

ENFLEX V1060A BLK UV

Thermoplastic Vulcanizate

ENPLAST Americas, a Ravago Group Company

Message:

Enflex V1060A BLK UV TPV (thermoplastic vulcanizate) is a fully weatherable black EPDM/PP compound. It is designed to replace thermoset elastomers such as EPDM or polychloroprene, and traditional thermoplastic TPVs. Enflex V grades provide the performance of vulcanized rubber with the advantage of low-cost thermoplastic processing.

General Information	
Features	Low compressive deformability Solvent resistance Good UV resistance Recyclable materials Workability, good Ozone resistance alkali resistance Alcohol resistance Good weather resistance Heat resistance, high acid resistance Detergent resistance Oil resistance

Appearance	Black
Processing Method	Extrusion Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.970	g/cm ³	ASTM D792
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 5 seconds, extruded	57		ASTM D2240
Shore A, 5 seconds, injection molding	60		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	2.59	MPa	ASTM D412
Tensile Strength (Break)	6.70	MPa	ASTM D412
Tensile Elongation (Break)	500	%	ASTM D412
Tear Strength ¹	26.0	kN/m	ASTM D624
Compression Set			ASTM D395
70°C, 22 hr	32	%	ASTM D395
125°C, 70 hr	45	%	ASTM D395

Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-60.0	°C	ASTM D746
Melting Temperature	158	°C	ASTM D1238
Dynamic Service Temperature	130	°C	

Injection	Nominal Value	Unit
Drying Temperature	82.2	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.080	%
Rear Temperature	177 - 188	°C
Middle Temperature	182 - 193	°C
Front Temperature	188 - 199	°C
Nozzle Temperature	199 - 221	°C
Processing (Melt) Temp	199 - 232	°C
Mold Temperature	10.0 - 48.9	°C
Injection Pressure	5.17 - 8.96	MPa
Injection Rate	Fast	
Screw Speed	50 - 200	rpm
Clamp Tonnage	4.1 - 6.9	kN/cm ²
Cushion	5.08 - 12.7	mm

Injection instructions

Holding Time: 5 to 7 Sec.Cooling Time: 30 to 50 Sec.

Extrusion	Nominal Value	Unit
Hopper Temperature	160 - 177	°C
Cylinder Zone 1 Temp.	171 - 191	°C
Cylinder Zone 2 Temp.	171 - 191	°C
Cylinder Zone 3 Temp.	171 - 191	°C
Cylinder Zone 4 Temp.	171 - 191	°C
Cylinder Zone 5 Temp.	171 - 191	°C
Adapter Temperature	191 - 210	°C
Melt Temperature	191 - 199	°C
Die Temperature	191 - 210	°C

Extrusion instructions

Screw: L/D 20:1 or greater (L/D 24:1 preferred)Compression Zone: 355 - 390°F (180 - 200°C)Metering Zone: 375 to 410°F (190 to 210°C)Cooling Water: 60 - 85°F (15 - 30°C)Screw Speed: 100 - 200 rpmScreen Pack: 20/40/60

NOTE

1. C mould

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

