

**PRODUCT DESCRIPTION**

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

**GENERAL PROPERTIES**

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

**Physical Properties**

| Property                                   | Typical Value (English) | Typical Value (SI)     | Test Method                  |
|--|-------------------------|------------------------|------------------------------|
| <b>Density</b>                             | 1.10 g/cm <sup>3</sup>  | 1,10 g/cm <sup>3</sup> | ASTM D 792                   |
| <b>Durometer Hardness, 3 sec (Shore A)</b> | 60.00                   | 60,00                  | ASTM D 2240                  |
| <b>Tensile Strength at Break</b>           | 1131 Psi                | 7,80 MPa               | ASTM D412, Method A          |
| <b>Mod.of Elasticity %100</b>              | 276 Psi                 | 1,90 MPa               | ASTM D412, Method A          |
| <b>Mod.of Elasticity %300</b>              | 566 Psi                 | 3,90 MPa               | ASTM D412, Method A          |
| <b>Elongation at break</b>                 | 600.00 %                | 600,00 %               | ASTM D412, Method A          |
| <b>Compression Set (at 73 °F, 22 h)</b>    | 15.00 %                 | 15,00 %                | ASTM D 395, Type 2, Method B |
| <b>Compression Set (at 158 °F, 22 h)</b>   | 62.00 %                 | 62,00 %                | ASTM D 395, Type 2, Method B |
| <b>Compression Set (at 212 °F, 22 h)</b>   | 84.00 %                 | 84,00 %                | ASTM D 395, Type 2, Method B |
| <b>Tear Resistance</b>                     | 199.85 lbf/in           | 35,00 N/mm             | ASTM D624                    |

**Shrinkage**

| Property           | Typical Value (English) | Typical Value (SI) | Test Method |
|--------------------|-------------------------|--------------------|-------------|
| <b>Flow</b>        | 1.33%                   | 1.33%              | ASTM D955   |
| <b>Across Flow</b> | 0.80%                   | 0.80%              | 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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**ISO 9001: 2015 & IATF16949: 2016 & ISO 14001: 2015 REGISTERED QUALITY SYSTEMS**

