

Elastron

G500.A80.B.PA

TECHNICAL DATASHEET

PRODUCT DESCRIPTION

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

GENERAL PROPERTIES

Color	Black
Certifications	RoHS
Processing Method	Injection
Available Standards	ASTM

Physical Properties

Property	Unit	Standard	Value
Density	g/cm ³	ASTM D 792	1.12
Durometer Hardness, 3 sec	Shore A	ASTM D 2240	80.00
Tensile Strength at Break	MPa	ASTM D412, Method A	5.00
Mod.of Elasticity %100	MPa	ASTM D412, Method A	2.90
Mod.of Elasticity %300	MPa	ASTM D412, Method A	4.90
Elongation at break	%	ASTM D412, Method A	500.00
Compression Set	% at 23°C, 22 h	ASTM D 395, Type 2, Method B	22.00
Compression Set	% at 70°C, 22 h	ASTM D 395, Type 2, Method B	51.00
Compression Set	% at 100°C, 22 h	ASTM D 395, Type 2, Method B	78.00
Flammability Rating	HB, V0, V1, V2	UL 94	HB
Tear Resistance	N/mm	ASTM D624	36.00

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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	1.10
Across Flow	%	ASTM D955	1.03

Notes

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