

Elastron

G101.D46.B

TECHNICAL DATASHEET

PRODUCT DESCRIPTION

A hard , black SEBS based thermoplastic elastomer (TPE) compound that offers good physical properties and chemical resistance.

GENERAL PROPERTIES

| | |
|----------------------------|--|
| Color | Black |
| Certifications | RoHS |
| Processing Method | Injection Extrusion |
| Available Standards | ASTM |

Physical Properties

| Property | Unit | Standard | Value |
|---------------------------|-------------------|------------------------------|--------|
| Density | g/cm ³ | ASTM D 792 | 1.20 |
| Durometer Hardness, 3 sec | Shore D | ASTM D 2240 | 46.00 |
| Tensile Strength at Break | MPa | ASTM D412, Method A | 14.00 |
| Mod.of Elasticity %100 | MPa | ASTM D412, Method A | 9.50 |
| Mod.of Elasticity %300 | MPa | ASTM D412, Method A | 12.00 |
| Elongation at break | % | ASTM D412, Method A | 550.00 |
| Compression Set | % at 23°C, 22 h | ASTM D 395, Type 2, Method B | 52.00 |
| Compression Set | % at 70°C, 22 h | ASTM D 395, Type 2, Method B | 73.00 |
| Compression Set | % at 100°C, 22 h | ASTM D 395, Type 2, Method B | 85.00 |
| Tear Resistance | N/mm | ASTM D624 | 84.00 |

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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 |

| Extrusion | Unit | Value |
|-----------------------|-------|--------------|
| Drying temperatures | °C | - |
| Drying time | hours | No need |
| Screw Comp. Ratio | - | 1.5:1- 2.0:1 |
| Screw L/D | - | 18- 30 |
| Feed Zone temp. | °C | 150- 170 |
| Rear Zone temp. | °C | 155- 175 |
| Center Zone temp. | °C | 165- 185 |
| Front Zone temp. | °C | 175- 205 |
| Head temp. | °C | 180- 210 |
| Die temp. | °C | 190- 210 |
| 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 | 1.41 |
| Across Flow | % | ASTM D955 | 1.23 |

Notes

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

