

Elastron® V V251.A65.B

Thermoplastic Vulcanizate

Elastron USA, Inc.

Message:

A soft, black TPV (EPDM /PP) material belongs to thermoplastic elastomer (TPE) family with superior UV resistance and excellent compression set. This product is specially designed for weatherseal applications.

Bondable to: PP, EVA, PE

General Information			
Features	Bondability		
	Good UV Resistance		
	Soft		
Uses	Seals		
RoHS Compliance	RoHS Compliant		
Appearance	Black		
Forms	Pellets		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.960	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow	3.2	%	
Across Flow	1.3	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	68		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% Strain	2.20	MPa	
300% Strain	3.60	MPa	
Tensile Strength (Break)	6.50	MPa	ASTM D412
Tensile Elongation (Break)	550	%	ASTM D412
Tear Strength	31.0	kN/m	ASTM D624
Compression Set			ASTM D395
23°C, 22 hr	17	%	
70°C, 22 hr	31	%	
100°C, 22 hr	40	%	
Additional Information	Nominal Value		Test Method
Ozone Resistance - Stressed	No Cracks		ASTM D518
Injection	Nominal Value	Unit	

Drying Temperature	90.0	°C
Drying Time	2.0	hr
Suggested Max Regrind	20	%
Rear Temperature	155 to 175	°C
Middle Temperature	165 to 185	°C
Front Temperature	170 to 190	°C
Nozzle Temperature	180 to 210	°C
Mold Temperature	25.0 to 50.0	°C

Extrusion	Nominal Value	Unit
Drying Temperature	90.0	°C
Drying Time	2.0	hr
Cylinder Zone 1 Temp.	155 to 165	°C
Cylinder Zone 2 Temp.	160 to 180	°C
Cylinder Zone 3 Temp.	165 to 185	°C
Cylinder Zone 4 Temp.	170 to 190	°C
Cylinder Zone 5 Temp.	180 to 210	°C
Die Temperature	185 to 215	°C

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