

Elastron

F.G400.A70.N

TECHNICAL DATASHEET

PRODUCT DESCRIPTION

A soft , colorable SEBS based thermoplastic elastomer (TPE) compound designed for contact with non-fatty foods. The monomers and additives used to produce this product are listed in the Union List of Authorized Substances of Regulation 10/2011/EC and meets the FDA requirements contained in the Code of Federal Regulations, 21 CFR.

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 | 0.89 |
| Durometer Hardness, 3 sec | Shore A | ASTM D 2240 | 70.00 |
| Tensile Strength at Break | MPa | ASTM D412, Method A | 10.00 |
| Mod.of Elasticity %100 | MPa | ASTM D412, Method A | 2.00 |
| Mod.of Elasticity %300 | MPa | ASTM D412, Method A | 3.30 |
| Elongation at break | % | ASTM D412, Method A | 900.00 |
| Compression Set | % at 23°C, 22 h | ASTM D 395, Type 2, Method B | 26.00 |
| Compression Set | % at 70°C, 22 h | ASTM D 395, Type 2, Method B | 49.00 |
| Compression Set | % at 100°C, 22 h | ASTM D 395, Type 2, Method B | 71.00 |
| Tear Resistance | N/mm | ASTM D624 | 39.00 |

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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 | 2.16 |
| Across Flow | % | ASTM D955 | 1.46 |

Notes

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

