

# Elastron

G500.A70.N.PA

## TECHNICAL DATASHEET

### PRODUCT DESCRIPTION

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

### GENERAL PROPERTIES

<b>Color</b>	Natural
<b>Certifications</b>	RoHS
<b>Processing Method</b>	Injection
<b>Available Standards</b>	ASTM

### Physical Properties

Property	Unit	Standard	Value
Density	g/cm <sup>3</sup>	ASTM D 792	1.12
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	70.00
Tensile Strength at Break	MPa	ASTM D412, Method A	4.50
Mod.of Elasticity %100	MPa	ASTM D412, Method A	2.40
Mod.of Elasticity %300	MPa	ASTM D412, Method A	3.60
Elongation at break	%	ASTM D412, Method A	500.00
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	18.00
Compression Set	% at 70°C, 22 h	ASTM D 395, Type 2, Method B	46.00
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	76.00
Flammability Rating	HB, V0, V1, V2	UL 94	HB
Tear Resistance	N/mm	ASTM D624	30.00

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## Ageing Tests

Property	Unit	Standard	Value
Ozone Resistance	Stressed	ASTM D 1149	No cracks

## Bondable to

PA

## Processing

Injection	Unit	Value
Drying temperatures	°C	90
Drying time	hours	2
Rear Zone temp.	°C	180- 200
Middle Zone temp.	°C	190- 210
Front Zone temp.	°C	205- 220
Nozzle Temperature	°C	220- 230
Injection Speed	-	Mod/ High
Injection Time	sec.	1- 4
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	-	2.0:1- 4.0:1
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	1.50
Across Flow	%	ASTM D955	1.15

### Notes

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