

Evoprene™ CE 6185

Thermoplastic Elastomer

AlphaGary

Message:

The Evoprene™ CE range has been specially created to offer processors a cost engineered range of easy processing, fast cycling TPE compounds for general purpose applications. Formulated primarily for injection moulding this range is compatible for coinjection with polypropylene. The soft to mid hardness range compounds offer high levels of flexibility with good recovery properties at room temperature and excellent low temperature flexibility to -600C. The compounds are normally supplied as natural or black. Natural compound can be readily coloured with a universal masterbatch. As with all Evoprene™ TPE compounds the Evoprene™ CE range is fully recyclable at all stages through the processing chain.

| General Information | | | |
|-------------------------------|-----------------------------|-------|-------------|
| Features | Fast Molding Cycle | | |
| | General Purpose | | |
| | Good Adhesion | | |
| | Good Electrical Properties | | |
| | Good Flexibility | | |
| | Good Processability | | |
| | High Friction | | |
| | Low Temperature Flexibility | | |
| | Ozone Resistant | | |
| | Recyclable Material | | |
| Uses | General Purpose | | |
| RoHS Compliance | Contact Manufacturer | | |
| Appearance | Black | | |
| | Natural Color | | |
| Forms | Pellets | | |
| Processing Method | Injection Molding | | |
| Physical | Nominal Value | Unit | Test Method |
| Density | 1.10 | g/cm³ | ISO 2781 |
| Molding Shrinkage | 0.50 to 1.2 | % | |
| Hardness | Nominal Value | Unit | Test Method |
| Shore Hardness (Shore A) | 50 | | ISO 868 |
| Elastomers | Nominal Value | Unit | Test Method |
| Tensile Stress (100% Strain) | 1.60 | MPa | ISO 37 |
| Tensile Stress (Yield) | 5.00 | MPa | ISO 37 |
| Tensile Elongation (Break) | 630 | % | ISO 37 |
| Tear Strength ¹ | 26 | kN/m | ISO 34-1 |
| Compression Set (23°C, 72 hr) | 26 | % | ISO 815 |
| Additional Information | Nominal Value | Unit | Test Method |

| | | | |
|------------------------|----------------|------|-----------------|
| M-S Flow | 1.08 | MPa | Internal Method |
| Injection | Nominal Value | Unit | |
| Suggested Max Regrind | 20 | % | |
| Rear Temperature | 160 to 180 | °C | |
| Middle Temperature | 160 to 180 | °C | |
| Front Temperature | 160 to 180 | °C | |
| Nozzle Temperature | 150 to 170 | °C | |
| Processing (Melt) Temp | 220 | °C | |
| Mold Temperature | 15.0 to 30.0 | °C | |
| Injection Rate | Fast | | |
| Vent Depth | 0.020 to 0.050 | mm | |

| NOTE | | | |
|------|-----------------------------|--|--|
| 1. | Method Ba, Angle (Unnicked) | | |

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