

tivilon® M 70 Dx 1

Thermoplastic Vulcanizate

API SpA

Message:

tivilon®M 70 Dx 1 is a thermoplastic vulcanized rubber (TPV) product. It can be processed by extrusion or injection molding and is available in Europe.
tivilon®The application areas of M 70 Dx 1 include engineering/industrial accessories and sealing applications.

Features include:
environmental protection/green
Good processability

General Information	
Features	Recyclable materials
	Workability, good
Uses	Washer
	Seals
	Profile
Appearance	Natural color
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.970	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/5.0 kg)	6.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 15 sec)	70		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
--	8.00	MPa	ASTM D638
100% strain	2.00	MPa	ASTM D638
300% strain	3.20	MPa	ASTM D638
Tensile Elongation (Break)	700	%	ASTM D638
Elastomers	Nominal Value	Unit	Test Method
Tear Strength ¹	35000	kN/m	ASTM D624
Compression Set (70°C, 24 hr)	44	%	ASTM D395

Additional Information		
Dx = UV Resistance Level DE = standard UV resistance level DI = medium UV resistance level DR = high UV resistance level		
Injection	Nominal Value	Unit

Drying Temperature	75 - 80	°C
Drying Time	1.5 - 2.0	hr
Rear Temperature	170 - 180	°C
Middle Temperature	180 - 190	°C
Front Temperature	185 - 200	°C
Nozzle Temperature	190 - 210	°C
Mold Temperature	35 - 50	°C
Injection Rate	Moderate-Fast	
Extrusion	Nominal Value	Unit
Drying Temperature	75 - 80	°C
Drying Time	1.5 - 2.0	hr
Cylinder Zone 1 Temp.	160 - 170	°C
Cylinder Zone 2 Temp.	170 - 180	°C
Cylinder Zone 3 Temp.	175 - 185	°C
Cylinder Zone 4 Temp.	180 - 190	°C
Die Temperature	190 - 200	°C
Extrusion instructions		
L/D Ratio: >20:1 Compression Ratio: 1:2.5		
NOTE		
1.	With Notch	

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