

PRODUCT DESCRIPTION

A soft , colorable SEBS based thermoplastic elastomer (TPE) compound specially designed for excellent adhesion to PS.

GENERAL PROPERTIES

Material Status	Active
Availability	Europe North America Asia- Pasific Africa & Middle East
Features	Designed for Excellent Adhesion to PS Insert Molding or 2K Molding Possible Designed for Soft Touch Applications Ozone Resistance Compliant with RoHS Directive 2011/65/EU
Certification	RoHS
Appearance	Natural
Form	Pellets
Processing Method	Injection

Physical Properties

Property	Typical Value (English)	Typical Value (SI)	Test Method
Density	1.18 g/cm ³	1,18 g/cm ³	ASTM D 792
Durometer Hardness, 3 sec (Shore A)	45.00	45,00	ASTM D 2240
Tensile Strength at Break	290 Psi	2,00 MPa	ASTM D412, Method A
Mod.of Elasticity %100	116 Psi	0,80 MPa	ASTM D412, Method A
Mod.of Elasticity %300	203 Psi	1,40 MPa	ASTM D412, Method A
Elongation at break	500.00 %	500,00 %	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)	80.00 %	80,00 %	ASTM D 395, Type 2, Method B
Tear Resistance	119.91 lbf/in	21,00 N/mm	ASTM D624

Shrinkage

Property	Typical Value (English)	Typical Value (SI)	Test Method
Flow	1.58%	1.58%	ASTM D955
Across Flow	1.23%	1.23%	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

PS

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	hours	2 hours	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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