, 3 sec (Shore A)	40.00	40,00	ASTM D 2240
Tensile Strength at Break	580 Psi	4,00 MPa	ASTM D412, Method A
Mod.of Elasticity %100	174 Psi	1,20 MPa	ASTM D412, Method A
Mod.of Elasticity %300	305 Psi	2,10 MPa	ASTM D412, Method A
Elongation at break	550.00 %	550,00 %	ASTM D412, Method A
Compression Set (at 73 °F, 22 h)	18.00 %	18,00 %	ASTM D 395, Type 2, Method B
Compression Set (at 158 °F, 22 h)	70.00 %	70,00 %	ASTM D 395, Type 2, Method B
Compression Set (at 212 °F, 22 h)	85.00 %	85,00 %	ASTM D 395, Type 2, Method B
Tear Resistance	85.65 lbf/in	15,00 N/mm	ASTM D624

Shrinkage

Property	Typical Value (English)	Typical Value (SI)	Test Method
Flow	1.96%	1.96%	ASTM D955
Across Flow	1.31%	1.31%	ASTM D955

Ageing Tests

Additional Information	Typical Value (English)	Typical Value (SI)	Test Method
Ozone Resistance-Stressed	No cracks	No cracks	ASTM D 1149

Bondable to

PMMA-ABS/PC-ASA-SAN-PET-PET-G

Additional Information

Elastron products are not compatible with PVC and Acetal.
Regrinding level up to %20 is recommended with minimum property loss.

Processing

Injection Molding	Typical Value (English)		Typical Value (SI)	
Drying temperatures	194	°F	90	°C
Drying time	2	hours	2	hours
Rear Zone temp.	356-392	°F	180- 200	°C
Middle Zone temp.	374-410	°F	190- 210	°C
Front Zone temp.	401-428	°F	205- 220	°C
Nozzle Temperature	428-446	°F	220- 230	°C
Injection Speed	Mod/ High	-	Mod/ High	-
Injection Time	1- 4	sec.	1- 4	sec.
Injection Pressure	10- 40	bar	10- 40	bar
Hold Pressure	5- 20	bar	5- 20	bar
Back Pressure	5- 40	bar	5- 40	bar
Screw Speed	50- 200	rpm	50- 200	rpm
Mold Temperature	77-122	°F	25- 50	°C
Screw Comp. ratio	2.0:1- 4.0:1	-	2.0:1- 4.0:1	-
Screw L/D ratio	18- 24	-	18- 24	-
Residence time	1-2 shot	-	1-2 shot	-
Cushion size	0.3120	inc	8	mm
Suggested Max Regrind	20	%	20	%

Notes

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