

Aaroprene® ATPR 1000 60A

Thermoplastic Elastomer

Aaron Industries Corp.

Message:

Aaroprene® ATPR 1000 60A is a thermoplastic elastomer (TPE) material. This product is available in North America and is processed by film extrusion, extrusion or injection molding.

| General Information | |
|---------------------|--|
| Appearance | Available colors |
| Forms | Particle |
| Processing Method | Film extrusion Extrusion Injection molding |

| Physical | Nominal Value | Unit | Test Method |
|------------------|---------------|-------------------|-------------|
| Specific Gravity | 0.998 - 1.10 | g/cm ³ | ASTM D792 |

| | | | |
|---|----|----------|------------|
| Melt Mass-Flow Rate (MFR) (190°C/2.16 kg) | 80 | g/10 min | ASTM D1238 |
|---|----|----------|------------|

| Hardness | Nominal Value | Unit | Test Method |
|------------------------------|---------------|------|-------------|
| Durometer Hardness (Shore A) | 60 | | ASTM D2240 |

| Mechanical | Nominal Value | Unit | Test Method |
|---|---------------|------|-------------|
| Tensile Modulus | 2.07 | MPa | ASTM D412 |
| Taber Abrasion Resistance (1000 Cycles, H-18 Wheel) | 355 | mg | ASTM D1044 |

| Elastomers | Nominal Value | Unit | Test Method |
|----------------------------|---------------|------|-------------|
| Tensile Strength (Yield) | 6.07 | MPa | ASTM D412 |
| Tensile Elongation (Break) | 630 | % | ASTM D412 |
| Tear Strength ¹ | 31.5 | kN/m | ASTM D624 |

| Injection | Nominal Value | Unit |
|--------------------|---------------|------|
| Rear Temperature | 79.4 | °C |
| Middle Temperature | 177 | °C |
| Front Temperature | 193 | °C |
| Nozzle Temperature | 199 | °C |
| Injection Pressure | 3.45 - 4.83 | MPa |
| Injection Rate | Moderate | |
| Back Pressure | 0.345 | MPa |
| Screw Speed | 30 | rpm |

Injection instructions

Injection Time: 3 sec Hold Time: 5 sec Clamp Time: 10 sec Cycle Time: 20 sec

| Extrusion | Nominal Value | Unit |
|-----------------------|---------------|------|
| Cylinder Zone 1 Temp. | 79.4 | °C |

| | | |
|-----------------------|-----------|----|
| Cylinder Zone 2 Temp. | 149 | °C |
| Cylinder Zone 3 Temp. | 149 | °C |
| Cylinder Zone 4 Temp. | 149 | °C |
| Cylinder Zone 5 Temp. | 149 | °C |
| Melt Temperature | 149 - 193 | °C |
| Die Temperature | 193 | °C |

Extrusion instructions

L/D Ratio: 24:1 Low Compression Ratios Deep Flighted Metering Sections Film Extrusion Melt Temperature: 325 to 375°F

NOTE


1. C mould

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